



INSPECTION REPORT

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Project	Pipe Inspection	Notification No.	N/A
Report No.	CIK-IR-Cangzhou-Abert-Pipe-20251114	PO No.	N/A

Vendor/Location	HEBEI ABTER STEEL PIPE CO., LTD	Person Contracted	Mr. Huang
Sub-vendor/Loc.		Inspection Date	Nov. 14 th 2025
Delivery Date	N/A	Next Inspection Date	N/A

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

No	Item No	Description	Quantity
1	1	36 meters 800mm NB LSAW Long Weld Pipe API 5L Grade X42 SCH STD	36.00 M/6PCS
2	2	12 meters 1000mm NB LSAW Long Weld Pipe API 5L Grade X42 SCH S STD	12.00 M/2PCS
3	3	108 meters 450mm NB ASTM A106 / API 5L GRB SMLS PIPE SCH40	108.00 M/18PCS

Inspection Result

Accepted Conditional Discrepancy/NCR

Inspected by: Name/Date/SignatureZhao Jiang
Nov. 14th 2025**Approved by: Name/Date/Signature****Inspection Activities according to the ITP No.**

Item	ITP Activity No.	Activity Description	TPI Involvement
1	/	Quantity inspection	Acc
2	/	Visual inspection	Acc with comments
3	/	Dimension inspection	Acc
4	/	Marking inspection	Acc
5	/	Document review	Not provided

Inspection Description



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- As per PO and client requirements, the CHITAKO inspector arrived at the Hebei Haihao Group Huize Pipe Industry Co., Ltd. to perform the final inspection for pipes on Nov. 14th 2025.
- The inspection contents including that the quantity inspection, visual inspection, marking inspection, dimension inspection and document review.
- The inspection ratio was 100%
- The inspection results were acceptable with comments.
- Details as follows:

1. Quantity inspection

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

Item	Qty of inspection list (PCS)	Qty on site (PCS)
1	6	6
2	2	2
3	18	18

2. Visual inspection

- According to the client request, CIK inspector checked pipes appearance under black paint and clear varnish condition according to the ASTM API 5L& ASTM A106.
- The pipe outer and inner surface was smooth, no defect found, such as crack, scratch, porosity, pit etc.
- [The inspection result was acceptable with the below comment.](#)



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- Comment-01: Some iron filings and debris were found on item 3 pipes inner surface. The iron filings and debris were cleaned up onsite. This punch item was closed by vendor.

- The iron cross arm was found on item-01 pipe, the iron arms is directly welded to the pipe wall. This punch items need to be confirmed by client. Please note that the welding appearance in the iron crossarm area is very poor, with welding spatter, run-off and residual welding slag.

3. Dimension inspection

- CIK inspector performed the dimensional check for the SAWL&SMLS steel pipe for each specification.
- 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	OD	THK	Bevel angle°	Root face	Length	Ovality
1	812.9-814.2	10.0-10.2	33.5-34.0	1.7-1.9	5994-5996	1.0-1.5
Req.	813±1.6	8.58-10.48	30-35	1.6±0.8	6000	/
2	1016.0-1017.0	10.2-10.3	33	1.4-1.7	5994	0.5-1.0
Req.	1016±1.6	8.58-10.48	30-35	1.6±0.8	6000	/
3	456.7-457.9	13.8-14.7	33-33.5	1.4-1.6	5986-5994	0.3-0.9
Req.	457+1.6, -0.8	12.49-16.41	30-35	1.6±0.8	6000	<6.8

4. Marking inspection

- As per the client's requirement, the inspector checked the marking of the pipes.
- The steel pipe marking by paint spray on the pipe body
- The inspector found the marking information were correctly and clearly marked on the pipe surface



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- The marking inspection results were acceptable.
- Detail as follow:

Item	Marking content
1	API 5L X42 LSAW 32" SCH STD 6.0M Heat No.1522107839YF2 BTA 78256 
2	API 5L X42 LSAW 40" SCH STD 6.0M Heat No.25600917A BTA 
3	API 5L ASTM A106 GR B SMLS 18" SCH 40 6.0M Heat No.25103321 BTA 78256 

5.Document review

- The factory did not provide any documents for the inspector to review.

