



CERTIFICATE OF CONFORMITY

CLIENT : CANSKO DUBAI LLC.
JOB # : W/2/1201424
ORDER # : 12075/6442 DATE : 09.10.2012
ITEM# : 18 3/4" X 10M HYDRIL - 5" PIPE RAM BLOCKS
QTY : 01 SET ASSET NO : CAN-10-378

FOLLOWING IS THE SCOPE OF WORK:

1. RECEIVE THE UNIT IN WORK SHOP AND CARRY OUT VISUAL INSPECTION.
2. DISASSEMBLE AND REMOVE SEALS AND GRIT BLAST ON THE EXTERNAL SURFACES OF PIPE BLOCKS COMPONENTS.
3. CARRY OUT MPI & HARDNESS TESTING ON THE PIPE RAM AS PER HYDRIL SPECIFICATIONS.
4. CARRY OUT POSITIVE MATERIAL IDENTIFICATION.
5. CARRY OUT A FULL DIMENSIONAL INSPECTION USING HYDRIL DRAWINGS FOR REFERENCE.
6. CARRY OUT WELD REPAIR ON LIFTING HOLES AS PER HYDRIL APPROVED WPS SPECIFICATION.
7. CARRY OUT PWHT AS PER HYDRIL APPROVED WPS SPECIFICATION.
8. DRESS AND POLISH ON ALL REQUIRED AREAS.
9. APPLY BASE COAT PRIMER.
10. CARRY OUT RE-ASSEMBLY OF THE PIPE RAMS.
11. PROTECT FOR SHIPPING.

FOLLOWING DOCUMENTS ATTACHED :

1. DIMENSIONAL INSPECTION REPORT.
2. NDT EXAMINATION REPORT.
3. PMI REPORT.
4. PWHT REPORTS.

WESCO REPRESENTATIVE

NAME : K. BALASUBRAMANIAN.

POSITION : HSEQ MANAGER

SIGNATURE : _____

DATE : 04.11.2012



QA/QC-AB/6900-13/2012

POSITIVE METAL IDENTIFICATION TEST REPORT

CLIENT: CANSCO DUBAI LLC		WESCO JOB NO: WI/2/1201424		REPORT NO: 1201424-INITIAL	
ITEM DESCRIPTION: RAM BLOCK				I.D NO: SEE COC	
LOCATION: WESCO WORKSHOP				DATE TESTED: 15.09.2012	
CHEMICAL ANALYSIS TEST METHOD: OPTICAL SPECTROMETER			EQUIPMENT BELEC COMPACT PORT Sr No -364		
INSPECTION STAGE:	INITIAL INSPECTION	SURFACE PREPARATION	GRIT BLASTED	PARENT METAL	
ACCEPTABLE Standard : HEMP 11.100 REV A1SOP -073 REV 0					

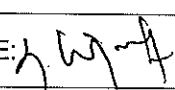
RESULTS

Sr No	PARTS DESCRIPTION	ELEMENTS ANALYSED %											Material Grade
		C	Si	Mn	P	S	Cu	Al	Cr	Mo	Ni	V	
1.	CAN-10-322 (PIPE RAM)	0.239	0.367	0.875	0.000	0.000	0.100	0.026	0.653	0.324	0.551	0.007	ASTM 487 GRADE 4
2.	CAN-10-280 (PIPE RAM)	0.260	0.510	1.131	0.012	0.002	0.090	0.059	0.588	0.281	0.510	0.003	ASTM 487 GRADE 4
3.	CAN-10-378 (PIPE RAM)	0.231	0.442	0.960	0.016	0.003	0.098	0.042	0.784	0.296	0.564	0.002	ASTM 487 GRADE 4
4.	CAN-10-271 (BLIND RAM)	0.223	0.456	1.110	0.011	0.005	0.040	0.025	0.708	0.287	0.547	0.000	ASTM 487 GRADE 4
5.	CAN-10-275 (BLIND RAM)	0.240	0.425	1.100	0.009	0.003	0.041	0.027	0.705	0.290	0.532	0.000	ASTM 487 GRADE 4
6.	CAN-10-269 (SHEAR RAM)	0.257	0.516	1.001	0.008	0.020	0.116	0.067	0.668	0.300	0.567	0.001	ASTM 487 GRADE 4
7.	CAN-10-379 (PIPE RAM)	0.244	0.398	0.643	0.039	0.005	0.092	0.042	0.889	0.309	0.785	0.015	ASTM 487 GRADE 4
8.	CAN-10-268 (SHEAR RAM)	0.257	0.761	0.946	0.034	0.005	0.085	0.053	0.898	0.347	0.733	0.036	ASTM 487 GRADE 4
9.	CAN-10-319 (PIPE RAM)	0.293	0.580	0.904	0.058	0.028	0.118	0.054	0.845	0.339	0.610	0.011	ASTM 487 GRADE 4
10.	CAN-10-320 (BLIND RAM)	0.232	0.545	0.821	0.054	0.030	0.116	0.035	0.749	0.318	0.606	0.011	ASTM 487 GRADE 4

