

Industry & Facilities Division



BV-FAIRWEATHER

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Interim  
 Final

**INSPECTION REPORT BVFW/SHZ/2016/11-001**

BV Job nr: BVFW/SHZ/2017/11-001

<b>PROJECT:</b> Square tube	<b>Ref:</b> BVFW/SHZ/2017/11-001
<b>BV Client:</b> Changsha Hunan Steel Co.,LTD.	<b>P/o nr:</b> BVFS-SHZ-17/061-PO <i>(client to BV)</i>
<b>Manufacturer:</b> Changsha Hunan Steel Co.,LTD.	<b>P/o nr:</b> / <i>(client to Manufacturer)</i>
<b>Inspection requested by:</b> Changsha Hunan Steel Co.,LTD.	

Item No.	SUPPLY / SUBJECT OF INSPECTION	Purchase Order	QTY (FT)
1	PRODUCTION INFORMATION/ EN10210 S355J2H	HNSCW172109L DX	118

**DOCUMENTS OF REFERENCE** : See continuation sheet for additional documents:  Yes  No

Title	Reference n°	Rev.	Approved by	Date
Hot finished structural hollow section of non-alloy and fine grain steel-part 1: technical delivery condition	EN 10210-1	2006	/	/
Hot finished structural hollow section of non-alloy and fine grain steel-part 2: tolerances, dimensions and sectional properties	EN 10210-2	2006	/	/
Non-destructive testing of steel tubes-part 8: automatic ultrasonic testing of the weld seam of electric welded steel tubes for the detection of longitudinal imperfections	EN 10246-8	2000	/	/
Non-destructive testing of steel tubes-part 9: automatic ultrasonic testing of the weld seam of submerged arc welded steel tubes for the detection of longitudinal and/or transverse imperfection	EN 10246-9	2000	/	/

**INSPECTIONS :** **Results of inspection :**  Satisfactory  Unsatisfactory



Interim  
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**INSPECTION REPORT BVFW/SHZ/2017/11-001**

BV Job nr: BVFW/SHZ/2017/11-001

**Inspection place & Date or Period:**

Place: No. 8299, JINGSHIXI Road,  
 Jinan City, Shandong Province China

Date: Nov. 21<sup>st</sup>~ 26<sup>th</sup>, 2017

**Stage of inspection:**

- Before manufacturing
- During manufacturing
- Final
- Packing

**Kind of inspection:**

- Pre-inspection meeting
  - Witnessing tests
  - Final inspection
  - Document review
  - Expediting & vendor assessment
  - Packing
- (for details see continuation sheet)

**Stamping :**

- No
- 
- 

**Non Conformities Reports (NCR):**

o NCR's issued during reported period :  
 N.A.

o List of outstanding NCR's :  
 N.A.

**Main Conclusions & Remarks:** (for details see continuation sheet)

The inspection results are satisfactory., the production meet the EN10210 S355J2H based on the inspection conducted in UT, visual inspection and dimension check.

**Next visit scheduled:**

**Description of the inspections carried out:**

➤ **Introduction**

Requested by **Changsha Hunan Steel Co.,LTD.** , BV-Fairweather inspector Mr Honggang Ma performed the third party inspection for the Square tubes at **JINAN** shop during Nov. 21<sup>st</sup>~ 26<sup>th</sup>, 2017.

The inspection results are satisfactory.

**BV -FW Scope of work:**

BV-FW performed third party inspection against the provided production list (one piece form every size, 110 pieces with weld, 8 pieces without weld) :

- UT for weld
- Visual inspection
- Dimension check

**Attended persons:**

Mr Honggang Ma                      BV-FW                      Inspector

➤ **Technical information of UT:**

- Acceptance level: EN 10246-8 U5, EN 10246-9 U4
- Probe incidence angle: 60° , 70°
- Surface compensation: 4dB





## INSPECTION REPORT BVFW/SHZ/2017/11-001

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- UT equipment type: PXUT-350+
- UT equipment serial No.: R50450

