

INSPECTION SERVICES AND ENGINEERING CERTIFICATION

PHONE: 780.870.1547 EMAIL: operations@indexndt.ca Head Office Mail: P.O. Box 10524, Lloydminster, AB T9V 3A6

INSPECTION REPORT


EQUIPMENT LOCATION:	Lloydminster, Alberta		NDT PROCEDURE#:	INSP-001				
EXAMINATION COVERAGE:	RANDOM:	5%	10%	25%	50%	75%	100%	X
ACCEPTANCE CRITERIA:	CSA W59	ISO 9927-1		CAODC RP		OTHER:		X
INSPECTION METHOD:	VT	X	UT	MT WET FLOURESCENT	X	MT WET BLACK	MT DRY RED	
EQUIPMENT INFO:	BLACK LIGHT MAKE - INOVA		LIGHT METER # 1822158		MAG COIL # RC1-30120121			

CLIENT:	K&S Power Tongs	UNIT/REPORT#:	KSV007/IDX-5324
EQUIPMENT:	Volant Tool	MAKE/MODEL:	Volant CRTi3-7.0
RATING:	N/A	SERIAL NUMBER:	KSV007

EQUIPMENT PHOTOS



INSPECTION RESULTS

ACCEPTABLE:	X	REJECTED:		DATE OF INSPECTION:	April 15, 2024
TECHNICIAN:			COMMENTS:		
			Part:	Serial#:	
			Mandrel	82306-03-4527A01-01	
			Cage	82856-4501A02-12	
			Upper Cam	81190-4517A04-04	
			Lower Cam	81191-4527A05-04	
			Cam Latch	80813-4517A07-02	
			Cam Int.	80810-4527A03-02	
			Die - 7" [17-26]	80929-01-3J4155-71	
			Die - 7" [17-26]	80929-01-4624A16-37	
			Die - 7" [17-26]	80929-01-4466A01-30	
Die - 7" [17-26]	80929-01-4538A03-71				
Die - 7" [17-26]	80929-01-3J4155-69				
Jaw	81955-02-4521A16-18				
Jaw	81955-02-4521A16-12				
Jaw	81955-02-4521A16-16				
Jaw	81955-02-4521A16-14				
Jaw	81955-02-4521A16-15				
Mandrel UT Measurements:			1.272, 1.270, 1.271, 1.273, 1.269		
REPAIRS: NA					

QUALITY ASSURED INSPECTIONS FOR QUALITY ASSURED BUSINESSES

Except as provided herein, Index NDT Inspections Ltd. makes no warranty, express or implied with respect to the mechanical or other conditions of the equipment inspected by us. Index NDT Inspections Ltd. shall only be responsible in the event of damage resulting directly from their inspection, and in no event, shall the liability of Index NDT Inspections Ltd. exceed the cost of inspection. Our organization assumes only the responsibility of locating defects in the inspected components and welds made accessible at the time of inspection. All equipment should be cleaned to allow access to all welds and critical components. It is of the utmost importance that the unit's owner be aware that excessive coating over 10 mils can severely mask the detection of discontinuities while utilizing standard inspection techniques. We are not responsible for the mechanical or other conditions assembled condition except at customer's request.

INCLUSION P-POROSITY IUC-INTERNAL UNDERCUT EUC-EXTERNAL UNDERCUT SSLAG C-CRATOR IP-INCOMPLETE PENETRATION NF-NON-FUSION CR-CRACK PH-PIN HOLE D-DISCONTINUITY



REES N.D.T. INSPECTION SERVICES 2008 LTD.



15612-89 Street
Grande Prairie, AB T8V 2N8

Grande Prairie
(780) 539-3594
(780) 532-8047 (Fax)

Dispatch
1-888-540-3594
www.reesndt.com

Vegreville
(780) 603-4887
Email: gcoers@reesndt.com

INSPECTION DATE: 30-Mar-22

CLIENT: K & S Power Tongs
ADDRESS: 3614 63 Avenue Close
Lloydminster AB T9V 2W1

REES NDT PO NUMBER: R68183
CLIENT PO NUMBER: Ksv007
REES NDT WO NUMBER: 197572

INSPECTION CERTIFICATE

CERTIFICATION OF: CRT Mandrel
MAKE: Volant
MODEL: CRTi3-7.0
SERIAL NUMBER: 82306-03-4527A01-01
UNIT NUMBER: NA
CAPACITY: 320 ton
OWNER: K & S Power Tongs

