OIL INDIA LIMITED
KG BASIN PROJECT
KAKINADA

BID CORRIGENDUM-1

Bid Number: TPI00173KG

Hiring of Third-Party Inspection (TPI) Agency Services for inspection of 9.5/8" Casings and accessories to be supplied against OIL's Purchase Order No. GEMC-511687718726440, dtd. 11.04.2025.

1.0 Prospective bidders are advised to bid as per following Terms and Conditions:

(i) Kindly refer to modified QAP/QCP for THREADING OF JFELION SD57 CONNECTION (for PUP JOINT (ON MSL PIPE) and QAP/QCP for THREADING OF JFELION SD57 CONNECTION (for R3 CASING ON MSL PIPE) enclosed as Annexure-II to BID CORRIGENDUM-1 along with statement of changes enclosed as Annexure-I to BID CORRIGENDUM-1.

Additionally, this revised QAP/QCP to be referred in all sections of Bid Documents viz. Technical Specifications Document/ BOQ Detail Document etc.

(ii) Extension of Bid Closing Date (BCD) & Bid Opening Date (BOD) of Bid Number: TPI00173KG as under:

Bid Closing Date & Time: 05.06.2025, 13:00 hrs. IST.

Bid Opening Date & Time: 05.06.2025, 15:00 hrs. IST.

2.0 All other terms and conditions of the tender remain unaltered.

Oil India Limited
KG Basin Project

Annexure-I to
BID CORRIGENDUM-1.

STATEMENT OF CHANGES IN QCP IN CORRIGENDUM VIS-A-VIS TENDER

QCP No.	Page No	Item No.	Changes
SOI-QCP-01-25(KSB) P REV 0 JFELION-R3	1	Cover Page	1.) Change from MARUBENI-ITOCHU TUBULAR ASIA (MITA) to MARUBENI-ITOCHU TUBULAR ASIA (MITA) / MAHARASHTRA SEAMLESS LIMITED (MSL). 2.) Change on customer signature column from MSL to MITA/MSL 3.) Added "SD57" instead of JFELION only.
	3	4	Acceptance criteria column 1.) Rename procedure JFELION-TP-E-001 – Swaging and Stress Relieving Procedure for JFELION to JFELION-TP-E-001 – Swaging Deformation and Stress Relieving Procedure for JFELION 2.) Removed percentage of swaging deformation statement "Deformation shall not exceed 5% as per JFE formula"
	4	6	Inspection column 1.) Added "shoulder area" 2.) Added " Via profilometer only "
	5	7	JFE Intervention change from monitor (M) to not required (-).
	5	8	JFE Intervention change from monitor (M) to not required (-).
	8	12	Inspection column 1.) Remove "Adhesive Tape" as a method for Phosphate Adhesion Test.
	8	14	Remark column 1.) Added " Low alloy jaw depth criteria"
	9	15	1.) Tally from end of the box to end of the pin - JFE Intervention change from monitor (M) to not required (-). 2) Storage Compound - JFE Intervention change from monitor (M) to not required (-). 3.) Tightening both end of protectors. - JFE Intervention change from monitor (M) to not required (-).
	10	16	JFE Intervention change from monitor (M) to not required (-).
SOI-QCP-02-25(KSB) P REV 0 JFELION-PUPJOINT	1	Cover Page	1.) Change from MARUBENI-ITOCHU TUBULAR ASIA (MITA) to MARUBENI-ITOCHU TUBULAR ASIA (MITA) / MAHARASHTRA SEAMLESS LIMITED (MSL). 2.) Change on customer signature column from MSL to MITA/MSL 3.) Added "SD57" instead of JFELION only.
	3	5	Acceptance criteria column 1.) Rename procedure JFELION-TP-E-001 – Swaging and Stress Relieving Procedure for JFELION to JFELION-TP-E-001 – Swaging Deformation and Stress Relieving Procedure for JFELION 2.) Removed percentage of swaging deformation statement "Deformation shall not exceed 5% as per JFE formula"
	5	7	Inspection column 1.) Added "shoulder area" 2.) Added "Via profilometer only "
	5	8	JFE Intervention change from monitor (M) to not required (-).
	6	9	JFE Intervention change from monitor (M) to not required (-).
	8	13	Inspection column 1.) Remove "Adhesive Tape" as a method for Phosphate Adhesion Test.
	9	15	Remark column 1.) Added " Low alloy jaw depth criteria"
	10	16	1.) Tally from end of the box to end of the pin - JFE Intervention change from monitor (M) to not required (-). 2) Storage Compound - JFE Intervention change from monitor (M) to not required (-). 3.) Tightening both end of protectors. - JFE Intervention change from monitor (M) to not required (-).
	10	17	JFE Intervention change from monitor (M) to not required (-).