Referenced Documents/Procedures/Standards

No.	Document Title	Document No. and Revision	Document Status
1	API 5L	Pipe line	Applicable
2	ASTM A106	Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service	Applicable

Instruments/Tools Used

No.	Instrument Name	Serial No./Tag No.	Calibration No.	Expire Date
1	Vernier caliper(0-300mm)	10054179	25201425020800 3	2026.02.0 8
2	Vernier caliper(0-600mm)	10052194	25201425020800 4	2026.02.0 8
3	Steel tape(0-15m)	AY02206	25201425020800 6	2026.02.0 8
4	Steel tape(0-10m)	AY021004	25201425020800 9	2026.02.0 8



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5	Thickness gauge	HL140126	25201425020801 0	2026.02.0 8
6	Bevel angle ruler(0-320)	2214547	25201425020800 2	2026.02.0 8

Documents Reviewed

No.	Document Title	Document No. and Revision	Remarks
1	Calibration certificates		/

Discrepancies/Non-Conformities

The iron cross arm was found on item-01 pipe, the iron arms is directly welded to the pipe wall. This punch items need to be confirmed by client. Please note that the welding appearance in the iron crossarm area is very poor, with welding spatter, run-off and residual welding slag.

The factory did not provide any documents for the inspector to review.

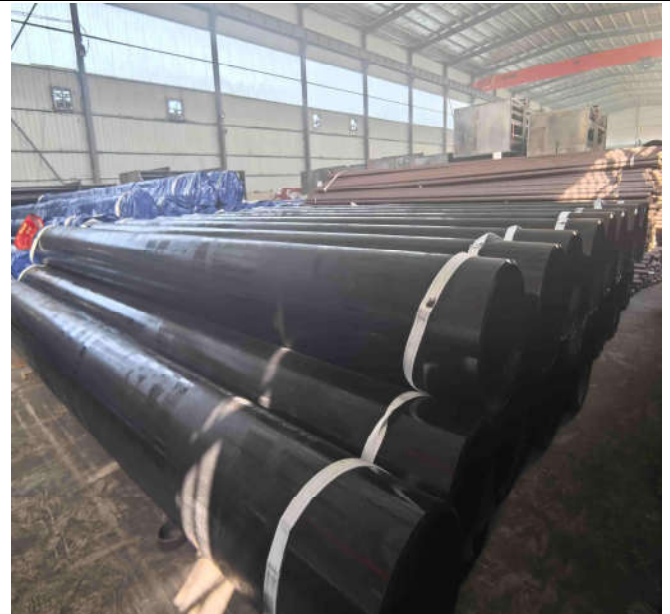
Attachments

No.	Document Title	Document No. and Revision	No. of Pages
1	Calibration certificates	/	N/A

Inspection Time and Mileage

Inspection Time	8 Hours	Mileage (Km)	120 km
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Photos





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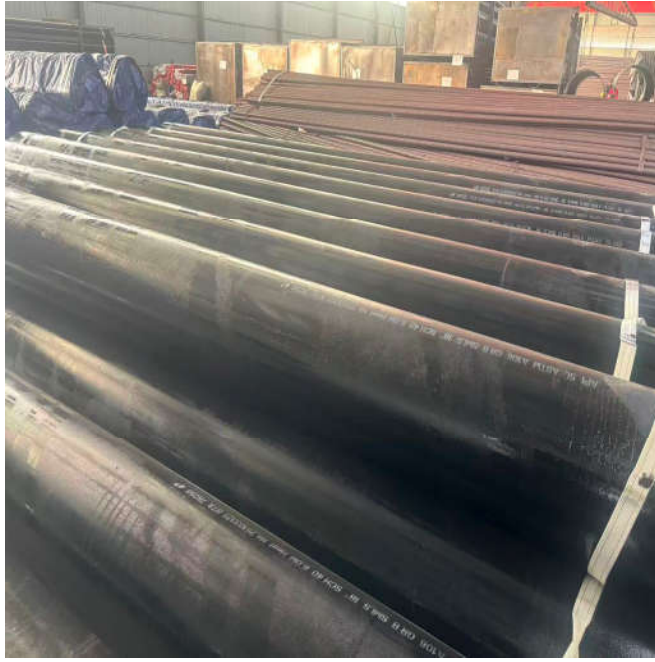
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Visual and quantity inspection