Rees NDT Inspection Services 2008 Ltd. performed a VISUAL AND NON-DESTRUCTIVE TESTING inspection on the above mentioned CRT MANDREL. All observations have been recorded and are disclosed in the complete documentation for Rees NDT Work Order #197572. The scope of this certificate is limited to the inspection of the item's structural condition at the time of inspection and does not imply a review of the equipment's design or its associated capacity rating. The capacity noted above reflects the original equipment manufacturer's maximum capacity rating and may be reduced by operating conditions, regulatory requirements and the use of auxiliary equipment that has a lower capacity rating.

The undersigned Engineer reviewed all the inspection reports and has issued this certificate after all required repairs (if any) were completed. In the undersigned Engineer's opinion, the CRT MANDREL may be returned to service and is safe to use within the original manufacturer's specifications. The equipment owner is obliged to supply the OEM's operating instructions with the equipment and maintain the OEM's identification and capacity markings. If OEM information cannot be obtained, certified replacements must be obtained from a Professional Engineer.

This certification covers the above mentioned unit for a period of 5 YEARS AS PER API-8B from the date of inspection, or until the unit is damaged by handling, transportation or operation.

Reviewed
By



12-Apr-2022

PERMIT TO PRACTICE	
REES NDT ENGINEERING LTD.	
Signature	<u>Albert Bhatt</u>
Date	<u>12-Apr-2022</u>
PERMIT NUMBER: P 11509	
The Association of Professional Engineers and Geoscientists of Alberta	



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LOAD TEST CERTIFICATE

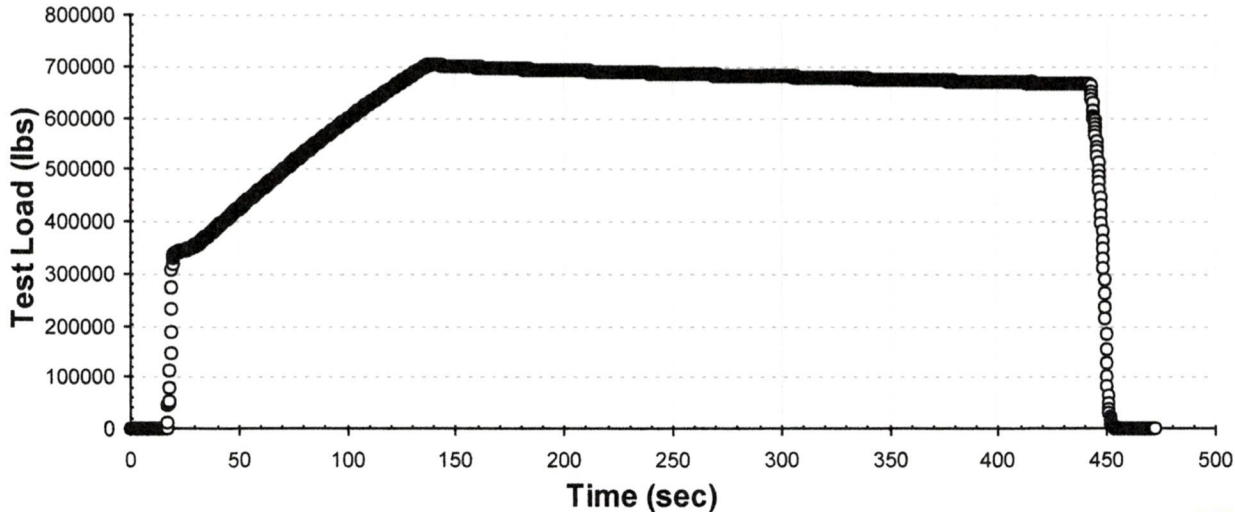
Owner K & S Power Tongs
Address 3614 63 Avenue Close
Lloydminster AB T9V 2W1

Date 30-Mar-22
Workorder # 197572
Purchase Order# **KSV007**

Contact Name:	Chris	Phone #:	(780) 872-8240
Item:	CRT Mandrel	Location:	Rees NDT Shop, Grande Prairie
Make:	Volant	Model:	CRTi3-7.0
Serial Number:	82306-03-4527A01-01	Unit:	NA
Capacity:		320 ton	

Proof Load Test 704000 lbs **Test Date** 31-Mar-22 **Required Duration (sec)** 300
Test Method: Proof 1.10 **Peak Load** 704358 lbs **Passed**

Test Equipment:	Make:	Model:	Serial Number:	Capacity:
Testing Frame	Volker Ries	525 ton	VR-01	525 ton
Pressure Gauge	Rosemount	3501	-	(0-5000) psi
Data Logger	ACR Systems	SRP-7-32K 0-25MA	96674	(0-25 mA)



DELAYED USE
Date of 1st Use: May 30/22
Job #: IPC Canada
Signed By: [Signature]





REES N.D.T. INSPECTION SERVICES 2008 LTD.