SOBENA OFFSHORE	SOBENA OFFSHORE INC SDN BHD (137601-A) KEMAMAN SUPPLY BASE, WAREHOUSE 25, P.O. BOX NO 95, 24007 KEMAMAN, TERENGGANU DARUL IMAN, MALAYSIA	QUALITY CONTROL PLAN	DOCUMENT NO.: SOI-QCP-02-25(KSB) P REV 0

CUSTOMER	MARUBENI-ITOCHU TUBULAR ASIA (MITA) / MAHARASHTRA SEAMLESS LIMITED (MSL)	**CONTRACT NO.**	GEMC-511687718726440	**DESCRIPTION**	THREADING OF JFELION SD57 CONNECTION – • PUP JOINT (ON MAHARASHTRA SEAMLESS LIMITED PIPE) - PIN X PIN - THREAD & COUPLE
END USER	OIL INDIA KAKINADA (KERALA-KONKAN BLOCK/KG BASIN)	**REVISION**	0		
LICENSOR	JFE	**DATE**	15th MAY 2025		
SIZE(S) & PPF	9 5/8”/ 53.5#	**APPLICABLE STANDARDS**		API SPEC 5CT, API RP 5A5, API SPEC 5B, PROPRIETARY CONNECTION SPECIFICATION – JFELION SD57	
GRADES	P110	**APPLICABLE CONTRACT SPECIFICATIONS**		N/A	

NOTES:

1) Processes that are listed in this QCP are solely based on SOI capabilities.
2) The applicability and requirements shall be based on the Individual Licensor’s Technical Package for each Premium Connection.
3) Notification for TPI to be done 48hrs before activity.
4) Any additional requirement beyond this QCP may be specified in addendum.

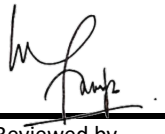
LEGENDS:

WI	WORK INSTRUCTION
SPEC	SPECIFICATION
IWO	INTERNAL WORK ORDER
SOI	SOBENA OFFSHORE INC.
API RP	API RECOMMENDED PRACTICE
QSP	QUALITY SYSTEM PROCEDURE

INSPECTION POINT:

H	HOLD POINT – 48 HRS NOTICE
M	MONITORING / RANDOM CHECK
100%	100% INSPECTION
R	DOCUMENTS REVIEW
RA	REVIEW & APPROVE
W	WITNESS – 48 HRS NOTICE
WR	RANDOM WITNESS

THIS QUALITY CONTROL PLAN IS SOLELY PROPRIETARY OF SOBENA OFFSHORE INC. SDN. BHD.