### ➤ Inspection result:

SR NO.	Specification	Inspection result					UT
		Visual inspection	Dimension check				
			Width (mm)	Width (mm)	WT (mm)	Length (mtr)	
1	50*50*4*1200MM	ACC	50	50	4	≥12	ACC
2	50*50*5*1200MM	ACC	50	50	5	≥12	ACC
3	50*50*6.3*1200MM	ACC	50	50	6	≥12	ACC
4	60*60*3.2*1200MM	ACC	60	60	3	≥12	ACC
5	60*60*4*1200MM	ACC	60	60	4	≥12	ACC
6	60*60*5*1200MM	ACC	60	60	5	≥12	ACC
7	70*70*4*1200MM	ACC	70	70	4	≥12	ACC
8	70*70*5*1200MM	ACC	70	70	5	≥12	ACC
9	70*70*6.3*1200MM	ACC	70	70	6	≥12	ACC
10	70*70*8*1200MM	ACC	70	70	8	≥12	Seamless
11	80*80*4*1200MM	ACC	80	80	4	≥12	ACC
12	80*80*5*1200MM	ACC	80	80	5	≥12	ACC
13	80*80*6.3*1200MM	ACC	80	80	6	≥12	ACC
14	80*80*12.5*1200MM	ACC	80	80	12	≥12	Seamless
15	90*90*4*1200MM	ACC	90	90	4	≥12	ACC
16	90*90*6.3*1200MM	ACC	90	90	6	≥12	ACC
17	100*100*4*1200MM	ACC	101	100	4	≥12	ACC
18	100*100*5*1200MM	ACC	100	100	5	≥12	ACC
19	100*100*6.3*1200MM	ACC	100	100	6	≥12	ACC
20	100*100*8*1200MM	ACC	100	100	8	≥12	ACC
21	100*100*10*1200MM	ACC	100	100	10	≥12	ACC
22	120*120*4*1200MM	ACC	120	120	4	≥12	ACC
23	120*120*5*1200MM	ACC	120	120	5	≥12	ACC
24	120*120*6.3*1200MM	ACC	121	120	6	≥12	ACC
25	120*120*8*1200MM	ACC	120	120	8	≥12	ACC
26	140*140*6.3*1200MM	ACC	140	141	6	≥12	ACC
27	140*140*10*1200MM	ACC	140	140	10	≥12	ACC
28	150*150*5*1200MM	ACC	150	151	5	≥12	ACC
29	150*150*6.3*1200MM	ACC	151	150	6	≥12	ACC
30	150*150*8*1200MM	ACC	150	150	8	≥12	ACC
31	150*150*10*1200MM	ACC	150	150	10	≥12	ACC
32	160*160*4*1200MM	ACC	161	161	4	≥12	ACC





## INSPECTION REPORT BVFW/SHZ/2017/11-001

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33	160*160*5*12000MM	ACC	160	160	5	≥12	ACC
34	160*160*6.3*12000MM	ACC	160	161	6	≥12	ACC
35	160*160*8*12000MM	ACC	160	160	8	≥12	ACC
36	160*160*12.5*12000MM	ACC	160	160	12	≥12	ACC
37	180*180*6.3*12000MM	ACC	180	180	6	≥12	ACC
38	180*180*8*12000MM	ACC	180	181	8	≥12	ACC
39	200*200*6.3*12000MM	ACC	201	200	6	≥12	ACC
40	200*200*8*12000MM	ACC	200	200	8	≥12	ACC
41	200*200*10*12000MM	ACC	200	200	10	≥12	ACC
42	200*200*16*12000MM	ACC	200	200	16	≥12	ACC
43	220*220*6.3*12000MM	ACC	221	221	6	≥12	ACC
44	220*220*10*12000MM	ACC	220	220	10	≥12	ACC
45	220*220*12.5*12000MM	ACC	220	220	12	≥12	ACC
46	250*250*6.3*12000MM	ACC	250	250	6	≥12	ACC
47	250*250*16*12000MM	ACC	250	251	16	≥12	ACC
48	260*260*16*12000MM	ACC	260	260	16	≥12	Seamless
49	300*300*12.5*12000MM	ACC	300	301	12	≥12	ACC
50	400*400*8*12000MM	ACC	402	401	8	≥12	ACC
51	400*400*10*12000MM	ACC	400	401	10	≥12	ACC
52	400*400*20*12000MM	ACC	401	401	20	≥12	ACC
53	100*50*6.3*12000MM	ACC	100	50	6	≥12	ACC
54	100*50*8*12000MM	ACC	100	50	8	≥12	Seamless
55	100*80*5*12000MM	ACC	100	80	5	≥12	ACC
56	120*60*6.3*12000MM	ACC	120	60	6	≥12	ACC
57	120*60*8*12000MM	ACC	120	60	8	≥12	Seamless
58	120*60*10*12000MM	ACC	120	60	10	≥12	Seamless
59	140*70*5*12000MM	ACC	140	70	5	≥12	ACC
60	140*70*6.3*12000MM	ACC	140	70	6	≥12	ACC
61	140*70*8*12000MM	ACC	140	70	8	≥12	ACC
62	140*80*8*12000MM	ACC	140	80	8	≥12	ACC
63	140*80*10*12000MM	ACC	140	80	10	≥12	Seamless
64	150*100*5*12000MM	ACC	150	101	5	≥12	ACC
65	150*100*6.3*12000MM	ACC	150	101	6	≥12	ACC
66	150*100*8*12000MM	ACC	150	100	8	≥12	ACC
67	150*100*10*12000MM	ACC	150	100	10	≥12	ACC
68	150*100*12.5*12000MM	ACC	150	100	12	≥12	ACC
69	160*80*5*12000MM	ACC	160	80	5	≥12	ACC
70	160*80*6.3*12000MM	ACC	160	80	6	≥12	ACC
71	160*80*8*12000MM	ACC	161	80	8	≥12	ACC
72	160*80*10*12000MM	ACC	160	80	10	≥12	ACC