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- Wall Thickness Testing • Hardness test
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- Drilling Rig Certification
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- Corrosion Monitoring
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- Quality Control
- Predictive Maintenance
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15612-89 Street Grande Prairie AB T8V 2N8

email: ronvader@reesndt.com

Consigned to K & S Power Tongs

Date 30-Mar-22

Address 3614 63 Avenue Close
Lloydminster AB
T9V 2W1

Workorder 197572

Purchase Order# KSV007

Location Rees NDT Shop, Grande Prairie

Customer K & S Power Tongs

Eng Certification - Visual - Fluorescent Magnetic Particle - Ultrasonic - Load Test

Contact Name:	Chris	Phone #:	(780) 872-8240
Item:	CRT Mandrel	Location:	Rees NDT Shop, Grande Prairie
		Model:	CRTi3-7.0
Make:	Volant	Unit:	NA
Serial Number:	82306-03-4527A01-01	Capacity:	320 ton

Field Report

RESULTS OF INSPECTION IN ALL ACCESSIBLE AREAS:

Rees NDT Inspection Services 2008 Ltd. performed a Visual, Wet Fluorescent Magnetic Particle Inspection, Wall Thickness Test and Load Test on the above mentioned CRT Mandrel. Mandrel was cleaned of paint, oil and grease prior to inspection. Mandrel was demagnetized at the time of inspection. See attached pictures.

MPI Inspection:

 Procedure: MPI-ASTM E709 Rev 0, Jan 22, 2019
 Technique: MT-3 Wet Fluorescent Magnetic Particle
 Acceptance Standard: API-8C
 Surface Prep: Bare Metal / Machined
 Material: Carbon Steel

NDT Inspection Results:

 Pre Load Test - CRT Mandrel: No relevant indications or damage was noted at the time of inspection. 4 1/2" IF Box Plug Gauge Passed.
 Post Load Test - CRT Mandrel: No relevant indications or damage was noted at the time of inspection.

5-Wall Thickness Readings Taken: 1.258", 1.254", 1.255", 1.259", 1.256" Average Thickness: 1.256"
 Areas scanned around and lowest readings recorded.
 O.D. was measured at the same spot as wall thickness readings: O.D. 3.989"

Calibrated Equipment Used Blacklights: BL-30-00 Wet Benches: WB-02-00 UT Machines: USU-23-00 Cal Blocks: 01-7186 Cal Blocks: UT-CB-74-00 Digital Calipers & Micrometers: DVC-34-00

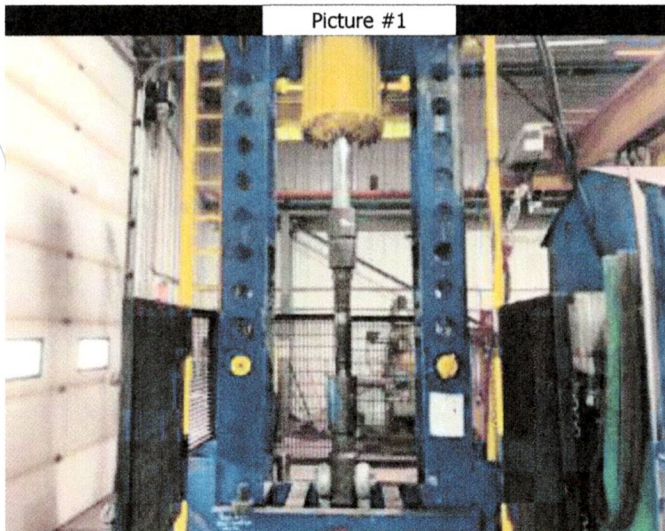
Inspected By: J. House CGSB #20221 (MPI II) SNT #028 (MPI II) B. Kempert SNT #044 (MPI II LPI II) CGSB #24150 (MPI II) K. Gejdos Millwright (J-09-31585) Machinist (J-11-16754) J. Ibarbia

AR = 0.0%= Passed,
calculated with CRT maintenance procedure Appendix B mandrel neck area calculation.