REMARKS:

NICKEL CONTENT ON WELL BORE WETTED SURFACES IS LESS THAN 1.0% : ACCEPTED

OPERATOR NAME : MAHESH

SIGNATURE: 

DATE: 15.09.2012

PREPARED BY:

R.SATHEESH

VERIFIED BY:

K. BALASUBRAMANIAN

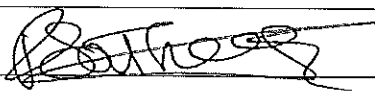
POSITION:

QA/QC INSPECTOR

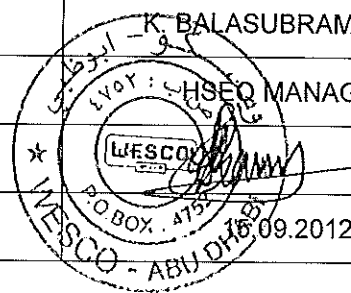
POSITION:

HSEQ MANAGER

SIGNATURE:



SIGNATURE



DATE:

15.09.2012

DATE:

15.09.2012

	 Bin Hamoodah FOR ENGINEERING SERVICES P.O.BOX : 4752, ABU DHABI	HYDRIL BOP RAMS INSPECTION REPORT	 GE Partner GE Oil & Gas
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JOB NO	W/2/1201424	CUSTOMER	CANSCO DUBAI LLC	RAMS TYPE		18 3/4" X 10M HYDRIL RAM					NDE-MPT	HARDNESS HB
WES CO ID NO	PART NO	RAM SIZE	RAM HOLDER WIDTH	RAM BLOCK HEIGHT	SEAL GROOVE DEPTH	LIFTING HOLE	RAM BLOCK MALE GUIDE CONDITION	RAM BLOCK FEMALE GUIDE CONDITION	FRONT SEAL LOCATING AREAS	RAM BLOCK PIPE RADIUS CONDITION		
25	CAN-10-378	5" PIPE RAM	24.000"	9.975"	2.010"	1" U.N.C OVER SIZE. WELD REPAIR	LIGHT DAMAGE. NEED DRESSING	LIGHT DAMAGE. NEED DRESSING	LIGHT DAMAGE. NEED DRESSING	LIGHT DAMAGE. NEED DRESSING	ACCP	214
26	CAN-10-378	5" PIPE RAM	24.006"	9.975"	2.008"	1" U.N.C OVER SIZE. WELD REPAIR	LIGHT DAMAGE. NEED DRESSING	LIGHT DAMAGE. NEED DRESSING	LIGHT DAMAGE. NEED DRESSING	LIGHT DAMAGE. NEED DRESSING	ACCP	223
2 NOS RAM BLOCK LIFT HOLE THREAD DAMAGED- NEED WELD REPAIR												
27	CAN-10-292	13 3/8" PIPE RAM	23.990"	9.968"	2.018"	1" U.N.C DAMAGED. WELD REPAIR	DAMAGED. WELD REPAIR	CORROSION. WELD REPAIR	CORROSION. WELD REPAIR	PITTING. WELD REPAIR	ACCP	214
28	CAN-10-292	13 3/8" PIPE RAM	23.983"	9.966"	2.019"	1" U.N.C DAMAGED. WELD REPAIR	DAMAGED. WELD REPAIR	CORROSION. WELD REPAIR	CORROSION. WELD REPAIR	PITTING. WELD REPAIR	ACCP	214

