

BP CHIRAG PROJECT

0	19.02.2013	As Built	ANTH	EROL		
Rev.	Issued date	Description	Made by	Chk'd by	Disc. Appr.	Proj. Appr.



Nyland as

PO Nr.:	Package Title:		Supplier Doc. Nr.:
4500111369	Up-/Down-facing Connector Assembly		MRB-4500111369-00080, rev 0
1 - Accepted	Date	Sign	
2 - Accepted w comments incorporated			
3 - Not accepted – revise and resubmit			
4 - For information only			
Document type:	Area:	System:	
PDF			
Document title:			
Manufacturing Record Book for Item 00080			
Document No.:	Rev.:	Page:	

Manufacturing Record Book for N112100-E155A Upfacing Jig

GE Oil & Gas
PO No.: 4500111369
NLI Order No.: 46126

Section	Description	Section Required	No of pages in each section	Remarks
1	Inspection & Test Plan	X	3	
2	QMS Certificate	X	4	
3	Quality Plan	N/A		
4	Material traceability List	X		See section 20, GRV
5	Material Certificates / PMI Reports	X	1	
6	Weld and NDE Log	X		See section 20, GRV
7	WPS / WPQ / PWHT	X		See section 20, GRV
8	Welders Certificates	X		See section 20, GRV
9	Visual Inspection Reports	X		See section 20, GRV
10	NDE Reports	X		See section 20, GRV
11	NDE Operators Certificates	X		See section 20, GRV
12	Surface Treatment Inspection Reports	X		See section 20, GRV
13	Dimensional Inspection Report	X	1	
14	Weighing Certificate	X	1	
15	Lifting Certificate	N/A		
16	Pressure Test Traceability Certificate	N/A		
17	Pressure Test Procedure / FAT Procedure	X		See section 20, GRV
18	Pressure Test Certificate / FAT Report	X		See section 20, GRV
19	Documentation from Sub-Suppliers	NA		
20	Non- Conformance / Concession Records	X	2	
21	Certificate of Conformance	X	1	
22	As-Built Drawings / Mark-Ups	X		See section 20, GRV
23	Photo's of: Equipment / Testing / Marking / Nameplate	N/A		
24	Mechanical Completion Dossier	X	6	
25	Heat Treatment Record	N/A		
26	Electrical Certification and Record	N/A		
27	Instrumentation	N/A		
28	Miscellaneous Certification Reports and Calibration Records	N/A		
29	Software Test Results	N/A		

1. Inspection & Test Plan

APPROVED CODE 1, 18.02.2013 GE Tom Aarøv

Inspection and Test Plan						Doc. No.: ITP-46126			
Project Name:		BP CHIRAG				Rev.	Date	Made by	Checked by
Product Name:		Up-facing / Down-facing Connector Assembly				0	17.04.12	VILA	
NLI Nyland Job Nr.: 46126						1	07.05.12	MAPO	
						2	15.10.12	HAOY	MAHV
						3	31.10.12	HAOY	MAHV
						4	18.02.13	HAOY	MAHV
Customer: GE Oil & Gas		Purchase Order: PO4500111369				H = Hold, W = Witness, R = Review, M = Monitoring H =10 working days, W = 5 working days			
Item	Activity	Responsible	Procedure	Accept. Criteria	Report/cert. type	NLI Nyland	GE	BP	Comments:
1	Contract Review	Sales- / Proj. Manager	NLI-B.300	NA	Report, Checklist, Signature	R			
2	Kick-off Meeting	Project Manager	NA	NA	MOM	H			
3	Pre Production Meeting	Project Manager	NA	NA	SDL, ITP, MOM	H	H	H	
4	Material control		NLI B-800	Bom/draw	Traceability List	R	R	R	A. Material Cert. Requirement: 3.1 + W. B. Non G8 EU countries to be approved by NLI/GE. C. Origin producer of bolts to be approved by NLI/GE.3.1 B + W
5	WQ- Welders Qualification		NA	NS-EN-287	Welders Certificate	R	R	R	
Structure									
6	Machining of relevant components		NA	Acc. To DRW / BOM	Dimensional Report	R	R	M-R	
7	Fabrication after Machining		NA	Acc. To DRW / BOM	NA	M	R	M-R	
8	WPS - Welding Procedure Specification / WPQR		NLI N.DF420 rev. 3	WPQR 25-10 rev. 0 / VGS 3.5.13 / draw	WPS / WPQR	H	H	H	Approval of documents
9	Start-up pre-fabrication / welding		Weld & NDE Matrix / Map.	Approved WPQR	Welding Log	R	R	M-R	
10	Welding		NLI N.DF420	WPQR 25-10	Welding Log	R	R	M-R	
11	NDE MT		QAP-MT-01.46126 / N041052-NW1 rev. B	QAP-MT-01.46126 / N041052-NW1 rev. B	Welding Log	R	R	M-R	
11	NDE VT		D-9.7.03.VT / NORSO M-101	D-9.7.03.VT / NORSO M-101	Welding Log	R	R	M-R	
12	Dimensional Check Before Surface Treatment		NA	Acc. To DRW/BOM	Dimensional Report	R	R	R	
13	Surface Treatment		B-1020-74 E / VGS .6.1.38.1 rev.0	B-1020-74 E / VGS .6.1.38.1 rev.0	Surface Treatment Report	R	R	M-R	
Piping									
17	Machining of relevant components		NA	Acc. To DRW/BOM	Dimensional Report	R	R	M-R	
18	Fabrication after Machining		NA	Acc. To DRW/BOM	NA	M	R	M-R	
19	WPS - Welding Procedure Specification / WPQR		pWPS NLI N.01 CW-12 / pWPS 13-12 / pWPS 14-12 / pWPS 13-12 repair / pWPS 14-12 repair	Acc. to N041052-E282NW1 / N041052-W282P1 / drawing.	WPS / WPQR	H	H	H	Approval of documents
20	NDE MT		QAP-MT-01.46126 / N041052-NW1 rev. B	QAP-MT-01.46126 / N041052-NW1 rev. B	Welding Log	R	R	M-R	



