



Interim
 Final

INSPECTION REPORT N° ECL/BV KOL/IR/015

BV Job nr: IND.K.4.11.0024 R1

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

SUPPLY / SUBJECT OF INSPECTION	ITEM / TAG Nr	QTY
PERFORMANCE TEST OF BOLTED RESTRAINED FLEXIBLE JOINT (Ve) DN 400 PRESSURE CLASS 30 (PFA 30 bar)	Sample Id No. 400.FLT.RJT.1

DOCUMENTS OF REFERENCE : 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>INSPECTIONS :</p> <p><u>Inspection place & Date or Period:</u> Electrosteel Castings Ltd. 30 B T Road, PO.Sukhchar, Pin 700116, Kolkata, India.</p> <p><u>Stage of inspection :</u></p> <p><input type="checkbox"/> Before manufacturing <input type="checkbox"/> During manufacturing <input type="checkbox"/> Final <input type="checkbox"/> Packing</p> <p><u>Type of inspection:</u></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><u>Stamping :</u> <input type="checkbox"/> No <input checked="" type="checkbox"/> <input type="checkbox"/> </p>	<p><u>Results of inspection :</u> <input checked="" type="checkbox"/> Satisfactory <input type="checkbox"/> Unsatisfactory</p> <p><u>Non Conformities Reports (NCR):</u> o NCR's issued during reported period : Nil</p> <p>o List of outstanding NCR's : NA</p> <p><u>Main Conclusions & Remarks:</u> (for details see continuation sheet) Nil.</p> <p><u>Next visit scheduled:</u> As required</p>
--	---


 Interim
 Final

INSPECTION REPORT N° ECL/BV KOL/IR/015

(continued)

BV Job nr: IND.K.4.11.0024 R1

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
BOLTED RESTRAINED FLEXIBLE JOINT (Ve) DN 400 PRESSURE CLASS 30 (PFA 30 bar)	Positive internal hydrostatic pressure as per Clause 7.2.2 of EN 545:2010 and Clause 7.1 of ISO 2531:2009	50.0 Bar	2 Hrs	<ul style="list-style-type: none"> • With Shear Load • Maximum Annular Gap • Minimum Pipe Thickness 	Conform
	Positive internal hydrostatic pressure as per Clause 7.2.2 of EN 545:2010 and Clause 7.1 of ISO 2531:2009	50.0 Bar	2 Hrs	<ul style="list-style-type: none"> • Deflected • Maximum Annular Gap • Minimum Pipe Thickness 	Conform
	Cyclic Internal Hydraulic Pressure as per Clause 7.2.5 of EN 545:2010	Cyclic between 31.0 bar to 36.0 bar	24000 Cycles	<ul style="list-style-type: none"> • With Shear Load • Maximum Annular Gap • Minimum Pipe Thickness 	Conform

Note: The Performance Test of DN 200 is representative of ELECTROSTEEL DUCTILE IRON pipe range of DN300-DN 600 with the same Joint

ANNEXES Yes (Total number of pages:) No

Inspected by: Name: Indrajit Das Report issued by: Indrajit Das Date of issue: 01.03.2013 Inspection centre: BV Kolkata		Checked by: Name: Indrajit Das
Distribution: <input checked="" type="checkbox"/> ECL <input checked="" type="checkbox"/> BV Kolkata		