2 NOS RAM BLOCK FOUND VERY POOR CONDITION. RECOMMEND TO SCRAP

INSPECTED BY: SIMON

VERIFIED BY: SUNNY









5CT - 0610
6A - 0661
7 - 0430
16A - 0157
7-1 - 0430

FORM # 61 REV 2



P.O. BOX : 4752 ABU DHABI

SPECIFICATION & CHART RECEIPT

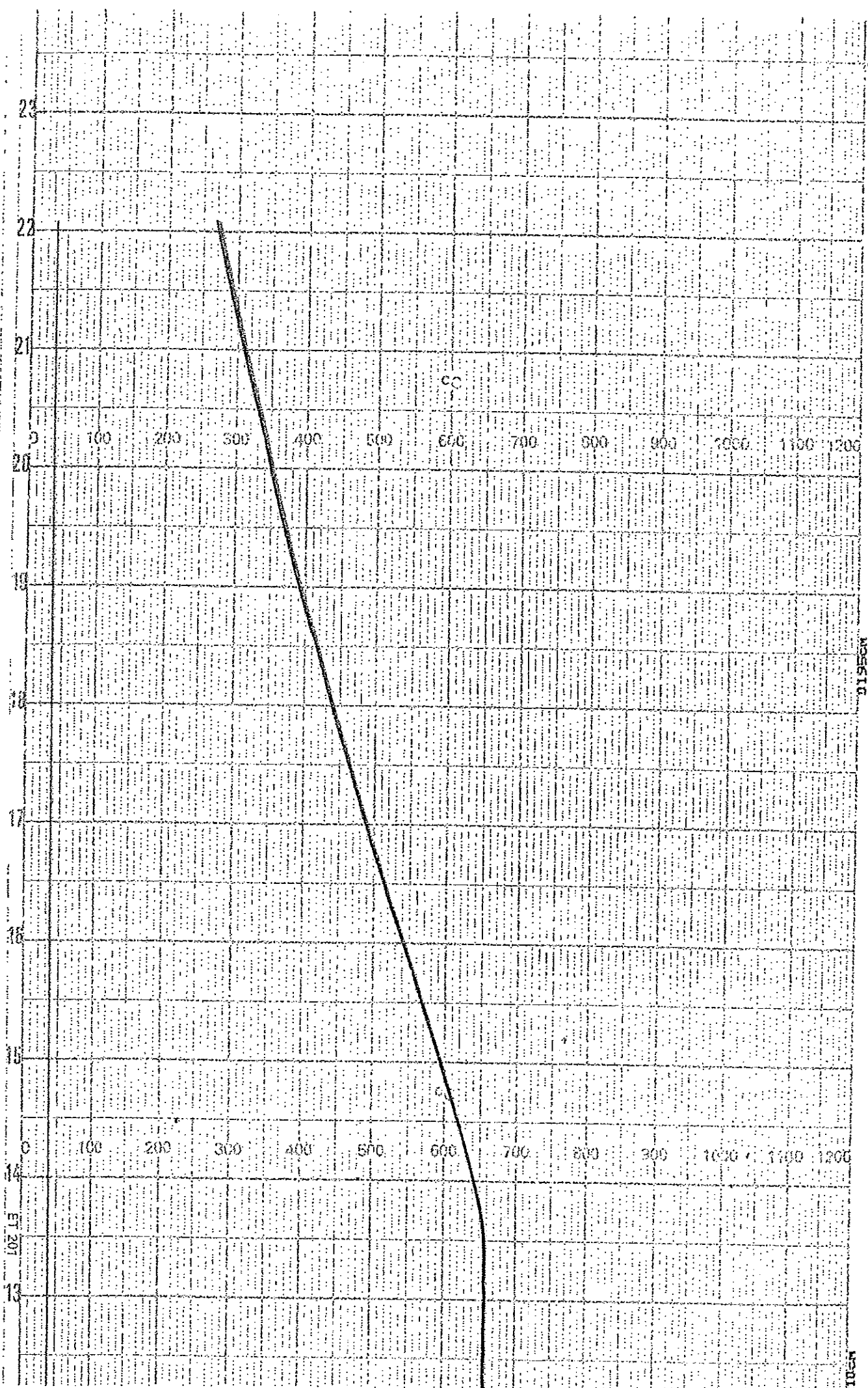
Client : CANSKO DUBAI LLC		Report No: 1201424																			
Site : WORKSHOP		Job No: W/2/1201424	Customer Ord. No: 12075/6442																		
Procedure : HEMPS 8.101 REV .E.		Drawing No. ----	Line No.																		
		Date: 24.09.2012																			
HEAT TREATMENT SPECIFICATION <table border="1"><tr><td>Start Temperature</td><td>300°C</td><td rowspan="4">For WESCO Signature: Name: K. Balasubramanian </td></tr><tr><td>Rate of Rise</td><td>40°C-50°C</td></tr><tr><td>Soak Temperature</td><td>662°C ± 7°C</td></tr><tr><td>Soak Period</td><td>4HRS</td></tr><tr><td>Rate of Cool</td><td>40°C-50°C</td><td rowspan="4">For Client Signature: Name:</td></tr><tr><td>Base Temperature</td><td>300°C</td></tr><tr><td>Insulation Remove</td><td>250°C</td></tr><tr><td>Other Requirements</td><td></td></tr></table>				Start Temperature	300°C	For WESCO Signature: Name: K. Balasubramanian 	Rate of Rise	40°C-50°C	Soak Temperature	662°C ± 7°C	Soak Period	4HRS	Rate of Cool	40°C-50°C	For Client Signature: Name:	Base Temperature	300°C	Insulation Remove	250°C	Other Requirements	
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Base Temperature	300°C																				
Insulation Remove	250°C																				
Other Requirements																					
Date of Work	Chart Rec. No.	Work Details																			
15.09.2012	70/0912/209	CAN-10-322 + CAN-10-280 + CAN-10-271 + CAN-10-275 + CAN-10-378																			
18.09.2012	71/0912/209	CAN-10-269 + CAN-10-379 + CAN-10-268 + CAN-10-319 + CAN-10-320																			
		RAM BLOCKS																			
Attached Sheet(s): YES / NO.																					
For WESCO Signed: Name : MOHAN LAL DATE : 24.09.2012		For WESCO Signed: Name : K. BALASUBRAMANIAN DATE : 24.09.2012 																			