Inspection and Test Plan

Doc. No.: ITP-46126

Rev.	Date	Made by	Checked by
0	17.04.12	VILA	
1	07.05.12	MAPO	
2	15.10.12	HAOY	MAHV
3	31.10.12	HAOY	MAHV
4	18.02.13	HAOY	MAHV

Customer: GE Oil & Gas

Purchase Order:

PO4500111369

H = Hold, W = Witness, R = Review, M = Monitoring H = 10 working days, W = 5 working days

Item	Activity	Responsible	Procedure	Accept. Criteria	Report/cert. type	NLI Nyland	GE	Witness	Comments:
21	Start-up pre-fabrication / welding		Weld & NDE Matrix / Map.	Approved WPS	Welding Log	R	R	M-R	
22	Welding (Cladding)		NLI N.01 CW-12 rev. 5	WPQR NLI N.01 CW-12 rev. 4	Weld Summary list	R	R	R	
23	NDE VT		QAP-VT-01.46126 / ISO 17637 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	QAP-VT-01.46126 / ISO 17637 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	Welding Log	R	R	M-R	
24	NDE of Weld Overlay Thickness		QAP-TOC-01	Acc. To WPS / DRW	Welding Log	R	R	M-R	
25	NDE UT		QAP-UT-03.46126 / N041052-E282NW1 REV.3	QAP-UT-03.46126 / N041052-E282NW1 REV.3	Welding Log	R	R	M-R	
26	NDE PT		QAP-PT-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	QAP-PT-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	Welding Log	R	R	M-R	
27	NDE PMI		QAP-PMI-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B / VGS 8.10.01	QAP-PMI-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B / VGS 8.10.01	Welding Log	R	R	M-R	
28	Welding (Pup-Hub)		WPS E-BP512 (rev. Acc. To SDL)	WPQR 13-12 rev. 1	Weld Summary list	R	R	R	
29	Welding (Pup-Hub)		WPS E-BP513 (rev. Acc. To SDL)	WPQR 14-12 rev. 0	Weld Summary list	R	R	R	
29	Welding Repair (Pup-Hub)		WPS E-BP514 (rev. Acc. To SDL)	WPQR 13-12 rev. 1 / WPQR 14-12 rev. 0	Weld Summary list	R	R	R	
30	NDE VT		QAP-VT-01.46126 / ISO 17637 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	QAP-VT-01.46126 / ISO 17637 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	Welding Log	R	R	M-R	
31	NDE UT		QAP-UT-08.46126 / N041052-E282P1 rev.B	QAP-UT-08.46126 / N041052-E282P1 rev.B	Welding Log	R	R	M-R	
32	NDE RT		QAP-RT-01.46126 / N041052-E282P1 rev.B	QAP-RT-01.46126 / N041052-E282P1 rev.B	Welding Log	R	R	M-R	
33	NDE PT		QAP-PT-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	QAP-PT-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B	Welding Log	R	R	M-R	
34	NDE PMI		QAP-PMI-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B / VGS 8.10.01	QAP-PMI-01.46126 / N041052-E282P1 rev.B / N041052-E282NW1 rev.B / VGS 8.10.01	Welding Log	R	R	M-R	
35	Dimensional Check Before Surface Treatment		NA	Acc. To DRW/BOM	Dimensional Report	R	R	R	



vetcogray™
a GE Oil & Gas business

Inspection and Test Plan

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Customer: GE Oil & Gas

Purchase Order:

PO4500111369

H = Hold, W = Witness, R = Review, M = Monitoring H
=10 working days, W = 5 working days

