

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 / hany.akafi@qualitycontrol-iraq.com



AFTER REPAIR INSPECTION CERTIFICATE OF 8" DRILL COLLAR

Client Name:	HILONG OIL SERVICE&ENGINEERING CO,Ltd IRAQ BRANCH.	Report No.:	QC-2024-12-HL-22-002
Acceptance Criteria:	<input checked="" type="checkbox"/> API SPEC 7-2	Date Of Inspection:	10.DEC.2024
Work Location:	ABERDEEN WORKSHOP	Rig Name	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	3500 Lux
Magnetic particle concentration flourcent 14 HF	0.1 TO 0.4 ML/100 ML	UV LIGHT INTENSITY:	2850 $\mu\text{w}/\text{cm}^2$
Magnetism Direction (Longitudinal)			
METHODOLOGY:	<ul style="list-style-type: none"> • Through Visual inspection • MPI inspection with Ultraviolet light • Dimensional 3 *Lead Gaiging, & Thread Profile Gaiging. 		
Connection:	6 5/8" Reg	Size:	8 "

Serial No.	Visual Inspection			MPI			Dimensional 3 Inspection																					
	Pin	Box	Body	Pin	Box	Body	Pin					Box					Body											
							OD (in)	ID (in)	SRG \square (in)	SRG \square (in)	Pin \square (in)	Bevel \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)	EGR \square (in)	SGR \square (in)	Overall \square (in)					
14S624	Acc	-	-	Acc	-	-	8"	2 7/8"	5 3/8"	3/4"	4 15/16"	7 1/2"	-	-	-	-	-	-	-	-	-	-	-	12 1/2"	-	-	-	-
110	Acc	-	-	Acc	-	-	7 30/32"	3"	5 3/8"	1"	4 15/16"	7 3/8"	-	-	-	-	-	-	-	-	-	-	-	18 1/2"	-	-	-	-
15S624	Acc	-	-	Acc	-	-	8"	2 7/8"	5 3/8"	7/8"	4 15/16"	7 1/2"	-	-	-	-	-	-	-	-	-	-	12 1/8"	-	-	-	-	
7S624	Acc	-	-	Acc	-	-	8"	2 7/8"	5 3/8"	15/16"	4 15/16"	7 1/2"	-	-	-	-	-	-	-	-	-	-	17 1/4"	-	-	-	-	

Conclusion: (04) The above Mentioned 8" Drill Collar were found "Acceptable" from Pin Connection 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
\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	Blue	Damage	Green	Seal Damage	Yellow	ACFM

Inspector Name:	RAO SOHAN	Review By				
Qualification:	ASNT Level II	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 07 NOV 2021				