	SOBENA OFFSHORE INC SDN BHD		
SIGNATURE			
	Prepared by	Reviewed by	Reviewed by
NAME	AHMAD TARMIDZI JANTAN	MOHD NOOR B. SALLEH	IZNUL HADI B. PANIS
TITLE	QAQC MANAGER	OPERATION MANAGER	PLANT MANAGER
DATE	21st MAY 2025	21st MAY 2025	21st MAY 2025

	LICENSOR: JFE/JFETC	CUSTOMER: MITA/MSL	END USER: OIL INDIA KAKINADA
SIGNATURE	Terry Tan		 **Note:** Approved as it is proprietary connection
NAME	TERRY TAN		Vivek Sawarkar
TITLE	OPERATIONS MANAGER		SED
DATE	21 MAY 2025		02.06.2025

NO	ACTIVITY	INSPECTION	ACCEPTANCE CRITERIA *(*latest Revision)*	REFERENCE DOCUMENT *(*latest Revision)*	RECORD	INSPECTION INTERVENTION				REMARKS
						SOI	JFE	MITA / MSL	END USER / TPI	
1	**CONTRACT REVIEW**	- License to Manufacture - Materials and Consumable Stock - Technical Specification - Scope of Work - Production Schedule - Delivery Time	- Within specification and requirement in Purchase Order	- QSP2000-ML05 – Contract Review, Determination and Review of Requirements - QSP2000-MR07 – Process Control Documents and Quality Control Plan	- F3000-ML01 – Contract Review - F3000-ML02 – Internal Work Order	H R	-		RA	- Internal Work Order issued to plant once order is confirmed before process starts. - All reference standards shall be the latest revision.
2	**RECEIVING OF PIPES & COUPLING STOCK** (INCLUDE RANGE PE FOR PUP JOINT CONVERSION)	- 10% Visual Body Inspection - Dimensional check - ID/OD Wall Thickness, Length, and Straightness - Quantity Check - Materials Defect - Materials Identification (Heat Number, Mfg. number, Pipes & CS number and Lot Number)	- Within requirements in WI3000-ML01 – Receiving and Inspection of Product and Material - WI3000-ML02 – Product and Material Handling and Storage - Review of mill cert	- WI3000-ML01 – Receiving and Inspection of Product and Material - WI3000-ML02 – Material Handling and Storage - API Spec 5CT – Specification for Casing and Tubing	- F3000-ML03 - Material Log (Receiving data) - F3000-QC08 - Material Receiving Inspection (dimensional check)	10% or 100% H	-		-	As per SOI Incoming Inspection Plan – 10% or 100% if the Quantity is ≤ 10.
3	**RECEIVING OF SUPPORTING MATERIALS**	- CNC Program Verification - Gauge Calibration - Tooling Inspection - Insert Inspection - Storage Compound - Chemical - Thread protector	- Within specification and requirement in Purchase Order - Tooling – as per requirement - Insert – compare with connection overlay - Chemical and storage compound – refer to COA and SDS - Thread protector as per API 5CT Annex F (Class-designation: 5CTA)	- QSP2000-PC09 – Procurement Control - QSP2000-QC18 - Inspection/Test Status, Inspection, Testing, and Verification, and Product Release - SDS – Safety Data Sheet - COA – Certificate of Analysis	- F3000-PC15 – Incoming Good Material Inspection	H R	-		-	

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						SOI	JFE	MITA / MSL	END USER / TPI	
4	**SAW CUT PUP JOINT** (FOR PUP JOINTS ONLY)	- Saw cut length - Straightness check - Traceability - Overall length tolerance ±3”	- Within requirements as per specified in Internal Work Order (IWO) - QSP2000-QC14 - Identification & Traceability - Saw Cut Diagram	- F3000-ML02 – Internal Work Order - WI3000-PD07 – Saw Cut & Marking - QSP2000-QC14 – Identification & Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release	- F3000-PD15 - Saw Cut Pup Joint/ Repair Job	100%	-		-	- Transfer the mother pipe markings i.e. pipe no., heat no., size, poundage, grade onto the pup joint body. - Pup joints are given new running number for identification and traceability.
5	**SWAGING PLAIN END**	- Visual - Swage Length - To measure ID and OD pipe after swage. - Calculation for deformation.	Within requirements: - Internal Work Order - JFELION-TP-E-001 – Swaging Deformation and Stress Relieving Procedure for JFELION	- F3000-ML02 – Internal Work Order - JFELION-TP-E-001 – Swaging Deformation and Stress Relieving Procedure for JFELION - WI3000-PD03 – Swaging and Expanding - QSP2000-QC14 – Identification and Traceability. - QSP2000- QC18 - Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-PD11 – Record Sheet Swaging/ Expand	100%	M		R	- Swaging Procedure available for review at threading facility
6	**THREADING OF PIN**	- Thread gauging - Visual and Dimensional Thread and Seal. - First and Last Article Inspection. - Casting - Overlays Inspection - Gauge Calibration	- Dimension and visual inspection within requirement of JFELION-TP-G-001 – JFELION Thread Inspection and Gauging Procedure for Pin - JFELION Drawing (Pin) and Inspection Sheet	- F3000-ML02 – Internal Work Order - JFELION-TP-G-001 – JFELION Thread Inspection and Gauging Procedure for Pin - JFELION Drawing (Pin) and Inspection Sheet	- JFELION Inspection Sheet (Pin)	100%	M		R	- Traceability of gauging records to individual connection. - PU foam bung shall be used at pipe ID. - Nonconformance product shall be marked with red paint, segregated before proceeding with rework process. Type of reject shall be indicated on