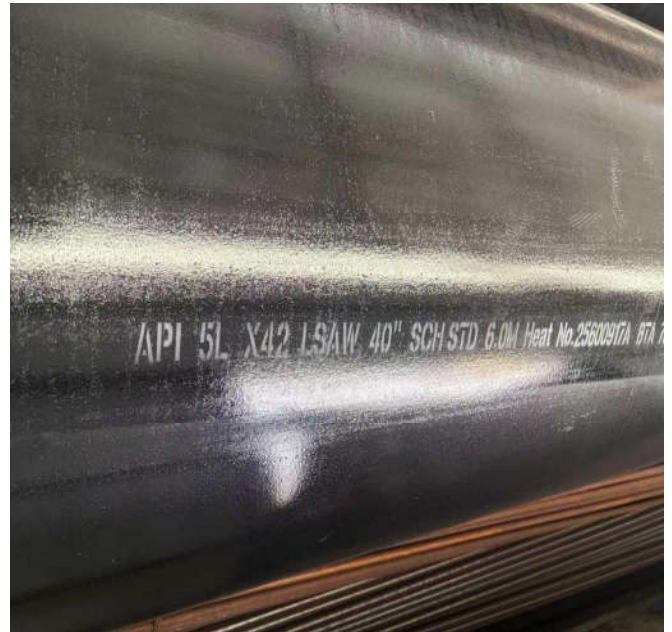
Visual and quantity inspection



Visual and quantity inspection



Visual and quantity inspection



Visual and quantity inspection

Marking inspection



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