Form 77 Rev. 1

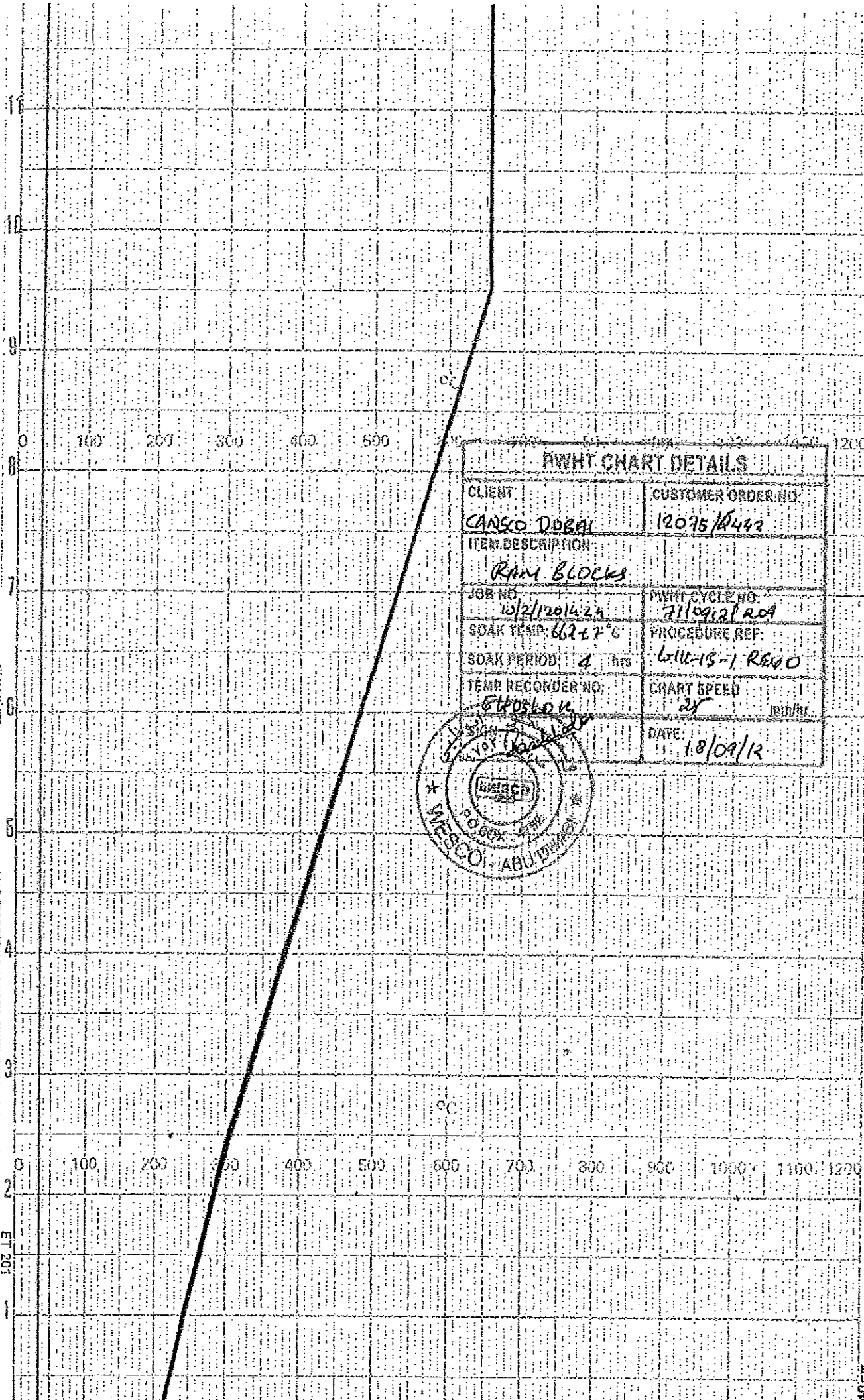


LICENSE
SCT-0610 6A-0661
7-0430 16A-0157, SDP-0149