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						SOI	JFE	MITA / MSL	END USER / TPI	
			- API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing - No Burrs	- WI3000-PD06 – Threading of Pipe, Coupling and Accessories. - WI3000-QC19 – Gauging Pin and Box. - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - API Spec 5B – Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing						threading form and rejected pipe. Gauging procedures are available at threading facility. - Apply alternate Bore ID as per JFELION procedure.
7	**SURFACE TREATMENT OF PIN END**	- Visual Inspection. - Blasting shall cover all thread, shoulder area and seal area. - Check Roughness (RA) via profilometer only.	- Within requirements in JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connections. - Good surface. - No burrs.	- F3000-ML02 – Internal Work Order - JFELION-TP-D-001 – Process Control Procedure for Manufacturing of JFELION Connections - JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connections. - WI3000-PD09 – Bead Peening. - QSP2000-QC14 –	- F3000-PD17 – Record Sheet - Blasting Field End / Mill End	100%	M		R	- Procedure available for review at threading facility - Media: Aluminium oxide - Required grit size: 54-100

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				Identification and Traceability. - QSP2000- QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.						
8	**SAW CUT COUPLING**	- Saw cut length and square check - Straightness check - Traceability	- Within requirements in: - Internal Work Order (IWO) - API Spec 5CT - Specification of Casing and Tubing - Products for Use as Casing, Tubing, Coupling Stock, and Accessory Material - JFELION Technical Procedure - JFELION Drawing for (Box)	- F3000-ML02 - Internal Work Order - WI3000-PD07 - Saw Cut and Marking OCTG - QSP2000-QC14 – Identification and Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - JFELION Drawing (Box)	- F3000-PD14 – Record Sheet - Saw-cut Coupling	100%	-		-	
9	**OD BLANKING COUPLING**	- Visual and Dimensional - Marking verification - Stamping verification - Traceability	- Within requirements in Licensor Technical procedure - JFELION Drawing for Box - Traceability marking	- F3000-ML02 - Internal Work Order - WI3000-PD08 - Blanking - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - JFELION Drawing (Box)	- F3000-PD13 – Record Sheet OD Blanking	100%	-		-	- Non-Conformance product marked with red paint, write details of nonconformance on coupling body and segregated.