Item	Activity	Responsible	Procedure	Accept. Criteria	Report/cert. type	NLI Nyland	GE	BP	Comments:
36	Xylan Coating		60-P-XYL-40 / N041051-000SX1	60-P-XYL-40 / N041051-000SX1	Coating Report	R	R	R	
37	Surface treatment		B-1020-33 E / VGS 6.1.38.4 rev 0	B-1020-33 E / VGS 6.1.38.4 rev 0	Coating Report	R	R	R	
Assembly									
38	FAT		N041040-120	N041040-120	FAT Report	H	H	H	
39	FAT		N042042-0003	N042042-0003	FAT Report	H	H	H	
40	FAT		N041040-14	N041040-14	FAT Report	H	H	H	
41	Check Marking / Nameplate	QC Manager	NA	Acc. to drawing / N041051-000SM1	Nameplate photo	R	R	R	
42	Final Inspection	QC Manager	NLI-B-1500	Bom / draw	MCCR, MCD and IRC	H	H	R	
43	MC Check out and MRB approval	QC Manager	NLI-B-1500	Bom / draw	Approved MCD and MRB	H	H	H	
44	Check Packing and Preservation	QC Manager	NLI-B-830	Contract / VGN-PR-LO-02	Packing list, photos	M	R	H	
45	Delivery	Storekeeper / Proj. Manager	NLI-B-830	PO	Del. Note, COC, Dispatch Dossier	R	R	H	

2. QMS Certificate

Management System Certificate

To certify conformity with // Godkjent overensstemmelse med
the Management System Requirements of // Styringssystemkravene i henhold til

NS-EN ISO 9001:2008

awarded // tildelt



NLI as

Bjellandveien 24, 3172 Vear
med følgende konsern og datterselskaper:

NLI Solutions as

NLI Engineering as
NLI Products as
NLI Subsea Service as
NLI Asker Subsea as
NLI Subsea Engineering as

NLI Oil & Industry as

NLI Larvik as
NLI Odda as
NLI Nyland as
NLI Contracting as
NLI Elektro as
NLI Industriservice as

Manufacturing/supplying following products/services:
for produksjon/leveranse av følgende produkter/tjenester:

Engineering, design, development, purchasing, manufacturing,
installation and testing of products of our own or specified by our customers

Engineering, utvikling, konstruksjon, anskaffelse, fabrikasjon, montasje
og testing av egne og kundespesifiserte produkter

Certificate No // Sertifikat nr.:

424

First issued // Utstedt første gang: 1998-08-27

Valid until // Gyldig til: 2014-04-25

Issued // Utstedt: 2012-04-18

Audit: Annual // Oppfølging: Årlig

Atle Berganist

Managing Director // Daglig leder

Hilmar Sælvaag

Technical Manager // Teknisk leder



Management System Certificate

To certify conformity with // Godkjent overensstemmelse med
the Management System Requirements of // Styringssystemkravene i henhold til

NS-EN ISO 14001:2004

awarded // tildelt



NLI as

Bjellandveien 24, 3172 Vear
med følgende konsern og datterselskaper:

NLI Solutions as

NLI Subsea Service as
NLI Asker Subsea as

NLI Oil & Industry as

NLI Larvik as
NLI Odda as
NLI Nyland as
NLI Contracting as
NLI Industriservice as

Manufacturing/supplying following products/services:
for produksjon/leveranse av følgende produkter/tjenester:

Engineering, design, development, purchasing, manufacturing,
installation and testing of products of our own or specified by our customers

Engineering, utvikling, konstruksjon, anskaffelse, fabrikasjon, montasje
og testing av egne og kundespesifiserte produkt

Certificate No // Sertifikat nr.:

587

First issued // Utstedt første gang: 2007-04-12

Valid until // Gyldig til: 2014-04-25

Issued // Utstedt: 2012-04-18

Audit: Annual // Oppfølging: Årlig

A blue ink signature of the name "Alf Bergqvist".

Managing Director // Daglig leder

A blue ink signature of the name "Håkon Selvøe".

Technical Manager // Teknisk leder



Management System Certificate

To certify conformity with // Godkjent overensstemmelse med
the Management System Requirements of // Styringssystemkravene i henhold til

OHSAS 18001:2007

awarded // tildelt



NLI as
Ryes gate 28, 3263 Larvik
med følgende datterselskaper:

NLI Alfr. Andersen as
NLI Nyland as
NLI Subsea Service as
NLI Contracting as

NLI Odda as
NLI Asker Subsea as
NLI Elektro as

Manufacturing/supplying following products/services:
for produksjon/leveranse av følgende produkter/tjenester:

Engineering, design, development, purchasing, manufacturing,
installation and testing of products of our own or specified by our customers

Engineering, utvikling, konstruksjon, anskaffelse, fabrikasjon, montasje
og testing av egne og kundespesifiserte produkt

Certificate No // Sertifikat nr.:

437

First issued // Utstedt første gang: 2005-07-01

Valid until // Gyldig til: 2014-04-25

Issued // Utstedt: 2011-04-05

Audit: Annual // Oppfølging: Årlig

Arne Skjelstad
Managing Director // Daglig leder

Håkon Selvaag
Technical Manager // Teknisk leder



Management System Certificate

To certify conformity with // Godkjent overensstemmelse med
the Management System Requirements of // Styringssystemkravene i henhold til

NS-EN ISO 3834-2

awarded // tildelt



NLI as

Bjellandveien 24, 3172 Vear
med følgende konsern og datterselskaper:

NLI Oil & Industry as

NLI Larvik as

NLI Odda as

Manufacturing/supplying following products/services:
for produksjon/leveranse av følgende produkter/tjenester:

Development, purchasing, manufacturing, installation and testing of
products of our own or specified by our customers

Utvikling, konstruksjon, anskaffelse, fabrikasjon, montasje og testing
av egne og kundespesifiserte produkt

Certificate No // Sertifikat nr.:

Gyldig i kombinasjon med TI-S Sertifikat nr.: 424

First issued // Utstedt første gang: 1998-08-27

Valid until // Gyldig til: 2014-04-25

Issued // Utstedt: 2012-04-18

Audit: Annual // Oppfølging: Årlig

Ale Bergqvist

Managing Director // Daglig leder

Hilmar Solberg

Technical Manager // Teknisk leder



3. Quality Plan

4. Material Traceability List

5. Material Certificates/ PMI Reports



Shandong Luxing Steel Pipe Co., Ltd

959 LUXING ROAD, QINGZHOU CITY, SHANDONG PROVINCE, P.R.CHINA
Tel: 86 536 3532047 Fax: 86 536 3536885



0036-CPD-13-2007

SL-0570

CERTIFICATE NO.: CSJE397/10-2-014
DATE: Apr.25th, 2011

MILL TEST CERTIFICATE

ACC. TO EN 10204/3.1(2006)

CONTRACTNO: CSJE397/10

THE BUYER:

ORIGINAL

DESCRIPTION OF GOODS: Seamless steel pipes			STANDARD AND GRADE: EN 10210 part 1 and part 2 edition 2006, S355 J2H, and DIN 2448/1629, material ST52.0, and API 5L Grade X52, 44 th edition, PSL 1.																
NORMALIZING TEMPERATURE OF THE PIPE: 920-970°C			MELTING PROCESS OF BASE MATERIAL: electric arc furnace																
QUANTITY DELIVERED			PIECES																
			9																
			THEORETICAL WEIGHT-MT																
			22.984																
Heat No. C00777	Weight (MT) 22.984	PCS 9	TEST RESULT																
			Chemical composition (14 elements)																
			H	0.16	0.48	1.57	0.018	0.016	0.026	0.017	0.017	0.004	0.003	0.011	0.0001	0.017	-	0.43	
			P	0.17	0.48	1.55	0.022	0.019	0.021	0.020	0.024	0.004	0.005	0.010	-	0.020	-	0.44	
			Mechanical property																
			Tensile strength (Mpa)				Yield strength (Mpa)				Elongation(%)				Impact value (-20°C)J				
			545				350				28				100	65	66		

VISUAL INSPECTION AND DIMENSIONAL CHECK: OK. Water Pressure Test (Pressure: 25.0MPA/ Time:6S): Satisfactory

WE DECLEAR THAT THIS MILL TEST CERTIFICATE AND THE MATERIAL DESCRIBED ABOVE HAS BEEN MANUFACTURED ACCORDING TO THE SPECIFICATION AND THE ORDER AND MEET THE REQUIREMENTS OF THE SPECIFICATION AND THE ORDER

