

Inspection report

Inspection summary

Inspection Order No.	PO 000340
Product Description	Gate Valves
Factory Name	***
Purchaser	***
Inspection Date	Oct. 8th to 9th 2016
Inspected By	***

Items for inspection

Check rate: 100%

No.	Item	Standard	Result	NCR Activity
1	Quantity	As per order list	✓	
2	Pressure test	EN12266	✓	
3	Dimensions	As per drawings	✓	
4	Material	As per client's specification	✓	
5a	Painting	See images	✓	*
5b	Appearance	See images	✓	*
6	Nameplate & marking	See images	✓	
7	Packing	As per spec	✓	**

* All valves had not yet been cleaned and repaired when inspected, so there are some painting and appearance issues on the flange and body surface. I have asked the factory have to repaint and repair all defective valves before shipping.

** Had not completed the packing for all valves during visit.

1. Quantity

All quantities meet the requirement on order provided by the factory.

2. Pressure Test

DN200 Gate Valve with Gear Box - **PASS**

Zero leaking on both shell test and seal test.

A. Pressure test

Shell test pressure ≥ 1.5 times nominal pressure (24 bars for PN16)

Seal test pressure ≥ 1.1 times nominal pressure (17.6 bars for PN16)

B. Shortest dwell time

Shell test pressure ≥ 180 s.

Seal test pressure for ≥ 60 s.

SHELL TEST IMAGES



SEAL TEST IMAGES



DN200 Gate Valve - PASS

Zero leaking on both shell test and seal test

SHELL TEST IMAGES

SEAL TEST IMAGES



DN450 Gate Valve - PASS

Zero leaking on both shell test and seal test

SHELL TEST IMAGES

SEAL TEST IMAGES

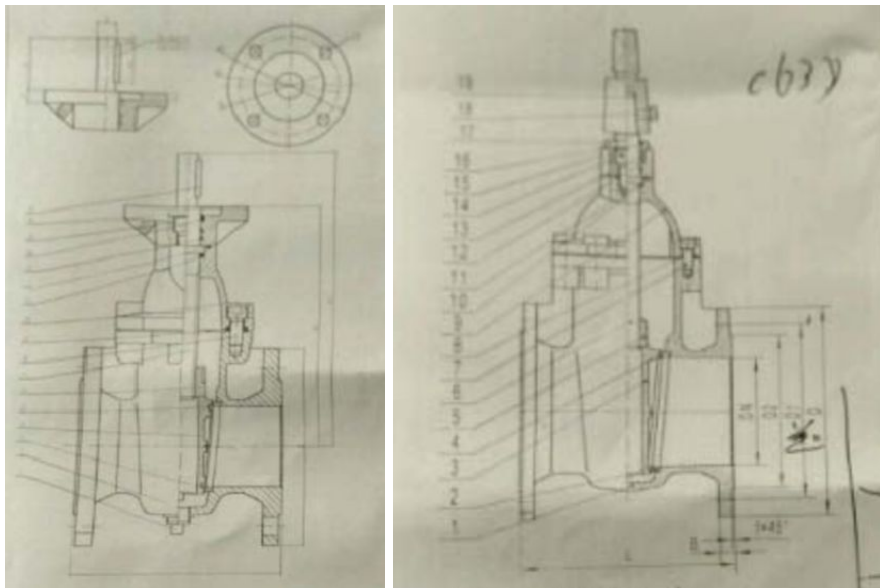


3. Dimensions

Checked 1 to 2 valves on each valve type for dimensions according to the drawings provided by the factory.
All dimensions meet drawing required. Detailed dimensional report below:

Size	Required Dimensions					Measurements					Result
DN	L±2	D	D1	B	n-d	L±2	D	D1	B	n-d	OK
200	292	Ø340	Ø292	19	12-Ø23	294	Ø340.8	Ø295.4	24.5	12-Ø23.1	OK
200 with gear box	292	Ø340	Ø295	19	12-Ø23	293.7	Ø341	Ø295.1	24.8	12-Ø23.2	OK
450	432	640	585	30	20-31	434	641	586	34.7	20-Ø 31.5	OK

DRAWINGS



4. Material

Checked the material date according to the material certificates of chemical component and mechanical property provided by factory.

Heat codes



Item	Description	Heat codes	
		Body	Bonnet
1	DN200 Gate Valve	C691	C685
2	DN450 Gate Valve	C68Z	D655C

NB. For example of DN450 Gate Valve, **C691** on 1st Sep. 2016.

- **C** means made by electric furnace
- **6** means 2016
- **9** means Sep.
- **1** means 1st

5a. Painting

The painting thickness is from 684 to 1221 μ m on DN200 gate valves and 465 to 828 μ m.

PAINT TEST IMAGES



Checked all valves on painting and appearance. All valves have not yet been cleaned and repaired when I inspected, so there are some painting and appearance issues on the flange and body surface. I had asked the factory have to repaint or repair all defective valves before shipping.

5b. Appearance



On DN200 Gate Valve



On DN200 Gate Valve with Gear Box



On DN450 Gate Valve

6. Nameplate & Marking

Markings are ok.



7. Packing

Packing incomplete at time of inspection.

END OF REPORT