

DESCRIPTION OF OPERATION		SCOPE	ACCEPTANCE CRITERIA	DOC. TYPE	INSPECTION METHOD		
<b>1.0</b>	<b>Quality Control of Materials by Neles</b>				NonMet	CPM	PGSOLPERTAGAS
1.1	<b>Chemical analysis and mechanical tests</b> Control of ladle analysis taken during pouring, and mechanical properties	Pressure retaining parts	Procedures M-144-En / M-148-En and material specification	10204 3.1	M	-	R
1.2	<b>Visual examination</b> Visual inspection of surfaces/markings prior to delivery	Pressure retaining parts	MSS SP-55 standard and relevant drawing		M	-	-
1.3	<b>Liquid Penetrant Test</b> Examination of surface defects on component surfaces.	Pressure retaining parts	Neles Standard	Test report	M	-	R
<b>2.0</b>	<b>Quality Control of Materials at Metso</b>				NonMet	CPM	PGSOLPERTAGAS
2.1	<b>Receiving of materials and certificates</b> Comparing of dispatch list with purchasing documents	Verification of identification marking and visual condition	Purchase order	Test report	M	-	R
2.2	<b>Incoming inspection</b> Control of dimensions, surface quality, markings and certificates	Applicable parts	Drawings, MSS SP-55 standard and procedures M-264-En, M-176-En, M-144-En / M-148-En / M-147-En		M	-	-
2.3	<b>Visual and dimensional inspection</b> Main dimensions, 3D measuring machine used on a sample basis, markings	In house machined parts	Drawings, standards and procedure		M	-	-
<b>3.0</b>	<b>Quality control during Valve Assembly at Metso</b>				NonMet	CPM	PGSOLPERTAGAS
3.1	<b>Assembly</b> Control of visual appearance, cleanliness and markings	All parts	Procedures M-230-En, SOP-2105-EN and internal procedures		M	-	-
3.2	<b>Valve final testing</b> - Shell Pressure Test - High Pressure Test - Low Pressure Test	Valve	No visible leakage in shell test acc. to M-906-Ko. Seat leakage according to procedure M-907-Ko and international standards	Test record	M	-	W
<b>4.0</b>	<b>Quality control during Actuator Assembly at NELES</b>						

Revision: 3	Approved: Aug 1, 2022	Checker: Ryo Yoon
Status: APPROVED	Responsible: Sunju Jung	Approver: Youngjun Joo

# Mss Sample Tests Madera

**L Cohen**



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