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73	160*80*12.5*12000MM	ACC	160	80	12	≥12	ACC
74	160*90*5*12000MM	ACC	160	90	5	≥12	ACC
75	160*90*6.3*12000MM	ACC	160	90	6	≥12	ACC
76	160*90*8*12000MM	ACC	160	90	8	≥12	ACC
77	160*90*10*12000MM	ACC	160	90	10	≥12	ACC
78	180*100*5*12000MM	ACC	180	101	5	≥12	ACC
79	180*100*6.3*12000MM	ACC	180	100	6	≥12	ACC
80	180*100*8*12000MM	ACC	180	100	8	≥12	ACC
81	180*100*10*12000MM	ACC	180	100	10	≥12	ACC
82	180*100*16*12000MM	ACC	180	100	16	≥12	Seamless
83	200*100*5*12000MM	ACC	201	101	5	≥12	ACC
84	200*100*6.3*12000MM	ACC	200	100	6	≥12	ACC
85	200*120*6.3*12000MM	ACC	200	121	6	≥12	ACC
86	200*120*8*12000MM	ACC	200	120	8	≥12	ACC
87	200*120*10*12000MM	ACC	200	120	10	≥12	ACC
88	200*120*12.5*12000MM	ACC	200	120	12	≥12	ACC
89	220*120*8*12000MM	ACC	220	120	8	≥12	ACC
90	220*120*10*12000MM	ACC	220	120	10	≥12	ACC
91	220*120*12.5*12000MM	ACC	220	120	12	≥12	ACC
92	250*100*8*12000MM	ACC	250	100	8	≥12	ACC
93	250*150*6.3*12000MM	ACC	251	150	6	≥12	ACC
94	250*150*8*12000MM	ACC	250	150	8	≥12	ACC
95	250*150*10*12000MM	ACC	250	150	10	≥12	ACC
96	250*150*12.5*12000MM	ACC	251	150	12	≥12	ACC
97	250*150*16*12000MM	ACC	250	150	16	≥12	ACC
98	260*140*8*12000MM	ACC	260	141	8	≥12	ACC
99	260*140*10*12000MM	ACC	260	140	10	≥12	ACC
100	260*180*12.5*12000MM	ACC	260	180	12	≥12	ACC
101	300*100*6.3*12000MM	ACC	300	101	6	≥12	ACC
102	300*100*8*12000MM	ACC	300	101	8	≥12	ACC
103	300*100*10*12000MM	ACC	300	101	10	≥12	ACC
104	300*200*8*12000MM	ACC	300	200	8	≥12	ACC
105	300*200*16*12000MM	ACC	300	200	16	≥12	ACC
106	400*200*8*12000MM	ACC	400	200	8	≥12	ACC
107	400*200*10*12000MM	ACC	400	200	10	≥12	ACC
108	400*300*8*12000MM	ACC	401	302	8	≥12	ACC
109	400*300*10*12000MM	ACC	400	300	10	≥12	ACC
110	400*300*12.5*12000MM	ACC	400	300	12	≥12	ACC
111	450*250*8*12000MM	ACC	450	250	8	≥12	ACC
112	450*250*10*12000MM	ACC	450	250	10	≥12	ACC
113	450*250*12.5*12000MM	ACC	451	250	12	≥12	ACC





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114	500*300*8*12000MM	ACC	501	302	8	≥12	ACC
115	500*300*10*12000MM	ACC	500	300	10	≥12	ACC
116	500*300*12.5*12000MM	ACC	502	300	12	≥12	ACC
117	500*300*16*12000MM	ACC	501	301	16	≥12	ACC
118	500*300*20*12000MM	ACC	501	300	20	≥12	ACC

**Notes:** Acc—Accept

➤ **Details of inspection activities carried out with respect to scope of work.**

1. Visual inspection

One uneven outer weld seam had been removed by grinding to within the tolerance



Some Inner weld seam had been remained and some inner weld seam had been removed