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10	**THREADING OF COUPLING** (Bevel 45°) Note: Any special bevel required shall be captured in addendum.	- Thread gauging - Visual and Dimensional Thread and Seal - First and Last Article Inspection - Casting - Overlays Inspection - Gauge Calibration	- Dimension and visual inspection within requirement of JFELION-TP-G-101 – JFELION Thread Inspection and Gauging Procedure for Box - JFELION Drawing (Box) - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing - No Burrs	- F3000-ML02 - Internal Work Order - JFELION-TP-G-101 – JFELION Thread Inspection and Gauging Procedure for Box - JFELION Drawing (Box) and Inspection Sheet - WI3000-PD06 - Threading of Pipe, Coupling and Accessories - WI3000-QC19 – Gauging Pin and Box - QSP2000-QC14 – Identification and Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing	- JFELION Inspection Sheet (Box)	100%	M		R	- Traceability of gauging records to individual coupling. - Non-Conformance product shall be marked with red paint and segregated. Type of reject will be indicated on threading form and rejected coupling. - Procedure available for review at threading facility.
11	**MPI FOR COUPLING – (Magnetic Particle Inspection)**	- Visual Inspection on: Thread, Seal, OD & Bearing Face - Interpret and evaluate the discontinuity indications.	- Interpret and evaluate the discontinuity indications - Within requirements in WI3000-QC18 – Magnetic Particle Inspection	- F3000-ML02 - Internal Work Order - WI3000-QC18 – Magnetic Particle Inspection	- F3000-QC21 – Magnetic Particle Inspection	100%	M		R	- Longitudinal - Transverse ID and OD - Remark “OK” at the coupling body to identify acceptance of MPI inspection. - To be removed at clean/coat process prior to delivery.

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			- API Spec 5CT - Specification of Casing and Tubing - ASTM E709 – Standard Guide for Magnetic Particle Inspection - ASTM E1444 – Standard Practice for Magnetic Particle Inspection	- WI3000-QC23 – Written Practice for NDT - ASTM E709 – Standard Guide for Magnetic Particle Inspection - ASTM E1444 – Standard Practice for Magnetic Particle Inspection - E3024 / E3024M - Standard Practices for Magnetic Particle Testing for General Industry - API Spec 5CT - Specification of Casing and Tubing						- Perform by ASNT Level 2 Inspector.
12	**SURFACE TREATMENT OF COUPLING**	- Visual Inspection - Blasting shall cover all seal and shoulder area only.	- Within requirements in JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connection - Good surface. - No burrs.	- F3000-ML02 – Internal Work Order - JFELION-TP-D-001 - Process Control Procedure for Manufacturing of JFELION Connections - JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connection - WI3000-PD09 – Bead Peening. - QSP2000-QC14 – Identification and Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and	- F3000-PD16 – Record Sheet – Blasting Coupling	100%	M		R	- Procedure available for review at threading facility - Media: Aluminium oxide - Required grit size: 120-220

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				Verification, and Product Release.						
13	**PHOSPHATING OF COUPLING** (MATERIAL GRADE: CARBON STEEL LOW ALLOY)	- Coating type: Manganese Phosphate - VBI & VTI - Adhesion Test – Eraser	- Each product shall be visually inspected, and the coating should be a consistent greyish/ black finish with no voids or uncoated areas. - No Flacking or Peeling - JFE-TP-H-201 – Phosphate Procedure for JFE Premium Connections - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads.	- Internal Work Order (F3000-ML02) - WI3000-PD10 – Phosphating - JFE-TP-H-201 – Phosphate Procedure for JFE Premium Connections - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads.	- F3000-PD19 – Phosphating Coupling	100%	M		R	- The non-conforming parts shall be stripped and reprocessed - Procedure available for review at threading plant - Coating weight: 9 – 43 g/m² (Frequency: Beginning of each shift)
14	**DRIFTING (Special Drift)**	- Drift dimension shall be verified - Full Length Drift	- The drift shall pass thru. - Within requirements in WI3000-PD12 – Drifting. - API Spec 5CT - Specification of Casing and Tubing - If found drift out of tolerance at the beginning of the shift, to inspect whole lot from previous shift.	- WI3000-PD12 - Drifting - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - F3000-MR32A- Drift Size - API Spec 5CT - Specification of Casing and Tubing	- F3000-QC17- Power Tong - F3000-QC19 – Final Inspection	100%	M		R	- Non-Conformance product marked with red paint and segregated. - FLD will be perform after make-up process. - Drift material: MC NYLON - Drift OD minimum dimension: **215.90 mm** - Drift Length minimum dimension: **305 mm**