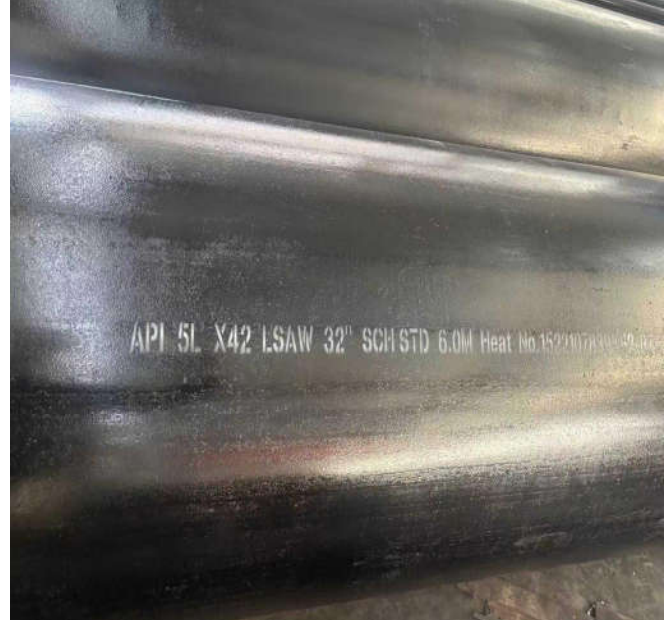
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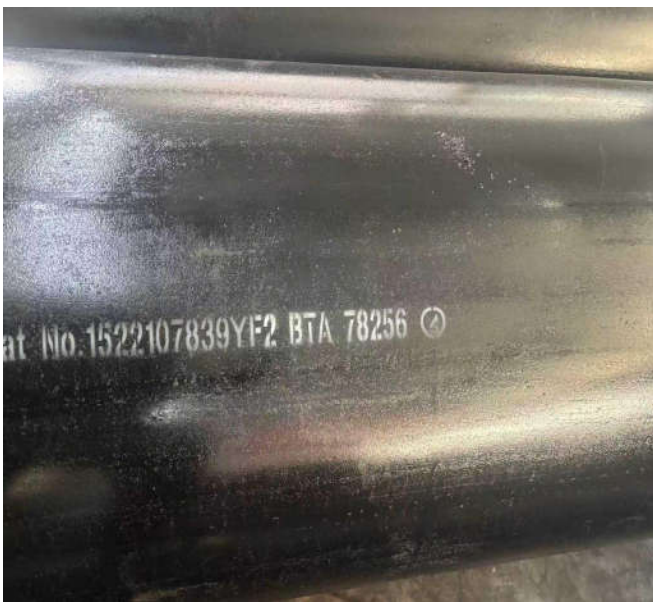
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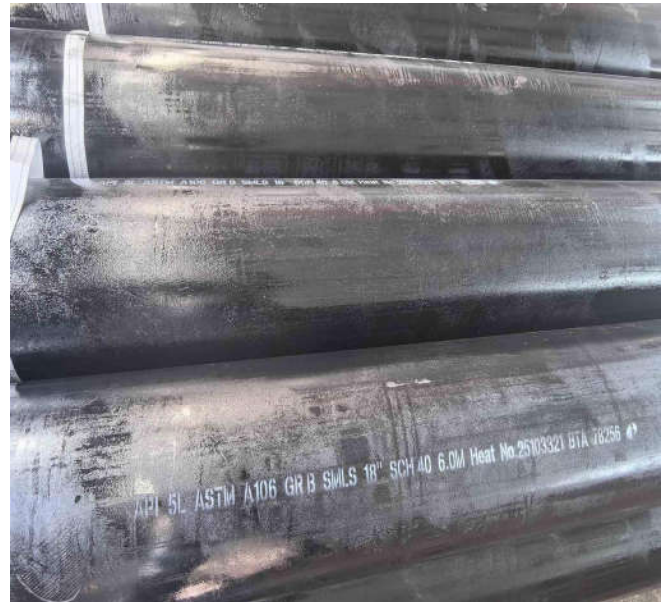
Marking inspection



