

TUV INDIA PRIVATE LIMITED

INSPECTION RELEASE NOTE / CERTIFICATE

IRN - 8117789926 /1001138420 - 03 - Rev. 00



TUV India Control Or SAP Number:	8117789926/ 1001138420	Date:	20-07-2021
Project Name & Location	LNG REGAS FACILITIES AT CHHARA, GUJARAT.	TUV India Branch Name:	Ahmedabad
TUV India Client Name:	TOYO ENGINEERING INDIA PVT. LTD.	End User Name:	HPCL SHAPOORJI ENERGY PVT LTD.
DEC / PMC / EPC Name: <i>(If applicable)</i>	ENGINEERS INDIA LIMITED.(EIL)	DEC / PMC / EPC Asgmt. Number: <i>(If applicable)</i>	EIL JOB NUMBER – B287
Vendor Name & Location:	M/s Ratnamani Metals & Tubes Ltd.- Bhimasar ,Anjar(Kutch)	P.O. Number: <i>(Client PO on Vendor)</i>	P/6399/35788/AYHA204B-3 Dated 10.04.2021
Sub Vendor Name & Location: <i>(If applicable)</i>	Not Applicable.	P.O. Number: <i>(If applicable - Vendor PO on Sub Vendor)</i>	Not Applicable.

Item Description:

PO Item No.	Item Code	Item Description	UOM	P.O. Quantity	Offered Quantity	Accepted Quantity	Cumulative Accepted Quantity
6	Item code- I16401823 19 Commodity code APPKE0M BD34	SS EF Welded Pipes, R/L (10 - 12 Meters.), BE, B36.19M, CRYO with Impact test. MOC: ASTM A 358 TP304 Class-I Size: 16 NPS X SCH 10S , Heat No. Y210405A45-7 Lot No.1 MTC No.93010024211120 Dt.20.07.2021	Meters.	30.000 Meters.	34.185 Meters. (03 Nos.)	34.185 Meters. (03 Nos.)	34.185 Meters. (03 Nos.)

Reference Documents:

Sr. No.	Document Name	Client Document Number	Vendor Document Number	Approval Status
1)	PR / MR / ARM	AYHA204 Rev.01 Dt.24.02.2020 for Job no. 6399	Not Applicable.	Approved by TEIPL.
2)	QAP / ITP / QCP	Not Applicable.	INSP-QAP-WELDED PIPE-01 Rev.02 Dt.01.06.2020	Approved by TEIPL. & TUV
3)	Drawing(s)	Not Applicable.	Not Applicable.	Not Applicable.
4)	Datasheet(s)	Not Applicable.	Not Applicable.	Not Applicable.
5)	Procedure(s)	Not Applicable.	1.Weld Map-WMP/40191271 Rev.02 dt.02.05.2020 2.Procedure for LPT(Solvent Removable Method)-LPT/40191271 Rev.00 Dt.11.03.2020 3.Procedure for Digital radiography& Radiography testing of pipes- RTDRT/40191271 Rev. 00 Dt.11.03.2020 4.Procedure for Pickling & Passivation-PIC/40191271 Rev.01 Dt.22.04.2020 4.Material colour coding ,Marking, Traceability Procedure- CCM/40191271 Rev. 00	Approved by TEIPL. & Approved by TUV (NORD) INDIA PVT. LTD. Approved by

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TUV India Pvt. Ltd. (TUV NORD GROUP): (REGD. & HEAD OFFICE), 801, Raheja Plaza - I, LBS Marg, Ghatkopar (West), Mumbai - 400086, Maharashtra, India.
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			Dt.11.03.2020 5. Procedure for Hydro testing of Pipes-HT/40191271 Rev. 00 Dt.11.03.2020	TEIPL. & Approved by TUV (NORD) INDIA PVT. LTD.
6)	Others (Specify)	1.General notes for piping material-A6399-PI-5103 Rev. C Dt.24.02.2020 2.Engineering Specification for Marking of piping material-A-6399-PI-5106 Rev. 0 Dt.26.08.2019 3. Standard Specification for Positive Material Identification-6-81-0001 Rev. 03 Dt.19.09.2016	Not Applicable.	Approved by TEIPL. Approved by EIL.

