



CERTIFICATE OF CONFORMITY

CLIENT : **CANSCO DUBAI LLC.**
JOB # : **W/2/1201170**
ORDER # : **11913/6442** DATE : **03.09.2012**
ITEM# : **11" X 5M SHAFFER- 4-1/2" PIPE RAM BLOCKS**
Model# : **LWS** Type # : **T70**
QTY : **01 SET** ASSET NO : **CAN-10-367**


FOLLOWING IS THE SCOPE OF WORK:

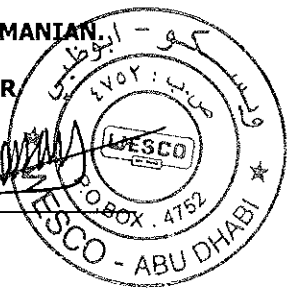
1. RECEIVE THE UNIT IN WORK SHOP AND CARRY OUT VISUAL INSPECTION.
2. DISASSEMBLE AND REMOVE SEALS AND GRIT BLAST ON THE EXTERNAL SURFACES OF PIPE RAM BLOCKS COMPONENTS.
3. CARRY OUT MPI & HARDNESS TESTING ON THE PIPE RAM AS PER SHAFFER SPECIFICATIONS.
4. CARRY OUT A FULL DIMENSIONAL INSPECTION USING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

FOLLOWING DOCUMENTS ATTACHED :

1. NDT EXAMINATION REPORT.
2. PWHT REPORTS.
3. PMI REPORTS

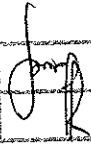
WESCO REPRESENTATIVE

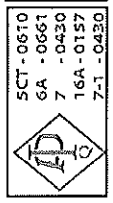
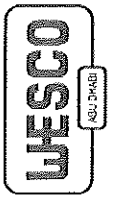
NAME : **K. BALASUBRAMANIAN.**
POSITION : **HSEQ MANAGER**
SIGNATURE : 
DATE : **30.09.2012**



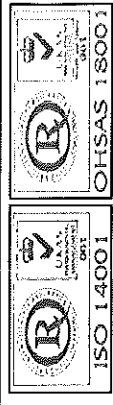
QA/QC-RS/6815-25/2012

CERTIFICATION

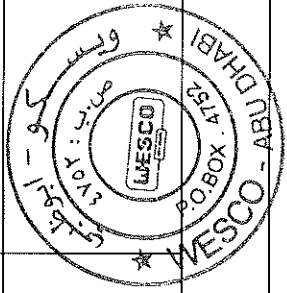
Date Received	04.10.2012	
Logged	Yes / No	
Electronically Filed	Yes / No	
Linked to Aspire	Yes / No	
Cert Reviewed & Approved - 1	<input checked="" type="radio"/> Yes / No	
Cert Reviewed & Approved - 2	<input checked="" type="radio"/> Yes / No	
If rejected, give reason :		



Shaffer Pipe Ram Block Inspection Report



Wesco Ref: W/2/1201170		CUSTOMER		RAM TYPE & SIZE								
		CANSCO DUBAI LLC		11" 5M SHAFFER								
Customer ID#	Shaffer Serial#	Pipe ram size	Ram Block Height (1)	Pipe radius (thru Bore) (2)	Rubber seal groove face (3)	Pipe Support Area (4)	Lifting holes (5)	Retract Screw location hole (6)	Ram Block male/female locating guide (7)	Ram Holder Height (8)	Ram Holder Side pads (9)	Ram shaft slot (10)
CAN-10-367	P/NO 142133 T-70	4 1/2" PIPE	4.483" LIGHT DAMAGED NEED DRESSING	IMPACT DAMAGED LOCAL REPAIR	LIGHT DAMAGED DRESSING	NO S/T NEED DRESSING	5/8" U.N.C RE-TAP	1 3/8" U.N.S RE-TAP	LIGHT DAMAGED NEED DRESSING		NOT RECEIVED	
CAN-10-367	P/NO 142133 T-70	4 1/2" PIPE	4.485" LIGHT DAMAGED NEED DRESSING	IMPACT DAMAGED LOCAL REPAIR	LIGHT DAMAGED DRESSING	NO S/T NEED DRESSING	5/8" U.N.C RE-TAP	1 3/8" U.N.S RE-TAP	LIGHT DAMAGED NEED DRESSING		NOT RECEIVED	
Hardness results		Block 1	223	NDT Results		Block 1	Free From Cracks					
Hardness results		Block 2	223	NDT Results		Block 2	Free From Cracks					
COMMENTS:												
2 NOS RAM BLOCK PIPE RADIOUS LIGHT DAMAGED -NEED LOCAL REPAIR AND DRESS POLISH												
CAN-10-286	N/A	C.S.O BLIND RAM	4.452" UNDER SIZE WELD REPAIR	-	HEAVY CORROSION WELD REPAIR	-	5/8" U.N.C DAMAGE D WELD REPAIR	1 1/8" U.N.S DAMAGED WELD REPAIR				
CAN-10-286	N/A	C.S.O BLIND RAM	4.452" UNDER SIZE WELD REPAIR	-	HEAVY CORROSION WELD REPAIR	-	5/8" U.N.C DAMAGE D WELD REPAIR	1 1/8" U.N.S DAMAGED WELD REPAIR				
Hardness results		Block 1	206	NDT Results		Block 1	Free From Cracks					
Hardness results		Block 2	198	NDT Results		Block 2	Free From Cracks					
COMMENTS: 2 NOS RAM BLOCKS FOUND VERY POOR CONDITION -BEYOND REPAIR RECOMMEND TO BE SCRAP												