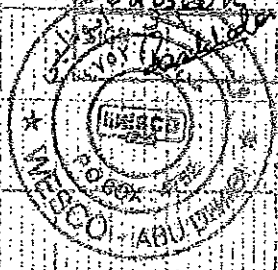


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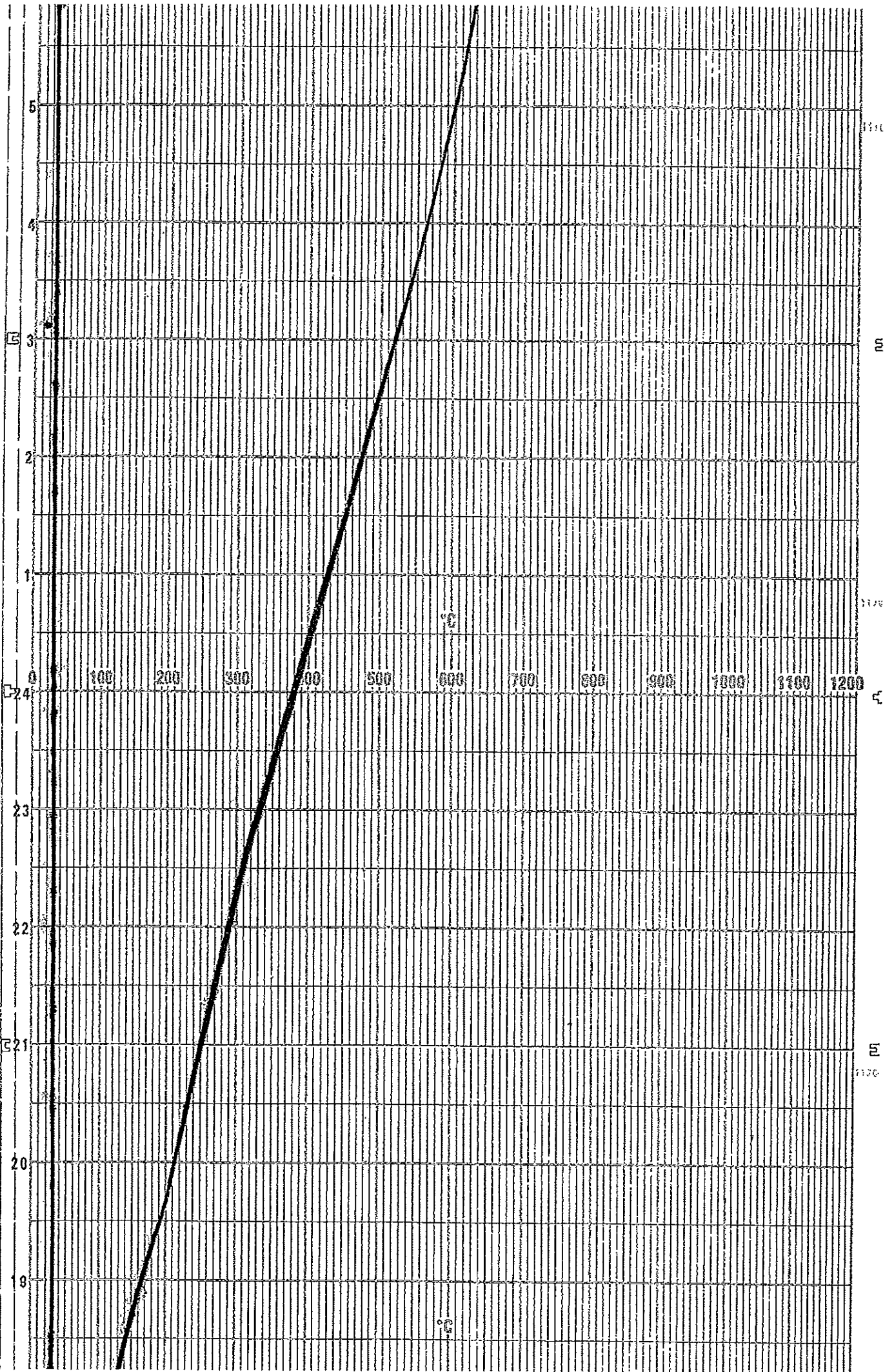