Marking inspection



Marking inspection



Marking inspection



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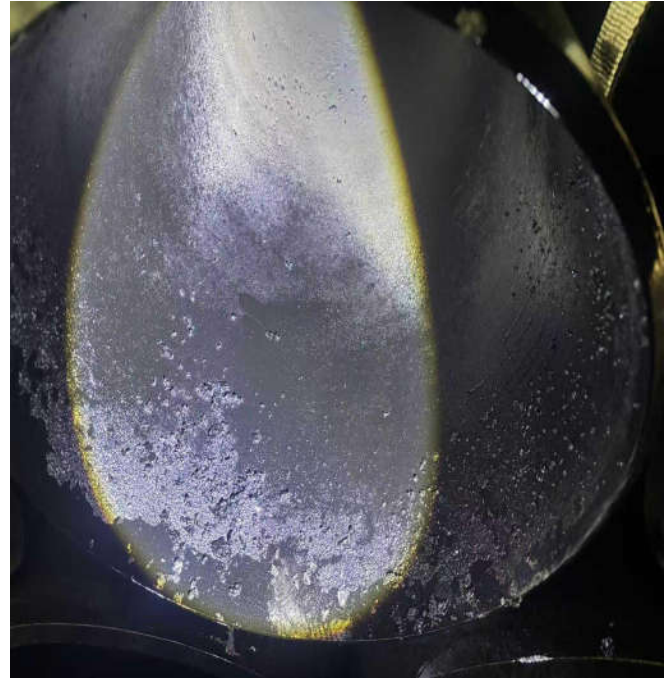
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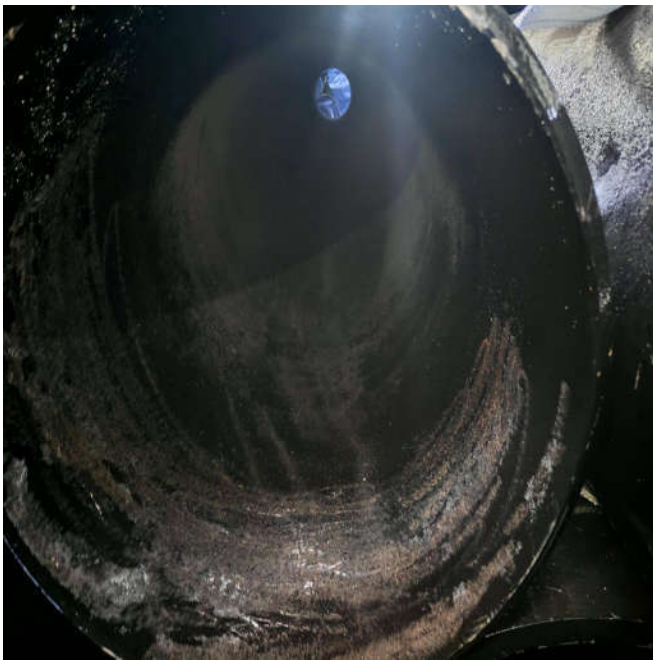
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Some iron filings and debris