Stages Witnessed:

- As per Approved QAP. Sr. No. -4 Sampling has been done for Chemical test, Mechanical tests (Tensile test and Bend test) and IGC test A262 practice "E" & Impact test.
- As per Approved QAP. Sr. No. -6(a) Witnessed 10% randomly selected Pipes of Qty. DP test on bevelled faces – No indication observed found acceptable.
- As per Approved QAP. Sr. No. -6(b) Witnessed Digital radiography images for 100% longitudinal weld seam after Solution annealing - found acceptable.
- As per Approved QAP. Sr. No. -7 Witnessed Mechanical tests (Weld Tensile test and Bend test) at manufacturer's in-house lab testing facility - found to meet the specification requirements.
- As per Approved QAP. Sr. No. -7 Witnessed Impact testing@ minus196° (PM, Weld and HAZ) at manufacturer's in-house lab testing facility - found to meet the specification requirements.
- As per Approved QAP. Sr. No. 7 Witnessed IGC test practice "E" with micro at 20X and 250X magnification at manufacturer's in-house lab testing facility - found to meet the specification requirements.
- As per Approved QAP. Sr. No.-8 Witnessed PMI test 02 Nos Pipes/Heat Size & 10% randomly selected Pipes of Qty. – found to meet the specification requirements.
- As per Approved QAP. Sr. No.-10 Hydro Test witnessed of 10% randomly selected Pipes for pressure 400 PSI (g) – No leakage or pressure drop observed During Holding Time (Min.05 Second).
- As per Approved QAP. Sr. No.-11 Witnessed 10% randomly selected Pipes of Qty. product Marking & Colour Coding - found Satisfactory.
- As per Approved QAP. Sr. No.-12 Witnessed 10% randomly selected Pipes of Qty. Dimensional Inspection (Straightness, Bevel Angle, Root Face, and Outer diameter, Thickness, Length, Ovality and Squareness – found within tolerance limit.
- As per Approved QAP. Sr. No.-12 Visual checks for surface condition – No injurious surface defects were observed.
- All measuring instruments/ equipment were verified for continued suitability for intended use, proper identification, calibration status, traceability to national standards & found satisfactory.

Documents Reviewed:

- As per Approved QAP. Sr. No. -1 Reviewed raw material identification report with copy of raw material test certificates - found Satisfactory.
- As per Approved QAP. Sr. No. -3 Reviewed Approved WPS, PQR, WPQ and Pipe welding records - found Satisfactory.
- As per Approved QAP. Sr. No. -5 Reviewed heat treatment (Solution Annealing) Chart & reports - found Satisfactory.
- As per Approved QAP. Sr. No. -6(b) Reviewed Digital radiography report for 100% longitudinal weld seam - found Satisfactory.
- As per Approved QAP. Sr. No. 7 Reviewed product analysis (Chemical test) report- found to meet the specification requirements.
- As per Approved QAP. Sr. No.-8 Reviewed PMI test report. – found satisfactory.
- As per Approved QAP. Sr. No. 9 Reviewed Pickling & Passivation inspection report- found to meet the specification requirements.
- As per Approved QAP. Sr. No.-10 Reviewed Internal Hydro Test report- found satisfactory.
- Reviewed calibration certificates of measuring instruments & internal inspection reports - found Satisfactory.
- As per Approved QAP. Sr. No.-14 Reviewed Pre-shipment Inspection report for Packing of Pipes & End protection -found satisfactory.
- Reviewed Water Chloride test certificate found satisfactory.

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- 12) Reviewed weld consumable test certificate found satisfactory.
13) As per Approved QAP. Sr. No.-15 Reviewed manufacture's test certificate No. 93010024211120 Dt.20.07.2021-Found satisfactory.

NCR / Waiver: (if Any)

None

Identification:

10% witnessed pipes identified with soft (electro Etch) double stamp and remaining Pipes are identified with Single stamp Electro Etch) as "  "near marking.

Order status:

☐ Complete ☒ Incomplete

Sub order status: (If applicable)

☐ Complete ☐ Incomplete

Date(s) of Inspection:

17.07.2021 , 19.07.2021(Bharat Joshi) & 20.07.2021(Kuldeepsinh Rana)

Conclusion:

All items were inspected within the scope defined in approved PO, QAP, specifications & Found to meet the requirements of purchase order & Specifications.



Kuldeepsinh Rana for self and on behalf of
Bharat Joshi

Inspector(s) to TUV India Private Limited

Distribution List: ☒ TUV India Client / End User ☒ TUV India Executing / Originating Branch ☒ Vendor / Sub Vendor

Revision Number (If Applicable) : 00 – Type Reason for revision here.

This Document Supersedes IRN No.: Mention previous IRN Number.

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