WORK INSTRUCTION FOR VISUAL & DIMENSION INSPECTION OF PIPES AND TUBES

1.0 SCOPE:

This Procedure is applicable for all grades of austenitic and Duplex Seamless Stainless Steel Tubes And Pipes.

2.0 PURPOSE:

The purpose of this procedure is to check the OD, Wall thickness, Length, outside and inside surface of the tubes and pipes.

3.0 EQUIPMENTS:

Visual observation with naked eyes.
Well-illuminated light of 1000 lux.
Micrometer, Vernier and Measure Tape of valid calibration.

4.0 INSTRUCTIONS:

4.1 Adjust the table for the required material.

4.2 Verify the tag with bundle and inter department memo.

4.3 Take the W.O. No. and size from Tag and ID memo. Refer the W.O. Copy and P.O. copy received from the Planning Department.

4.4 As per W.O. Copy and P.O. Copy, refer the relevant standard and take the tolerance for OD, Wall Thickness and length.

4.5 For the checking of OD, Wall thickness and Length, use valid calibration Micrometer, Vernier and Measure Tape respectively.

4.6 First, check the surface of pipes and tubes for defects like Material Defects, Die score, Straightening mark, Pitting, Scale, Metal tearing etc.

4.7 Keep separately the rejected tubes / pipes having Material Defect, Die Score, Straightening marks, pitting and scale.

4.8 The identification No., and next Due date for calibration must be mentioned in the Visual and Dimension Inspection Report of the measuring instrument used for checking the size.

4.9 **When specified by Customer, check the Outside Diameter, using a VALID Calibrated GO NO-GO Ring gauges**

ROOPAM STEEL MUMBAI 400004

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