Inspected By: SIMON Date: 21.07.2012 Checked By: SUNNY Date: 22.07.2012



POSITIVE METAL IDENTIFICATION TEST REPORT



CLIENT: CANSCO DUBAI LLC

WESCO JOB NO:
W/2/1201170REPORT NO:
1201170-INITIAL

ITEM DESCRIPTION: SHAFFER RAM BLOCK

I.D NO: SEE COC

LOCATION: WESCO WORKSHOP

DATE TESTED:
11.07.2012

CHEMICAL ANALYSIS TEST METHOD: OPTICAL SPECTROMETER

EQUIPMENT BELEC COMPACT PORT Sr No -
435

INSPECTION STAGE:

INITIAL
INSPECTIONSURFACE
PREPARATION

GRIT BLASTED

PARENT METAL

REMARKS:

RESULTS

Sr No	PARTS DESCRIPTION	ELEMENTS ANALYSED %											Material Grade
		C	Si	Mn	P	S	Cu	Al	Cr	Mo	Ni	V	
1.	Ram Block (CAN-10-376)	0.357	0.296	0.550	0.014	0.027	0.128	0.005	1.055	0.219	0.128	0.040	AISI 4130
2.	Ram Block (CAN-10-285)	0.309	0.246	0.493	0.010	0.006	0.027	0.005	0.892	0.156	0.160	0.012	AISI 4130
3.	Ram Block (CAN-10-367)	0.310	0.250	0.519	0.012	0.010	0.029	0.003	0.936	0.169	0.165	0.013	AISI 4130
4.	Ram Block (CAN-10-377)	0.316	0.269	0.524	0.014	0.005	0.025	0.005	0.935	0.174	0.161	0.016	AISI 4130

REMARKS:

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

OPERATOR NAME : MAHESH

SIGNATURE: 

DATE: 11.07.2012

PREPARED BY:

R.SATHEESH

VERIFIED BY:

K. BALASUBRAMANIAN

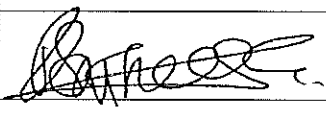
POSITION:

QA/QC INSPECTOR

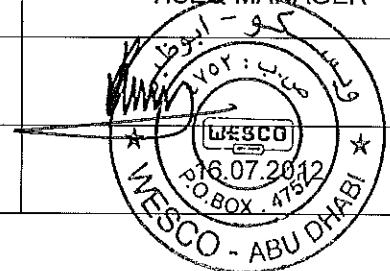
POSITION:

HSEQ-MANAGER

SIGNATURE:



SIGNATURE



DATE:

16.07.2012

DATE:



FORM # 60 REV 1



LICENSE
SCT-0610 6A-0661
7-1 0430 16A-0157
SDP-0149



P.O. BOX : 4752 ABU DHABI

SPECIFICATION & CHART RECEIPT

Client : CANSCO DUBAI LLC		Report No: 1201170
Site : WESCO Workshop	Job No: W/2/1201170	Customer Ord. No: 11913/6442
Procedure: L-III-13-1 REV.0, WS/SAW/039 REV 0	Drawing No: N/A	Line No :
		Date: 02.09.2012