This inspection and compliance certification covers items supplied for inspection.
Customer is responsible for PLC / mechanical components, and proper function of tool.

Equipment Used:

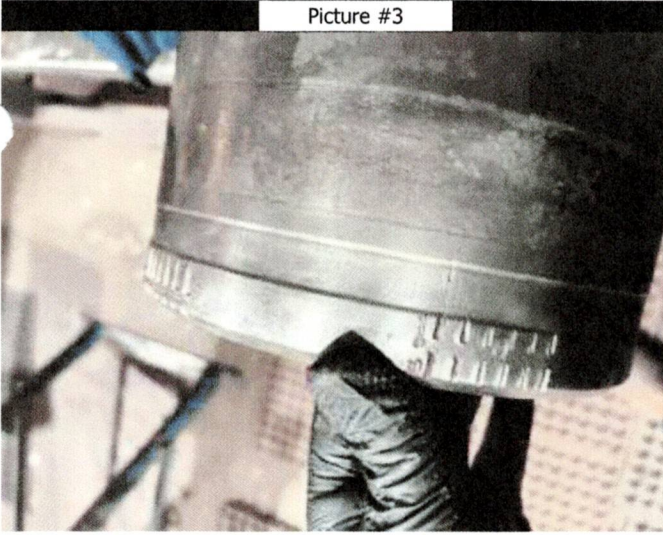
- Spectroline BIB-150P (BL-30-00 - 1910553) Calibration Due: 30-Jul-2022
 - DCM Wet Bench (WB-02-00 - 37941) Calibration Due: 05-Apr-2022
 - Krautkramer USN-58L SW (USU-23-00 - 023K45) Calibration Due: 03-Jun-2022
 - DS Block with Case (01-7186 - 01-7186) Calibration Due: 31-Dec-2099
 - 0.250" - 1.000" 4 Step Curve (UT-CB-74-00 - UT-CB-74-00) Calibration Due: 31-Dec-2099
 - Digital Vernier Caliper (DVC-34-00 - 0012982) Calibration Due: 07-Jun-2022
 - Magnaglo 14A Fluorescent Magnetic Particles Batch #21E020
- See attached pictures.



