

AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED

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AFTER REPAIR INSPECTION CERTIFICATE OF X-OVER#33444

Client Name:	HILONG OIL SERVICE&ENGINEERING CO,Ltd IRAQ BRANCH.	Report No.:	HL-22-QC-24-11-RS-002
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 $\mu\text{w}/\text{cm}^2$
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 ϖ (In)	BBL λ (In)	Bevel ϕ (In)	OD(In)	CB ϕ (In)	CB δ (In)	BB ϖ (In)	BB λ (In)	Bevel ϕ (In)	Box Tong λ (in)	Overall λ (In)	Box Tong (In)
33444	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 1/2"	-

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	ϖ	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 III		Senior Inspector:	M.SARWAR	Supervisor:	AHMED MOHAMMED	Customer Name:	
Signature:							Customer Signature:	
Original - Client Files			Copy - Area Office			QC/FN/AF,REP/026 Rev.00 Dated 01 AUG 2021		

