



INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

1 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A

Vendor/Location	HEBEI ABTER STEEL PIPE CO., LTD.	Person Contracted	Mr. Huang Dong
Sub-vendor/Loc.		Inspection Date	20 th Sep 2025
Delivery Date	N/A	Next Inspection Date	N/A

Inspected Item Description (As per PO/Contract/other References)

No	PO Quantity (pcs)	Description	Inspection Qty. (pcs)
1	1	12 meters 800mm NB API 5L Grade X42 LSAW Pipe SCH STD	1
2	5	60 meters 900mm NB API 5L Grade X42 LSAW Pipe SCH STD	5
3	2	12 meters 750mm NB API 5L Grade X42 LSAW Pipe SCH XS	2

Inspection Result

Accepted Conditional Discrepancy/NCR

Inspected by: Name/Date/Signature**Approved by: Name/Date/Signature**An Guoqiang
20th Sep 2025**Inspection Activities according to the ITP No.**

Item	ITP Activity No.	Activity Description	TPI Involvement
1	/	Quantity inspection	W-100%
2	/	Visual inspection	W-100%
3	/	Marking inspection	W-100%
4	/	Dimension inspection	W-100%
5	/	Ovality test	W-100%
6	/	Documents review	R-100%

Inspection Description

➤ As per PO and client requirements, the CHITAKO inspector arrived at the Cangzhou Haihao Huizhe Steel Pipe Co., Ltd. to perform the final inspection for pipes on Sept. 20th 2025.



INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

2 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A

- The inspection contents including that the quantity inspection, visual inspection, marking inspection, dimension inspection, ovality test and document review.
- The inspection ratio was 100%
- The inspection results were acceptable.
- Details as follows:

1. Quantity inspection

- Per the PO, the inspector checked the quantity of steel pipes and found the quantity was met the PO requirement.
- The result was acceptable.

2. Visual inspection

- As per the client's requirement, the inspector checked the internal and external surface quality of the pipes. No found damage, deformation, etc.
- Inspector checked the quality of the welds on inside and outside of the pipe, no found porosity, spatter, missing welding, pit and undercut.
- Inspector checked the paint and no found bubbling, pin-holes, orange skin, runs etc.
- The result was acceptable.

3. Marking inspection

- As per the client's requirement, the inspector checked the marking of the pipes.
- The inspector found the marking information were correctly and clearly marked on the pipe surface
- The marking inspection results were acceptable.
- Detail as follow:

Item	Marking
1	API 5L X42 LSAW 32" SCH STD 12.0M Heat No.1522107839YF2 BTA 77731



INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

3 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A

2	API 5L X42 LSAW 36" SCH STD 12.0M Heat No.1522107503E BTA 77731
3	API 5L X42 LSAW 30" SCH XS 12.0M Heat No.1522109392E BTA 77731

4. Dimension inspection

- As per API 5L, the inspector checked the dimension of the pipes.
- Before dimension inspection, all used tools were checked and found in good condition and calibrated & within the validity period.
- The dimension inspection results were acceptable.
- Detail as bellow :

(Unit: mm)

Item	12 meters 800mm NB API 5L Grade X42 LSAW Pipe SCH STD						Result
1	Req.	OD	WT	Angle	Length	Root face	Acc
		813±1.6	9.53(+1.43,-1.19)	30°-35°	12000	0.8	
	Act.	813.7	10.2-10.3	34	12015	0.9	

Item	60 meters 900mm NB API 5L Grade X42 LSAW Pipe SCH STD						Result
2	Req.	OD	WT	Angle	Length	Root face	Acc
		914±1.6	9.53(+1.43,-1.19)	30°-35°	12000	0.8-2.4	
	Act.	915.3	10.1-10.2	33	12015	1.6	
	Act.	915.6	10.1-10.2	34	12016	1.8	
	Act.	915.3	10.1-10.3	33	12020	1.2	
	Act.	915.6	10.0-10.1	32	12020	1.8	
	Act.	915.3	10.0-10.3	33	12020	1.7	

Item	12 meters 750mm NB API 5L Grade X42 LSAW Pipe SCH XS						Result
3	Req.	OD	WT	Angle	Length	Root face	Acc



INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

4 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A

		762(±1.6)	12.7(+1.9,-1.5)	30°-35°	12000	0.8-2.4	
	Act.	762.4	12.8-12.9	32	12015	1	
		763.4	13-13.1	35	12014	1.2	

5. Ovality test

- As per the API 5L, inspector checked the ovality of the pipes. The testing method employs the diameter method.
- The result was acceptable.
- Detail as bellow :(Unit: mm)

Item	1	2					3	
Req.	≤4.065	≤4.57					≤3.81	
OD(max)	813	915	914	912.7	915.5	915	761.7	762.5
OD(min)	812	914	913	912.5	914.5	913	761	761
Act.	1	1	1	0.2	1	2	0.7	1.5
Result	Acc	Acc	Acc	Acc	Acc	Acc	Acc	Acc

6. Document review

- The inspector reviewed the Calibration certificate and result was acceptable.

Referenced Documents/Procedures/Standards

No.	Document Title	Document No. and Revision	Document Status
1	PO	-	Effective
2	API 5L	2018	Effective

Instruments/Tools Used

No.	Instrument Name	Serial No./Tag No.	Calibration No.	Expire Date
1	Vernier caliper	10054179	252014250208003	Feb.07 2026
2	Vernier caliper	20031458	252014250208005	Feb.07 2026



INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

5 of 12

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PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A	

3	Thickness gauge	HL2561013	252014250208011	Feb.07 2026
4	Angle(0~320°)	2214547	252014250208002	Feb.07 2026
5	Steel tap	AY021004	252014250208009	Feb.07 2026

Documents Reviewed

No.	Document Title	Document No. and Revision	Remarks
1	Calibration certificate	-	Acc

Discrepancies/Non-Conformities

N/A

Attachments

No.	Document Title	Document No. and Revision	No. of Pages
1	Calibration certificate	-	19

Inspection Time and Mileage

Inspection Time	8 Hours	Mileage (Km)	220 Km
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Photos



Quantity inspection



Quantity inspection



INSPECTION REPORT

CIK-QMS-03-Rev.0

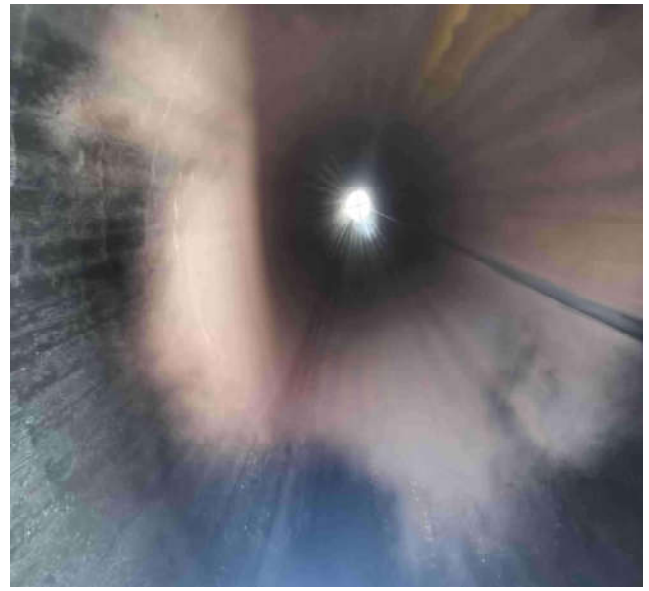
Page

6 of 12

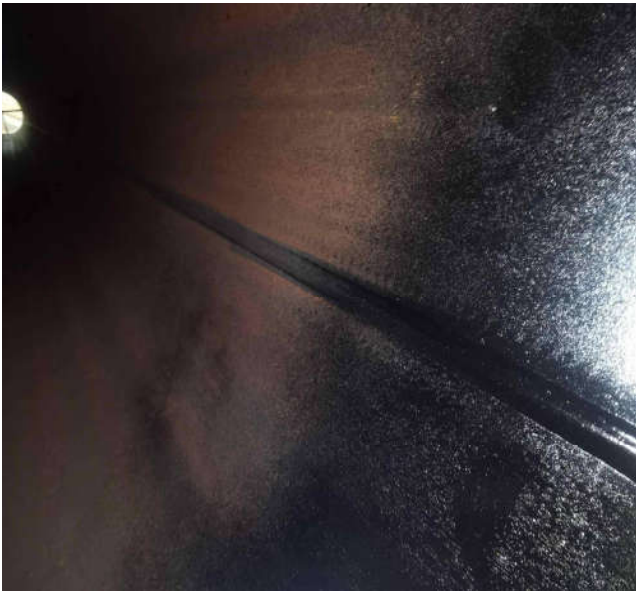
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Visual inspection