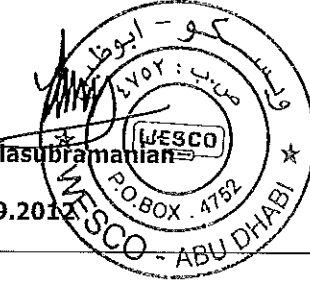
HEAT TREATMENT SPECIFICATION		
Start Temperature	300°C	For WESCO Signature Name: K. Balasubramanian
Rate Of Rise	40°C-50°C	
Soak Temperature	625°C TO 642°C	
Soak Period	4Hrs	
Rate Of Cool	40°C-50°C	For Client Signature Name:
Base Temperature	300°C	
Insulation Remove	250°C	
Other Requirements		



Date Of Work	Chart Rec. No.	Work Details
27.08.2012	62/0812/209-1	RAM BLOCK (CAN-10-377,CAN-10-376,CAN-10-367, CAN-10-285)

Attached PWHT Sheet(s): **Yes / No.**

For WESCO Signed Name : Mohan Lal Date : 02.09.2012	For WESCO Signed Name : K. Balasubramanian Date : 02.09.2012
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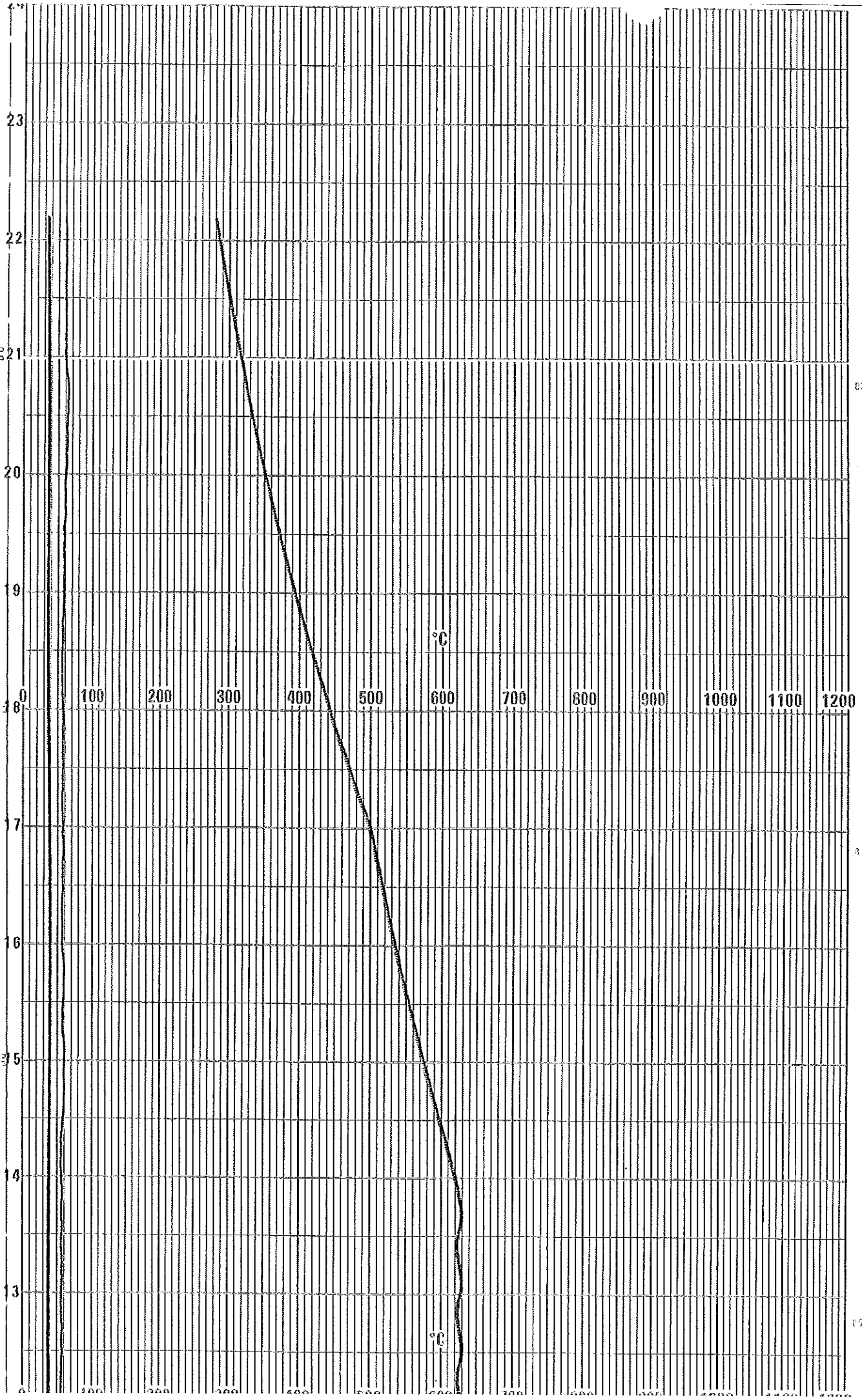
Form 77 Rev. 1



