

BENDING PROCEDURE 7

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1.0 PURPOSE

This procedure describes the minimum requirements for shipping of induction bends made from carbon steel, low intermediate alloy steel, and high alloy steel.

2.0 SCOPE

The scope of this procedure is to verify that pipe bends are shipped as specified by Bendco and the client.

3.0 RESPONSIBILITY

The Quality Manager/Management Representative (QM/MR) and the Shop Superintendent are responsible for the activities identified in this procedure. Other designated individuals may be involved in these areas as required by the procedure.

4.0 PROCEDURE

4.1 Upon completion of fabrication and all subsequent operations, fabrication shall be prepared for shipment.

4.2 All sand/debris will be removed from the inside of pipe by blowing with compressed air.

4.3 Shipping protection will be applied as follows unless specified differently by the customer:

- **If required, open ends will be covered with plastic covering or caps.**
- **Threads will be protected with plastic plugs or caps.**
- **Flange faces will be covered with plastic covers securely attached to the flange.**

4.4 Each piece is identified by using a tag or other methods which includes the job number, spool number, and piece mark number. Color code shall be used if required by customer.

4.5 Carbon steel and high alloy materials shall not be mixed on the same trailer without consent of the customer.

4.6 Trailer is loaded with the largest and heaviest pieces on the bottom of the trailer with cribbing and padding as necessary. Alloy material shall not contact carbon steel.

4.7 As fabrication is placed on the trailer the spool number and piece mark are cross checked between the shop drawing and the identification on the part.

4.8A Packing List is generated and loading copies of the shop drawings are pulled to accompany the packing list.

MANUFACTURING PROCEDURE SPECIFICATION
AND INSPECTION TEST PLAN FOR INDUCTION BENDING
FINAL SHIPMENT

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PASADENA, TEXAS
November 17, 2020

	CONTROL COPY DATA		DATE
Prepared By:	GORDON AAKER		DECEMBER 07, 2016
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