



Interim  
 Final

**INSPECTION REPORT N° ECL/BV KOL/IR/014**

**BV Job nr: IND.K.4.11.0024 R1**

<b>PROJECT:</b> -----	<b>Accepted Offer Dt. : 25.03.11 thru mail</b>
<b>BV Client: M/s Electrosteel Castings Ltd.</b>	<b>P/o nr:</b>
<b>Manufacturer / Supplier : M/s Electrosteel Castings Ltd.</b>	<b>Order Ref. : Nil</b>
<b>Inspection requested by: M/s Electrosteel Castings Ltd.</b>	

SUPPLY / SUBJECT OF INSPECTION	ITEM / TAG Nr	QTY
PERFORMANCE TEST OF BOLTED RESTRAINED FLEXIBLE JOINT (Ve) DN 200 PRESSURE CLASS 40 (PFA 40 bar)	Sample Id No. 200.FLT.RJT.1	.....

<b>DOCUMENTS OF REFERENCE</b> : See continuation sheet for additional documents: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No				
Title	Reference n°	Rev.	Approved by	Date
Standards	EN 545 : 2010, ISO 2531 : 2009, ISO 10804 : 2010	-	-	-

<p><b>INSPECTIONS :</b></p> <p><b><u>Inspection place &amp; Date or Period:</u></b>                  Electrosteel Castings Ltd.                  30 B T Road, PO.Sukhchar,                  Pin 700116, Kolkata, India.</p> <p><b><u>Stage of inspection :</u></b></p> <p><input type="checkbox"/> Before manufacturing  <input type="checkbox"/> During manufacturing  <input type="checkbox"/> Final  <input type="checkbox"/> Packing</p> <p><b><u>Type of inspection:</u></b></p> <p><input type="checkbox"/> Pre-inspection meeting  <input type="checkbox"/> Document and QC record review  <input type="checkbox"/> Visual examination, checks  <input checked="" type="checkbox"/> Witnessing tests  <input type="checkbox"/> Manufacturing progress status  <input type="checkbox"/> Vendor assessment  <input type="checkbox"/> Final inspection  <input type="checkbox"/> Packing                  (for details see continuation sheet)</p> <p><b><u>Stamping :</u></b>  <input type="checkbox"/> No    <input checked="" type="checkbox"/>     <input type="checkbox"/> </p>	<p><b><u>Results of inspection :</u></b> <input checked="" type="checkbox"/> Satisfactory    <input type="checkbox"/> Unsatisfactory</p> <p><b><u>Non Conformities Reports (NCR):</u></b>                  o NCR's issued during reported period : Nil</p> <p>o List of outstanding NCR's : NA</p> <p><b><u>Main Conclusions &amp; Remarks:</u></b> (for details see continuation sheet)                  Nil.</p> <p><b><u>Next visit scheduled:</u></b> As required</p>
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(continued)

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Supply/Subject of inspection:-

The Performance Tests of Socket and Spigot Bolted Restrained Push On Joint manufactured by **ELECTROSTEEL CASTINGS LIMITED, INDIA** have been carried out accordance to **EN 545:2010, ISO 2531:2009 and ISO 10804:2010** and have given the following result.

ASSEMBLY	TEST	Pressure	Duration	Condition	Result
<b>BOLTED RESTRAINED FLEXIBLE JOINT (Ve) DN 200 PRESSURE CLASS 40 (PFA 40 bar)</b>	Positive internal hydrostatic pressure as per Clause 7.2.2 of EN 545:2010 and Clause 7.1 of ISO 2531:2009	<b>65.0 Bar</b>	<b>2 Hrs</b>	<ul style="list-style-type: none"> <li>• With Shear Load</li> <li>• Maximum Annular Gap</li> <li>• Minimum Pipe Thickness</li> </ul>	<b>Conform</b>
	Positive internal hydrostatic pressure as per Clause 7.2.2 of EN 545:2010 and Clause 7.1 of ISO 2531:2009	<b>65.0 Bar</b>	<b>2 Hrs</b>	<ul style="list-style-type: none"> <li>• Deflected</li> <li>• Maximum Annular Gap</li> <li>• Minimum Pipe Thickness</li> </ul>	<b>Conform</b>
	Cyclic Internal Hydraulic Pressure as per Clause 7.2.5 of EN 545:2010	<b>Cyclic between 43.0 bar to 48.0 bar</b>	<b>24000 Cycles</b>	<ul style="list-style-type: none"> <li>• With Shear Load</li> <li>• Maximum Annular Gap</li> <li>• Minimum Pipe Thickness</li> </ul>	<b>Conform</b>

Note: The Performance Test of DN 200 is representative of ELECTROSTEEL DUCTILE IRON pipe range of DN80-DN 300 with the same Joint.

**ANNEXES**  Yes (Total number of pages: ..... )  No

<b>Inspected by:</b> Name: Indrajit Das  Report issued by: Indrajit Das  Date of issue: 01.03.2013  <b>Inspection centre:</b> BV Kolkata		<b>Checked by:</b> Name: Indrajit Das
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 Distribution:  ECL  BV Kolkata