Some iron filings and debris

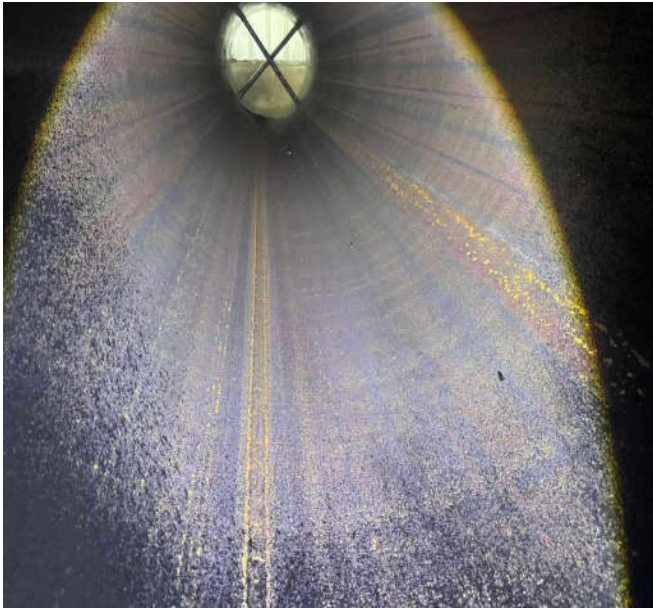


After cleaned up

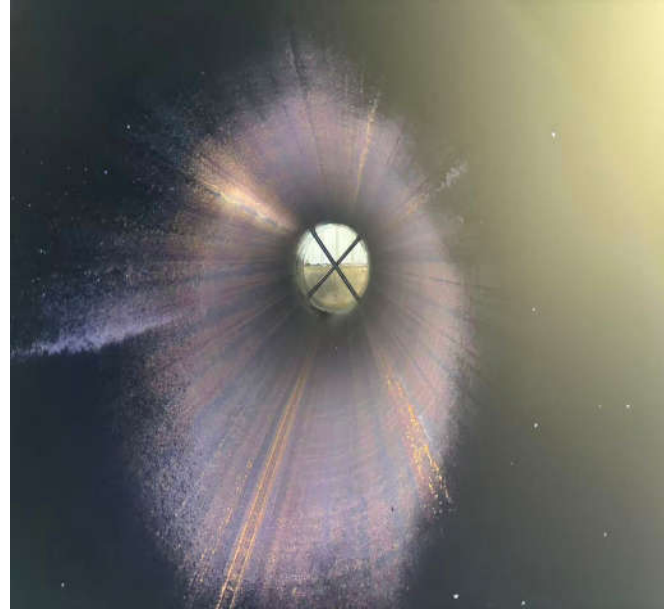


After cleaned up

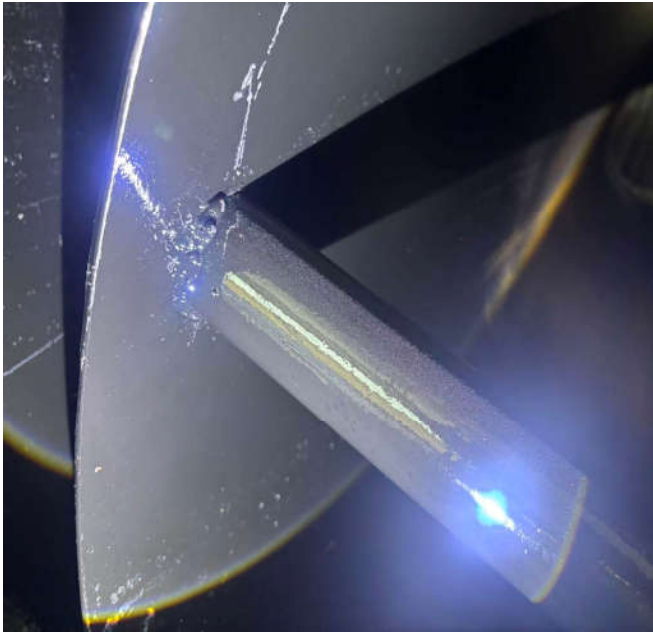
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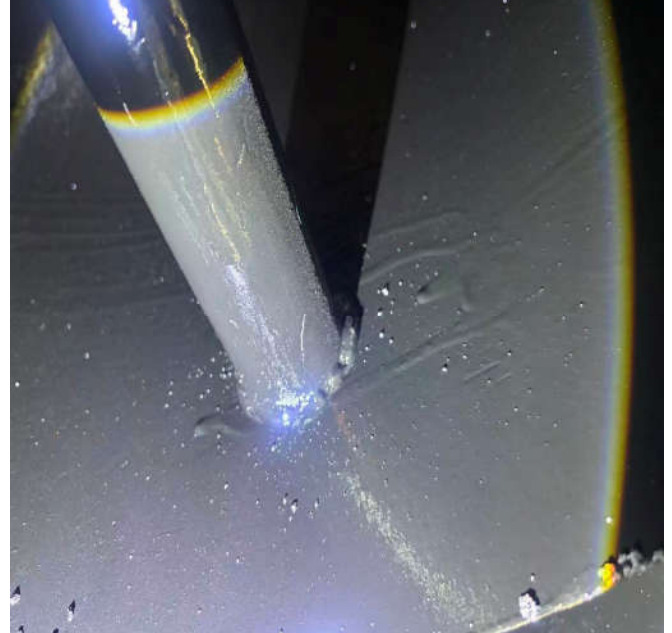
Dimension inspection