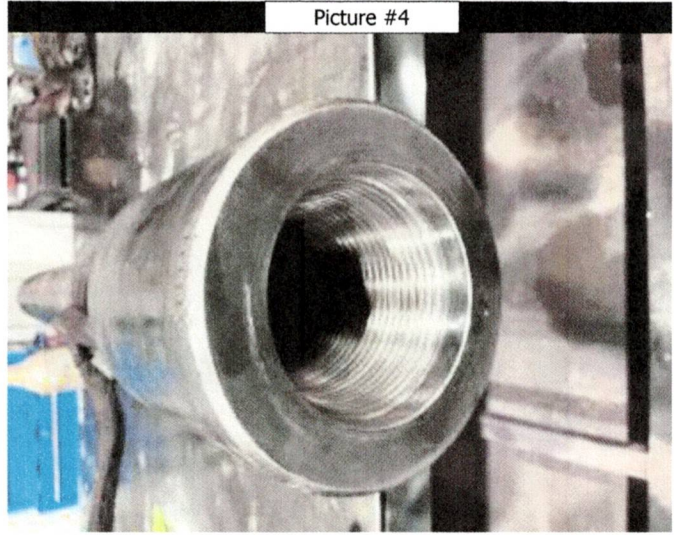
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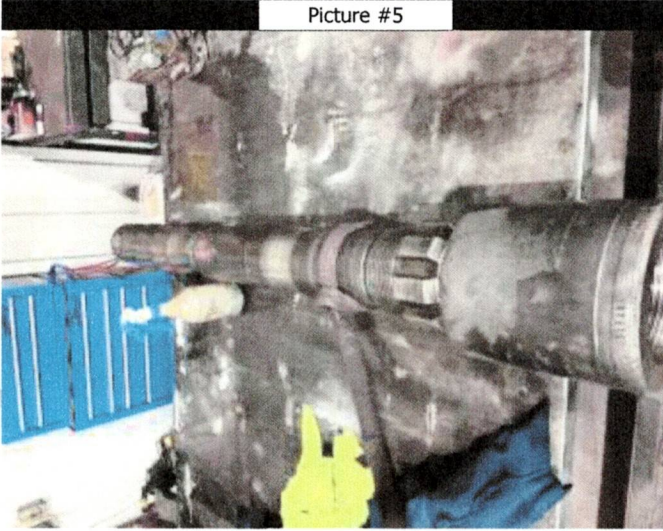
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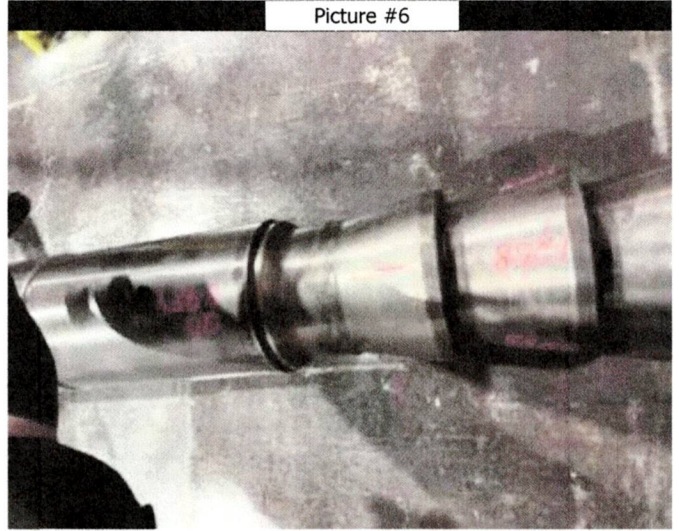
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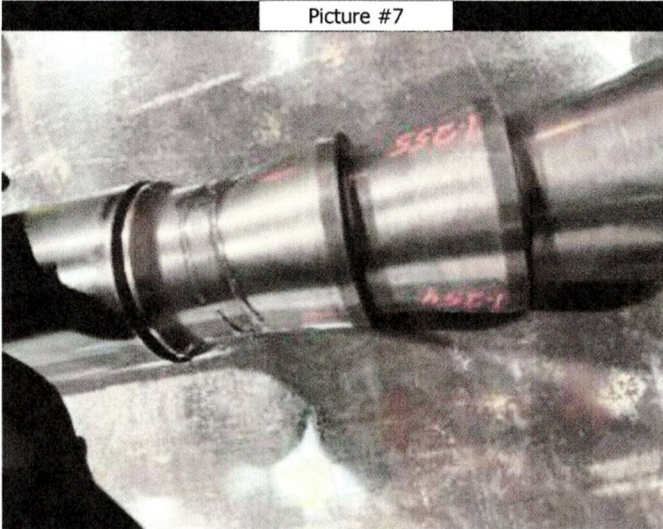
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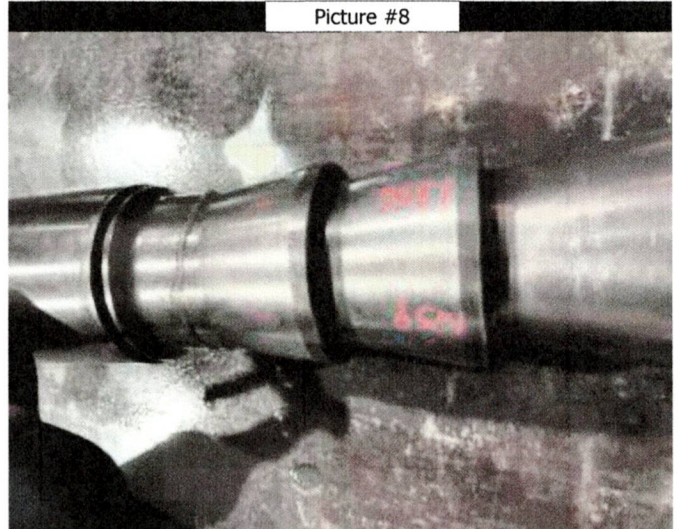
Picture #6



Picture #7



Picture #8



Calibrated Equipment Used Blacklights: BL-30-00 Wet Benches: WB-02-00 UT Machines: USU-23-00 Cal Blocks: 01-7186 Cal Blocks: UT-CB-74-00 Digital Calipers & Micrometers: DVC-34-00

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