Visual inspection



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INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

7 of 12

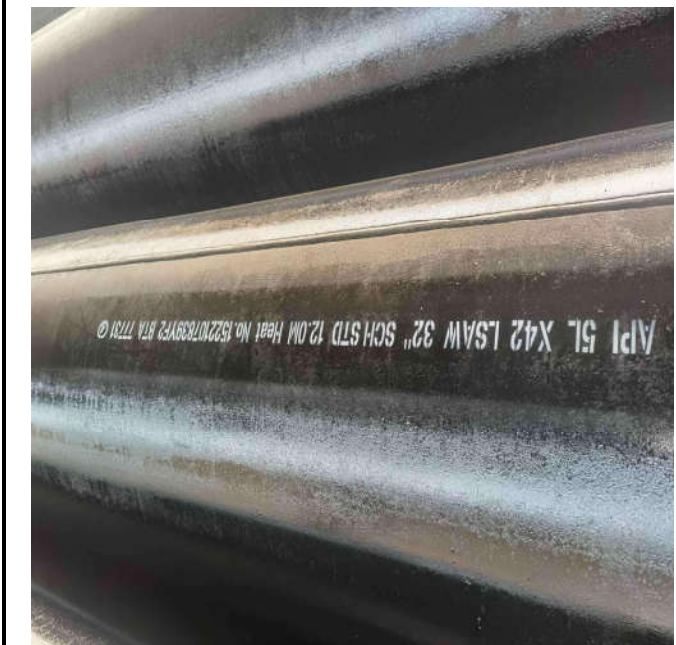
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Visual inspection



Marking inspection



Marking inspection



Marking inspection



INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

8 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A



Dimension inspection



Dimension inspection



Dimension inspection



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INSPECTION REPORT

CIK-QMS-03-Rev.0

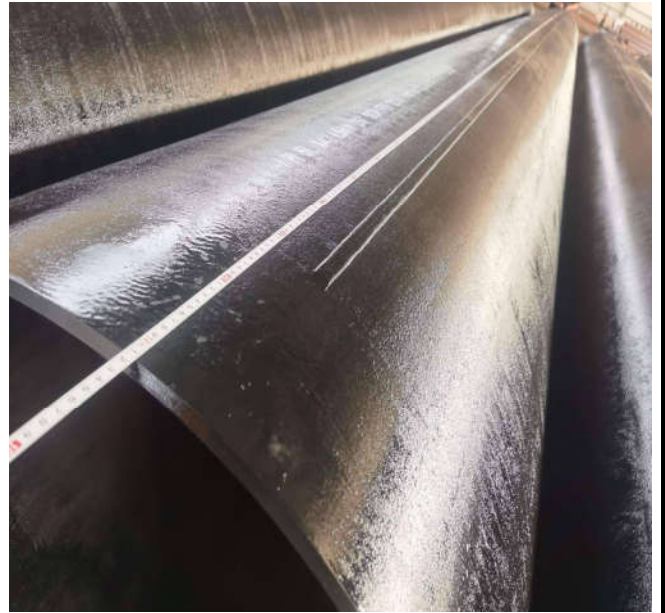
Page

10 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A



Dimension inspection



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Dimension inspection



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INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

11 of 12

Project	Pipe Inspection	Notification No.	N/A
PO No.	CIK-IR-Cangzhou-Abert-Pipe-20250920	Report No.	N/A



Ovality inspection



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INSPECTION REPORT

CIK-QMS-03-Rev.0

Page

12 of 12

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Ovality inspection



Ovality inspection

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