

1.0 PURPOSE

The purpose of this work instruction is to establish and maintain documented procedure that describes the details for material receiving inspection, cleaning, marketing and certification by Bendco.

2.0 SCOPE

This work instruction contains methods and requirements to maintain the implementation of these work instructions.

3.0 RESPONSIBILITY

Assistant Manager/Sr. Engineer/Sr. Officer/Engineer/Officer and HOD (QA/QC) shall be responsible for proper monitoring of PIG TEST of Bends.

4.0 MATERIAL RECEIVING INSPECTION

4.1 Material for bending shall comply with the applicable specs and the customer's PO.

4.2 External surface shall be free from surface contamination or other defects that may inhibit successful completion of bend.

4.3 Inside and outside surfaces shall be clean and free of foreign material that may be detrimental to bending.

4.4 Visual inspection and dimensional checks shall be carried out at the point of receipt to confirm that no damage has occurred during transportation.

5.0 CLEANING

5.1 Where lubricants are used for internal mandrels, the pipe I.D. must be cleaned of all residue before the material is shipped.

5.2 Where lubricants are used for external tool lubrication, the surface of the pipe must be cleaned of all residue before surface finishes are applied.

5.3 When so required, finished bends shall be cleaned in accordance with the customer's requirements. Cleaning processes will comply with state, local and federal regulations.

6.0 MARKING

MANUFACTURING PROCEDURE SPECIFICATION AND INSPECTION TEST PLAN FOR INDUCTION BENDING INSPECTION AND CERTIFICATION		PAGE 1	PASADENA, TEXAS November 17, 2020
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Prepared By:	GORDON AAKER		DECEMBER 07, 2016
Reviewed By:			
Approved By:			
Issued By:			
Issued To:			

6.1 All markings of bends will be made in yellow, white or black low chloride marker.

6.2 The information below (8 items) will be included on the Production Bends I.D. and O.D. near one end:

1. Bendco Job No.
2. Heat No.
3. Mark No. per Bendco Drawings
4. Grade
5. O.D.
6. W.T.
7. C/L Radius
8. Angle

6.3 Identifying marks or tags shall also be made as determined by the customer's requirements.

6.4 CERTIFICATION

6.5 All certification and documentation shall be required by the customer.

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