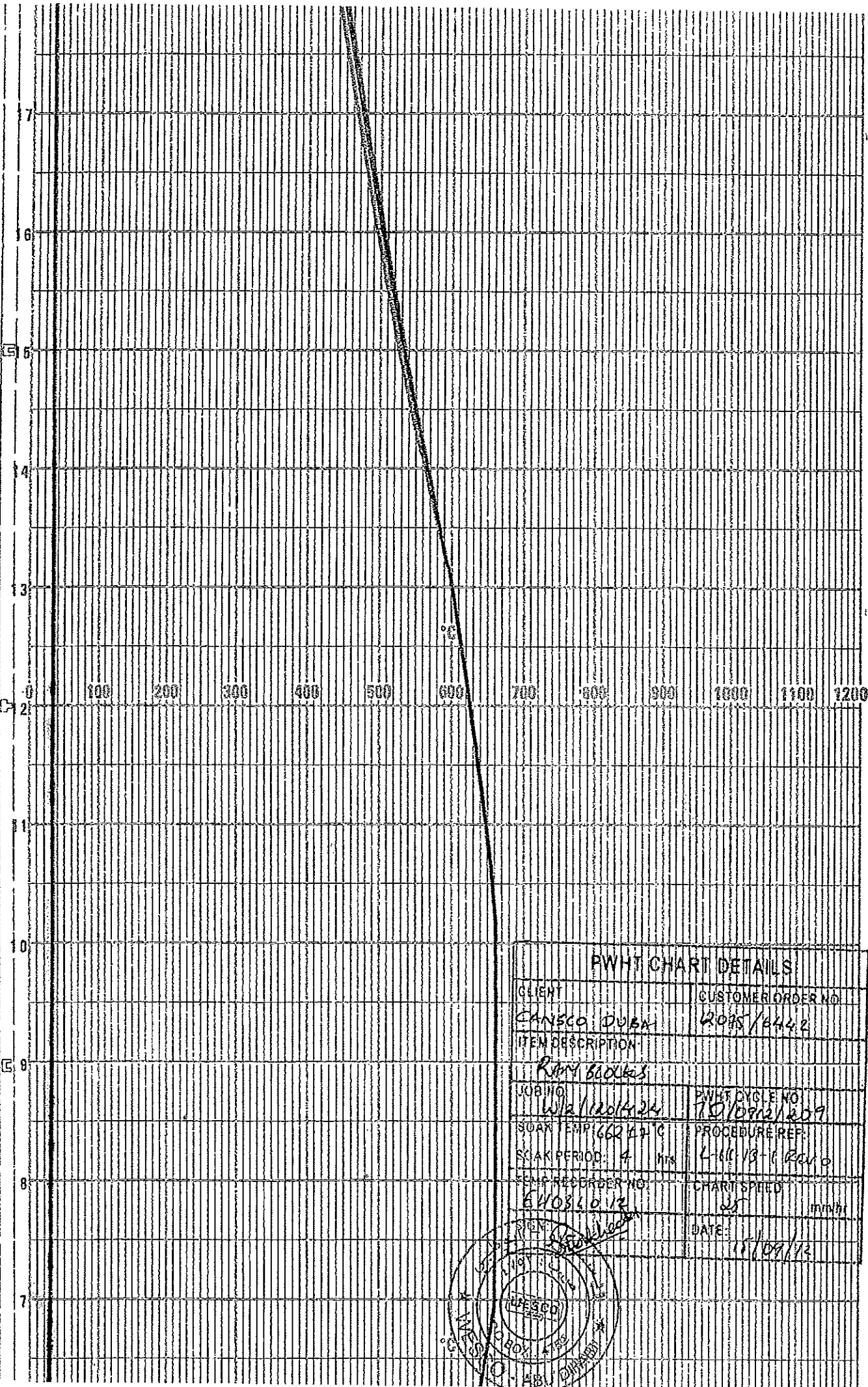
PWHT CHART DETAILS	
CLIENT CANSO DOBAI	CUSTOMER ORDER NO. 12075/10442
ITEM DESCRIPTION RAM BLOCKS	
JOB NO. 02/1201424	PWHT CYCLE NO. 71/09121209
SOAK TEMP: 662 ± 2 °C	PROCEDURE REF. 6-11-15-1 REV 0
SOAK PERIOD: 4 hrs	CHART SPEED 25 mm/hr
TEMP RECORDER NO. 67056016	DATE 18/09/12



022556

24024





PWHT CHART DETAILS

CLIENT	CUSTOMER ORDER NO.
CANSCO DUBAI	2095/6442
ITEM DESCRIPTION	
RAW BLOCKS	
JOB NO.	PWHT CYCLE NO.
W12/12016-24	75/0912/209
SOAK TEMP: 662 ± 1 °C	PROCEDURE REF.
SOAK PERIOD: 4 hrs	L-10.13-1 Rev 0
TEMP RECORDER NO.	CHART SPEED
EH0360.12	25 mm/hr
	DATE: 16/09/13