PIECE ANALYSIS : P

HEAT ANALYSIS: H

As per our inspection

Shandong Luxing Steel Pipe Co., Ltd.
An ISO9001 Certified Company

6. Weld & NDE log

7. WPS/ WPQR/ PWHT

8. Welders Certificates

9. Visual Inspection Reports

10. NDE Reports

11. NDE Operators Certificates

12. Surface Treatment Inspection Report

13. Dimensional Inspection Report

DIMENSIONAL CHECK

CUSTOMER:	Vetco Gray Scandinavia AS		PROJECT:	Chirag			CUST. PO.NO.:	4500111369			
PRODUCT:	VCCS Jig Size 300		DRW.NO.:	N112101-02			GPL Drawing:				
NLI Nyland PROJECT NO.:	46126		MATERIAL ENTRY NO.:				GA Drawing:	A112101-02			
SPECIFIED DIMENSION:	1500	120° Typ	10° Typ	40° Typ	30°	3x M20	4x Ø22	60 Typ	60°	10	Geometric Tolerance
Part: / Ref:	A	B	C	D	E	F	G	H	I	J	
001	1500	120	10	40	30	20	22	60	60	10	OK
002											
003											
004											
005											
Instrm. No.	533	1513	1513	1513	1513	600	520	520	1513	520	
SPECIFIED DIMENSION:	5	600	600	300	40 Typ	360 Typ	2x Ø18	142 ±0,5	142 ±0,5	Ø560 ±2	Geometric Tolerance
Part: / Ref:	K	L	M	N	O	P	Q	R	S	T	
001	5	600	600	300	40	360	18	142	142	560,5	OK
002											
003											
004											
005											
Instrm. No.	520	482	482	482	520	482	520	520	520	482	
SPECIFIED DIMENSION:	Ø600	Ø104,5 ^{+0,3} ₀	75	Ø104,5 ^{+0,3} ₀	75	3X125					Geometric Tolerance
Part: / Ref:	U	V	W	X	Y	Z	AA	AB	AC	AD	
001	600	104,6	75	104,6	75	125					OK
002											
003											
004											
005											
Instrm. No.	482	520	520	520	520	520					
INSPECTOR:	S.A	DATE:	29/10/12	MACHINE NO.:							

14.08.2012 15:59

Frantz Karlstad
8/2-2013Reviewed
BO

19 Feb 2013

\nli.no\NLI Nyland\12 Projects\NLI Måleskjema\46000 - 46500\46126 GE\N112101-02.xls

14. Weighing Certificate

NLI	VEKT SERTIFIKAT WEIGHT CERTIFICATE			SERTIFIKAT NR.: CERTIFICATE NO.:	1
			NLI ORDRE NR.: NLI ORDER NO.:	5011	
KUNDE / CUSTOMER: GE OIL&GAS		PROSJEKT / PROJECT: CHIRAG	KUNDE / CUST. P.O.NO.:	SIDE / PAGE 4500111369	AV / OF 1 1
ØVRIGE OPPLYSNINGER / SUPPLEMENTARY DATA :					
VCCS JIG SIZE 300					
PRODUKT / KOMPONENTER: PRODUCT / COMPONENT:					
PART NR.: PART NO.:	SERIE NR. SERIAL NO.	VEID DATO WEIGHING DATE	VEKT / WEIGHT (Kg.)		ANMERKNINGER REMARKS
			NETTO / NET	BRUTTO / GROSS	
N112100-02 A	4500111369-000-80-001	14.02.2013	130Kg		
TOTAL VEKT / TOTAL WEIGHT :			130Kg		

VEIEUTSTYR / WEIGHING EQUIPMENT (MÅLEOMRÅDE, FABRIKAT / RANGE, PRODUCER)					
UNIT : Spanset 5Tonn Dynameter					
SER.NO: 15042-2659569					
KALIBRERT DATO: CALIBRATION DATE: 06.05.2012			KALIBR. INSTANS: CALIBR. AUTHORITY: IKM Instrutek AS		
KONTROLLAVDELING / CONTROL DEPARTMENT (Sign. / Date) NLI Larvik as Espen Håkestad 14.02.2013			VEING BEVITNET AV / WEIGHING WITNESSED BY (Sign. / Date) NLI Larvik as 14/2-2013 Pål-Justin Riksfjord Svendsen 		



VCCS JIG SIZE
300

4500111369-001

14/02/2013

15. Lifting Certificate

16. Pressure Test Traceability Certificate

17. Pressure Test Procedure / FAT Procedure

**18. Pressure Test Certificate / FAT
Report**

19. Documentation from Sub-Suppliers

**20. Non-Conformance / Concessions
Records**

Supplier Rejection Report for PO: 4500111369 Line 0080

Part Category	NEW PART	Rejection Number	GRV752029 Rev NC
Purch Order	4500111369	Plant Location	NORWAY - BIL
Sales Order		Plant Sublocation	VEN - Vendor
Cust Name		Org Code	
Part #	N112100-E155A	Rejection Status	CLOSED
PMS Code	GM - VSS (VERTICAL STROKING SYSTEM)	Status Date	2012/10/26 08:50
Part Description	ACG 3, VCCS UPFACING JIG (MANIFOLD), GENERAL ARRANGEMENT/INTERFACE	Create Date	2012/10/04 03:14
Vend #	0000016777	DLC	2012/10/26 08:50
Buyer	ANNETTE SPARBY	Last Updated By	Daniel Spasenoski
		Site	NOR
		Project Name	CHIRAG
		Responsible Person	Daniel Spasenoski

Discrepancy

GRR Type	Lot Qty	Inspected Qty	Inspected Qty Rej	Total Qty Rej	Actual Part Affected
02 - PRODUCT DEFECT	1	1	1	1	N112100-E155A

General Defect

11 - DIMENSIONAL

Specific Defect

11AN - MISSING FEATURE

Material Spec #

Detection Method

Found By/At

08 - SUPPLIER

Current Material Location

NLI NYLAND

Part Serial Number

4500111369-00080-001

Trace Numbers

Responsible Function (Preliminary)

03 - ENGINEERING

Preliminary Specific Responsibility

03 - ENGINEERING

Preliminary Root Cause

02 - DRAWING ERROR

Manufactured Origin / Location (Preliminary)

Discrepancy

ON THE DRAWING N112100-E155A ARE 3 HOLES IN THE CYLINDER MARKED. THE VERTICAL POSITION IS MISSING WHICH MEANS THAT WE CANNOT COMPLETE THE JIG. PLEASE ADVISE ON POSITION.