LICENSE
SCT-0610 6A-0661
7-1-0430 16A-0157,
SDP-0149

CHART No. FT-201

E21



2

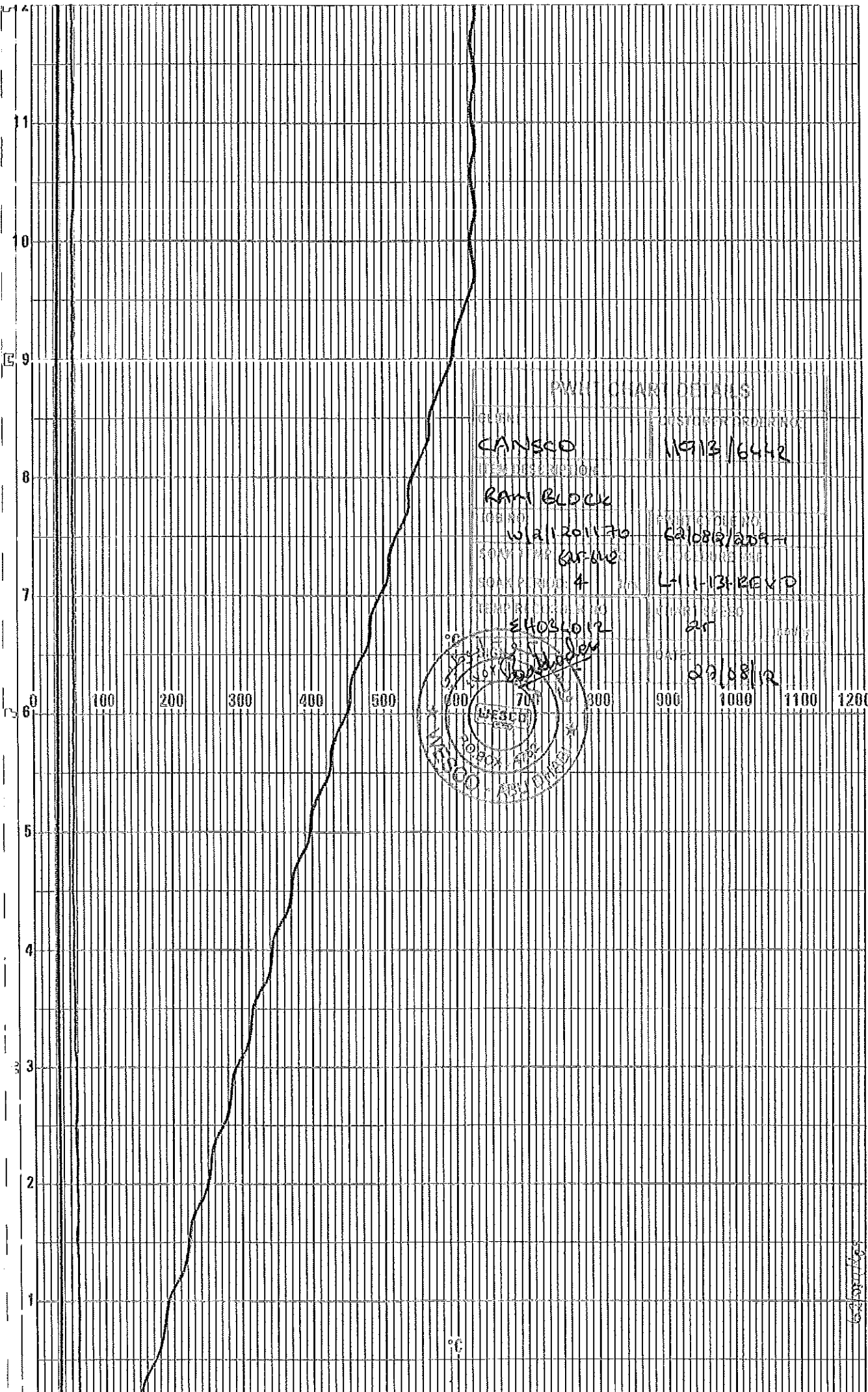
5

230°C

310°C

5

250°C



2
9
6
6
5
4
3
2
1

100 200 300 400 500 600 700 800 900 1000 1100 1200

370ca
240ca
240ca