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15	**MAKE-UP PIN END WITH COUPLING**	- Visual Thread Inspection - Type of dope - Torque Values - Make-Up area - Feeler gauge - End Drift –from face to pass make up jaw area.	- Torque value / Make-up Graph are within requirements in: - JFE-TP-J-001 – JFE Connection Make-Up Procedure - JFELION-TP-J-101 – Make-Up Torque for JFELION Connections - Feeler gauge.	- F3000-ML02 – Internal Work Order - JFE-TP-J-001 – JFE Connection Make-Up Procedure - JFELION-TP-J-101 – Make-Up Torque for JFELION Connections - WI3000-PD13 – Buck on Coupling and Accessories.	- F3000-QC17 - Power Tong	100%	M		M	- Thread Compound: API Modified - Low Alloy Criteria: OD Size (inch): 6 5/8" – 20" Coupling OD Max Grip Mark (inch) as per API 5CT E.31: 0.040 Pipe OD Max Grip Mark as per API 5CT SR2 Requirement (JFE-TC Recommendation): 5% of Nominal Wall Thickness
16	**END FINISHING / STENCILLING**	- Visual Thread Inspection - Visual Body Inspection	- ID/OD Pipe shall be clean and free from scales. - To ensure thread and pipe body are clear from any defect or dent.	- F3000-ML02 – Internal Work Order. - QSP2000-QC14 – Identification and Traceability. - QSP2000- QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-QC19 – Final Inspection	100%	M		M	- Check ID free from foreign materials before close the protector.
		- ID/OD Clean and Coat	- ID/OD Coating shall be as thin as possible if the pipes already been mill coated to ensure no overflow of coating excess when opening the thread protector.	- WI3000-PD15 – Clean and Coat - API Spec 5CT – Specification of Casing and Tubing	- F3000-QC19 – Final Inspection	100%	-		M	- ID Cleaning by using Mechanical brush/ Rattling Motor and high-pressure Air. - ID Coat: Synergen 718/Light oil (OPTIONAL) - OD Coat: Plusco 315
		- Tally from end of the box to end of the pin	- Within requirement API Spec 5CT – Specification of Casing and Tubing - Customer Requirement	- WI3000-PD15 – Clean and Coat - QSP2000-QC14 – Identification and Traceability.	- F3000-QC19 – Final Inspection	100%	-		M	- Calibrated measuring tape shall be used. - Tally in Meter (m) round to two decimal places.

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		- Storage Compound	- Covered Fully on Threaded Surface	- QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.		100%	-		M	- OCTG Orange Kendex shall be used as storage compound.
		- Stencilling / colour band	- Stencilling 2' from box end. - Colour band as per requirement. - JFE-TP-K-001 – JFE Connection Stencilling Procedure	- WI3000-PD15 – Clean and Coat - JFE-TP-K-001 – JFE Connection Stencilling Procedure - QSP2000-QC14 – Identification and Traceability	- F3000-QC19 – Final Inspection	100%	M		M	- Details of marking on final product: TBA by MITA in every service instruction/order. Stencil low stress & Handheld inkjet marking shall include: 1. Connection name 2. Material grade 3. Connection size & weight 4. **Special drift (SD)** 5. Licensee code
		- Tightening both end of protectors.	- Wrench tight. - JFE-TP-N-001 – Thread Protector of JFE Premium Connection	- QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - JFE-TP-N-001 – Thread Protector of JFE Premium Connection		100%	-		M	Protector type: CENL with 3mm vent hole.
17	**STORAGE**	- Stacking.	- As per API RP 5C1 – Recommended Practice for Care and Use of Casing and Tubing	- QSP2000-ML17 – Packaging, Storing and Handling - WI3000-ML02 – Material, Handling and Storage.	- F3000-ML14 – Inventory Assessment	100%	-		-	
18	**PRODUCT RELEASE INSPECTION**	- Visual Thread Inspection - Storage compound coverage - Protector fitting	- As per requirement in QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-ML02 – Internal Work Order. - QSP2000-QC14 – Identification and Traceability.	- F3000-QC20 – Product Release	10%	-		H	