File Name	Size	Stored By	Stored Date
N112101-02_TQ.pdf	134,693	Nli Subsea Services AS	2012/10/04 03:14
N112101-02.pdf	92,368	Nli Subsea Services AS	2012/10/04 03:14

Disposition

Disposition Code 1	Qty 1	Disposition Code 2	Qty 2	Disposition Code 3	Qty 3
02 - REPAIR	1				

Disposition

THE DRAWING SHALL BE REWORKED.

Justification

BUILD TO PRINT LETS US DOWN.

Customer Notification Required Customer Approval Required

Rework

Customer Approval Received On	Recorded By
Moderate	RCA/NCA Required NO

Final Root Cause

02 - DRAWING ERROR

Responsible Function (Final)

05 - OTHER

Final Specific Responsibility

10 - SALES

Manufactured Origin / Location (Final)

Perform Work Without Work Order

YES

Work Order # for Performing Work

Disposition Accomplished

YES

Rejection Cost - COPQ (USD)

0

Material Accepted

YES

Material NOT Accepted. New Rejection #

Supplier Return Number

Recorded By

Authored By	Nli Subsea Services AS	2012/10/04 03:14	Reviewed By	Daniel Spasenoski	2012/10/12 14:51
Dispositioned By	Christian Warhus	2012/10/17 12:09	Released By	Ingvild Elseth	2012/10/25 10:05
Closed By	Daniel Spasenoski	2012/10/26 14:50			

Supplier Rejection Report for PO: 4500111369 Line 0080

Part Category	NEW PART	Rejection Number	GRV755628 Rev NC
Purch Order	4500111369	Plant Location	NORWAY - BIL
Sales Order		Plant Sublocation	VEN - Vendor
Cust Name		Org Code	
Part #	N112100-E155A	Rejection Status	CLOSED
PMS Code	GM - VSS (VERTICAL STROKING SYSTEM)	Status Date	2012/12/20 09:58
Part Description	ACG 3, VCCS UPFACING JIG (MANIFOLD), GENERAL ARRANGEMENT/INTERFACE	Create Date	2012/12/13 11:11
Vend #	0000016777	DLC	2012/12/20 09:58
Buyer	ANNETTE SPARBY	Last Updated By	Daniel Spasenoski
		Site	NOR
		Project Name	CHIRAG
		Responsible Person	Daniel Spasenoski

Discrepancy

GRR Type	Lot Qty	Inspected Qty	Inspected Qty Rej	Total Qty Rej	Actual Part Affected
01 - PROCESS DEFECT	1	1	1	1	N112100-E155A

General Defect

10 - DOCUMENTATION

Specific Defect

10AB - INCOMPLETE

Material Spec #

Detection Method

Found By/At

08 - SUPPLIER

Current Material Location

NLI NYLAND

Part Serial Number

0080-001

Trace Numbers

Responsible Function (Preliminary)

03 - ENGINEERING

Preliminary Specific Responsibility

03 - ENGINEERING

Preliminary Root Cause

12 - OTHER SPECIFICATION ERROR

Manufactured Origin / Location (Preliminary)

Discrepancy

REQUEST TO PROVIDE DOCUMENTATION LIMITED TO DIMENSIONAL REPORT.

DIMENSIONAL CONTROL WILL BE CARRIED OUT IN FULL.

AS PER E-MAIL D.D. 12.12.2012, IT IS CONFIRMED THAT TOOL SHALL NOT BE USED SUBSEA OR BE SUBMITTED TO EXCESSIVE WEIGHT OR STRESS.

Disposition

Disposition Code 1	Qty 1	Disposition Code 2	Qty 2	Disposition Code 3	Qty 3
01 - CONFORMS	1				

Disposition

IT SHALL ONLY BE PERFORMED A DIM CONTROL ON THE ASSEMBLY.

Justification

SEE ABOVE

Customer Notification Required NOCustomer Approval Required NO

Rework

Customer Approval Received On	Recorded By

Criticality	RCA/NCA Required	RCA/NCA Number
MINOR	NO	

Final Root Cause

33 - COMMUNICATION BREAKDOWN/ERROR

Responsible Function (Final)	Final Specific Responsibility
02 - SOURCING	12 - SUPPLIER (POST ORDER)

Manufactured Origin / Location (Final)

Perform Work Without Work Order

YES

Work Order # for Performing Work

Disposition Accomplished

YES

Rejection Cost - COPQ (USD)