Dimension inspection



the iron arms is directly welded to the pipe wall



the iron arms is directly welded to the pipe wall



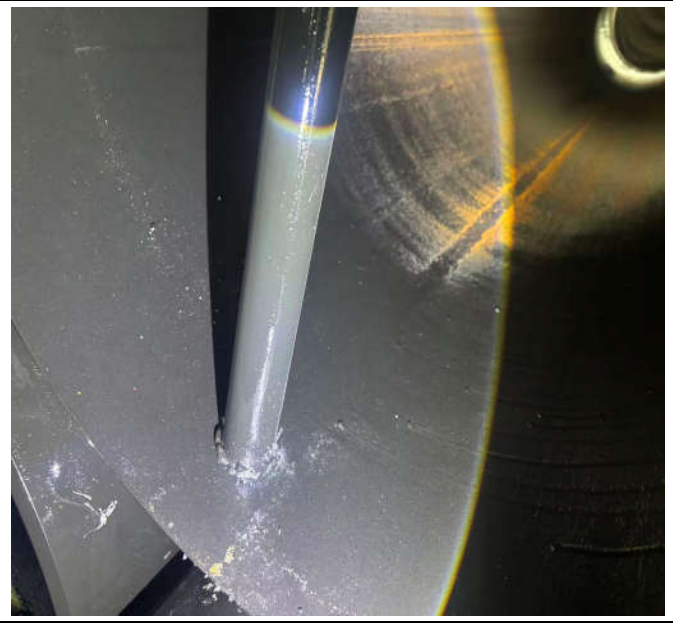
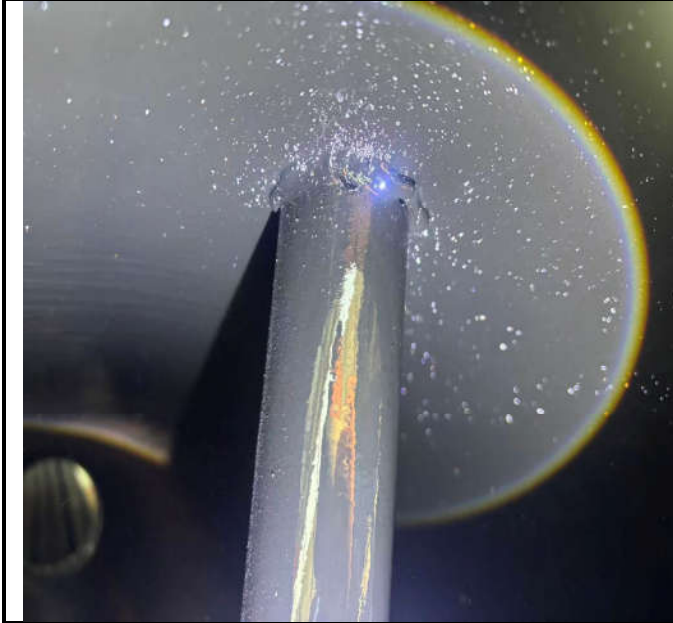
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Dimension inspection



Dimension inspection



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Dimension inspection



Dimension inspection



Dimension inspection



Dimension inspection



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Dimension inspection



Dimension inspection



Dimension inspection



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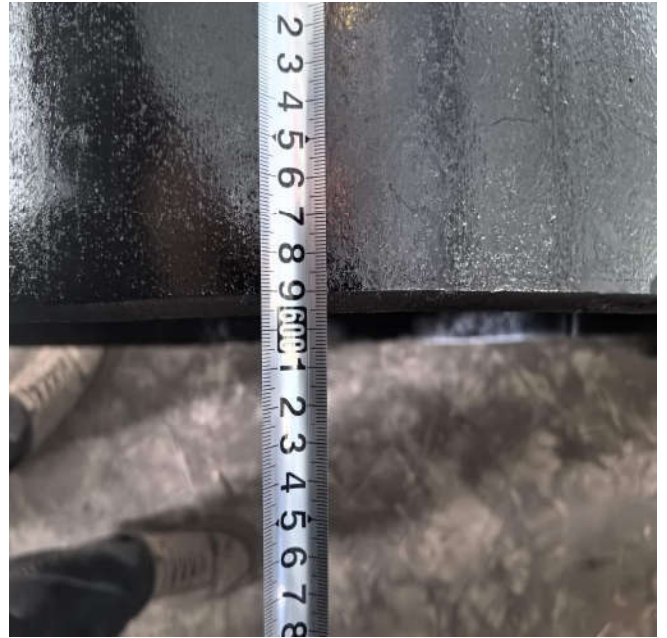
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Dimension inspection



Dimension inspection

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