Material Accepted

YES

Material NOT Accepted. New Rejection #

Supplier Return Number

Recorded By

Authored By	Nli Subsea Services AS	2012/12/13 11:11	Reviewed By	Daniel Spasenoski	2012/12/17 09:10
Dispositioned By	Roy Hestsveen	2012/12/19 13:18	Released By	Ingvild Elseth	2012/12/19 13:18
Closed By	Daniel Spasenoski	2012/12/20 15:58			

21. Certificate of Conformance



Larvik as

CERTIFICATE OF CONFORMITY

NLI Larvik as

Order No.: **5011**

SUBJECT: **VCCS JIG SIZE 300**

GE Oil&Gas as

P.O. No.: **450011369**

Ln	Article	Description	SN	Quantity
00080	N1120101-02	VCCS JIG SIZE 300 Assembly	001	1

We hereby declare that the above mentioned order is manufactured
in accordance with your purchase order.

Larvik,

18.02.2013

Company stamp and signature:

22. As-built Drwg./Mark-ups

**23. Photos of Equipment/ Testing/
Marking/ Nameplate**

24. Mechanical Completion Dossier

Equipment: VCCS JIG SIZE 300		MECHANICAL COMPLETION CERTIFICATE			GE Oil & Gas Drilling & Production Vetco Gray Scandinavia AS		
NOI no.: 30		Project: BP Chirag		MCD No: E282-MCD-0020			
Supplier: NLI		Client: BP		PO No: 4500111369			
APPROVAL SIGNATURES							
Supplier:	Name: Pål-Justin R. Svendsen	Sign: <i>Pål-Justin R. Svendsen</i>	Date: 18.02.2013				
GE Oil & Gas VetcoGray:	Name: Tore Ausland	Sign: <i>Tore Ausland</i>	Date: 18.02.2013				
End Client:	Name: Barbara Walker	Sign: <i>B. Walker</i>	Date: 18.02.2013				
SHIPMENT RELEASE CHECK RECORD							
MC Release Check Points			Yes	No	NA	PL	Sign.
1. Are all the applicable items in the Check Record (MCCR) closed ?			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<i>* B. Walker 18/2/13</i>
2. Is the equipment fabricated according to last revision drawings and specifications ? Verify with GEOG VGS PQE. If available, compare Supplier's Document Register vs. GEOG VGS's ePIMS / SiMON Systems !			<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
3. Are all applicable technical issues answered and closed ? Verify with GEOG VGS PQE. If available, check the Supplier NCR Log and GEOG VGS's GRR & EPIC Systems !			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<i>* B. Walker 18/2/13</i>
4. Are all Inspection Activities completed as per the approved ITP ? Verify with GEOG VGS PQE. If available, check the ITP and all relevant Quality Records !			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<i>* B. Walker 18/2/13</i>
5. Have the equipment been through all relevant FAT and Functional Tests and accepted ?			<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
6. Equipment's Manufacturing Records Book (MRB) have been reviewed and found acceptable ? MRB Acceptance Codes: Yes = Code 1 / PL = Code 2 / No = Code 3 / NA = Code 4			<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
7. Are there any other documents – besides the Certificate of Conformity – which need to follow the shipment ? Ex.: Material Traceability List and Material Certificates for items to be welded / Lifting Certificates / FAT / Test Reports ? Check the SDRL ! Verify with GEOG VGS PQE.			<input type="checkbox"/>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	
8. Has the equipment been finally inspected and accepted / released for shipment ?			<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>	<i>* B. Walker 18/2/13</i>
COMMENTS							
<p>* REF GRV # 755628</p>						<p>* <i>(B.W.)</i> Note Dimensional Report Reviewed</p> <p>> Fastener holes Located as per Drwg Rev C</p> <p>(GRV. 752029) Reviewd 19 Feb 13</p> <p>B. Walker COPX</p>	

Equipment: VCCS JIG SIZE 300		MECHANICAL COMPLETION CHECK RECORD			 GE Oil & Gas Drilling & Production Vetco Gray Scandinavia AS		
NOI no.: 30	Project: BP Chirag				MCD No:	E282-MCD-0020	
Supplier: NLI	Client: BP				PO No:	4500111369	
MCD CHECK POINTS I							
This is a General Check List. The MC Inspector should mark by an X all the relevant checks points.							
No.	Check Point description	X	PL no	Checked by / Sign. Date			
				Supplier	VGS	Client	
General Check Points							
1.	Perform a Visual Inspection. Ensure that all components are free from damage (scratches, dents, etc.).	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
2.	Check that all markings (tag plates where required) have been included / applied according to Purchase Order Requirements.	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
3.	Ensure that Sealing Surfaces are adequately greased, where applicable.	NA					
4.	Ensure that Heat Numbers (Batch Nos. / Serial Nos.) are correctly marked both on the items and on the documentation.	NA					
5.	Perform a random Visual Inspection of the welds. Ensure that the accessible welds are visually acceptable.	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
6.	Ensure that an acceptable Certificate of Conformity is available for this equipment.	X		<i>[Signature]</i>	<i>ordina</i>		
7.	Ensure that all Material Certificates are available and full Material Traceability verified.	NA					
8.	Ensure that Material Certificates for all Consumables (inlay / welding material, coating materials, etc.) are available.	NA					
9.	Ensure that Dimensional Inspection / Check has been satisfactorily carried out and documented.	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
10.	Ensure that all the relevant WPS-s / WPQR-s were reviewed and pre-approved by GE and included in the MRB, as per SDRL.	NA					
11.	Ensure that the Welding Log and all required NDE (including PMI) is completed and recorded.	NA					
12.	Ensure that all inspection & testing activities required by the approved ITP are fully documented and recorded in the MRB.	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
13.	Ensure that Surface Treatment / Coating is complete, recorded and according to specification (including the colour).	NA					
14.	Ensure that all Electrical Continuity Checks have been satisfactorily carried out and recorded.	NA					
15.	Ensure that Lifting Certificate is available and accepted.	NA					
16.	Ensure that Weight Report / Certificate is available at least for one unit.	X		<i>[Signature]</i>	<i>ordina</i>		
17.	Ensure that Assembly has been performed according to correct revision of the drawings.	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
18.	Ensure that the MCD is fully documented by photos of the equipment / packaging.	X		<i>[Signature]</i>	<i>ordina</i>	<i>(BW)</i>	
19.	Check that the applicable Manufacturing Records Book sections are complete. [Ref. Specs.: E000-SQG-0001 / E000-SQG-0002]	X		<i>[Signature]</i>	<i>ordina</i>		
Insulation Check Points							
20.	Check that correct thermal insulation material is used	NA					
21.	Check traceability to GEOG VGS tag no. and that batch & tag markings on product match.	NA					
22.	Check moulding traceability records; visual inspection, dimensional and hardness checks.	NA					

Equipment: VCCS JIG SIZE 300		MECHANICAL COMPLETION CHECK RECORD			 GE Oil & Gas Drilling & Production Vetco Gray Scandinavia AS		
NOI no.: 30	Project: BP Chirag				MCD No:	E282-MCD-0020	
Supplier: NLI	Client: BP				PO No:	4500111369	
MCD CHECK POINTS II							
This is a Product Specific Check List. The MC Inspector should mark by an X all the relevant checks points.							
No.	Check Point description	X	PL no	Checked by / Sign. Date			
				Supplier	VGS	Client	
23.	Check records for weekly testing, density, thermal conductivity, specific heat capacity and hardness checks.	NA					
24.	Inspect thermal insulation on products for visual defects.	NA					
25.	Verify that minimum thicknesses of thermal insulation are achieved.	NA					
26.	Check by measurements the length of pipes for verification of up-facing fabricator measurements.	NA					
Clamp Connector Check Points							
27.	Ensure that the Torque Tool (TT) interface is installed.	NA					
28.	Ensure rubber springs correctly mounted on one side (only for clamps with casing)	NA					
29.	Ensure that surface roughness on the segments is according to the drawing requirements.	NA					
30.	Ensure that entering chamfers are grinded on the segments as specified in the drawing.	NA					
31.	Ensure that cable strapping has the right length and that it is welded / brazed to cable shoe.	NA					
32.	Ensure the correct type of grease is applied on uncoated load shoulders of the segments (as specified on drawing).	NA					
33.	Ensure tool lifting mandrel correctly mounted (only for clamps with casing)	NA					
34.	Ensure holes for lifting points included and marked correctly (only for clamps with casing)	NA					
Seals Check Points							
35.	Inspect all sealing areas for damage, contamination and protection.	NA					
36.	Check that Silver coating (Xylan on test seals) is according to specification [N041051-000SS1 / E000-SMS-2035].	NA					
37.	Separate seal area control measurements have been done on both sides after machining, according to drawing / specification (min. 8 measuring points on diameter).	NA					
38.	Seal area surface roughness has been recorded and is within drawing / specification requirements.	NA					
39.	Retainer locking tabs are bent out to specified position within tolerances according to drawing / specification. (5 mm +1/-0).	NA					
Hubs / Pressure Caps / Pressure Caps Assemblies Check							
40.	Inspect all sealing areas for damage, contamination and protection.	NA					
41.	Ensure that dimensional control has been carried out and documented.	NA					
42.	Ensure that each separate seal area has been controlled, measured and recorded after machining.	NA					
43.	Ensure that the seal area surface roughness has been recorded and is within tolerances.	NA					
44.	Ensure that bolt holes are protected with Tectyl 506 WD.	NA					

Equipment: VCCS JIG SIZE 300		MECHANICAL COMPLETION CHECK RECORD			 GE Oil & Gas Drilling & Production Vetco Gray Scandinavia AS																																																																																																																																																																																											
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25. Heat Treatment Record

26. Electrical Certification & Record

27. Instrumentation

**28. Miscellaneous Certification Reports
& Calibration Records**

29 Softwear Test Results