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		- Stencilling & colour band	- Thread shall be free from any defect. - Storage compound shall cover full thread and seal area. - Protector shall be snug tight. - Stencilling & colour band as per requirement.	- QSP2000-QC18 — Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - API Spec 5CT – Specification of Casing and Tubing - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads.						
19	**DELIVERY**	- Certificate of Conformance - Tally Sheet - Delivery Order - Documentation	- Within requirements in QSP2000-MR04 Control of Records.	- WI3000-ML22 – Delivery of Product. - QSP2000-MR04 – Control of Records. - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-QC20 - Product Release - F3000-ML03 - Material Log. - F3000-QC04 – Certificate of Conformance	M R	-		H RA	- Size/grade delivered loose.

M: Monitor

Include wide variety of action taken by charge person to inspect, check, control of activities and their sequence by means of observation, information, collection, notice, verify the routing and supporting documents (hardware and/or software) for the purpose of proper expedition. Any nonconformity found during above mentioned inspection shall be reported to CUSTOMER and CLIENT / END USER immediately.

W: WITNESS

Witness point is a designate point during or following and important activity at which inspection or examination may proceed through the designate witness point if the inspector is not present for the previously established activity. However, CUSTOMER are responsible to submit a check advice to parties. The agreement about time of notification will be finalized in PIM. In case of percentage witnessing, inspector shall witness the test of the indicated percentage from whole of percentage of tests. In case of finding non-conformity according to project requirements for percentage witnessing shall be increased twice; if another non-conformity found, then extent shall be changed to hold.

H: HOLD POINT

Hold point is a designate point during or following a specific activity at which inspection or examination shall not proceed unless the designate parties have witnessed the inspection and/or test. Based on place of inspection and mutual agreement, a written notice to a register check advice (notification) or other kind of official letter shall be handed over from CUSTOMER to parties. The agreement about time of notification will be finalized in PPM.

R: REVIEW

It is proceeded through reviewing any result of inspection or test as a method of ensuring that the inspection of test is performed in accordance with any approved procedures, specifications, or acceptance criteria. Inspection result shall be sent to Parties review, but presence of Parties at inspection time is not mandatory. Documents that review by TPA shall be signed and sealed as reviewed.

RA: REVIEW AND APPROVED

Documents reviewed by TPA shall be signed & sealed as reviewed and approved.

WR: RANDOM WITNESS

The inspection process includes random witnessing to ensure impartial evaluation and adherence to quality standards.

SOBENA OFFSHORE	SOBENA OFFSHORE INC SDN BHD (137601-A) KEMAMAN SUPPLY BASE, WAREHOUSE 25, P.O. BOX NO 95, 24007 KEMAMAN, TERENGGANU DARUL IMAN, MALAYSIA	QUALITY CONTROL PLAN	DOCUMENT NO.: SOI-QCP-01-25(KSB) P REV 0

CUSTOMER	MARUBENI-ITOCHU TUBULAR ASIA (MITA) / MAHARASHTRA SEAMLESS LIMITED (MSL)	**CONTRACT NO.**	GEMC-511687718726440	**DESCRIPTION**	THREADING OF JFELION SD57 CONNECTION – • R3 CASING (ON MAHARASHTRA SEAMLESS LIMITED PIPE)
END USER	OIL INDIA KAKINADA (KERALA-KONKAN BLOCK/KG BASIN)	**REVISION**	0		
LICENSOR	JFE	**DATE**	15th MAY 2025		
SIZE(S) & PPF	9 5/8”/ 53.5#	**APPLICABLE STANDARDS**		API SPEC 5CT, API RP 5A5, API SPEC 5B, PROPRIETARY CONNECTION SPECIFICATION – JFELION SD57	
GRADES	P110	**APPLICABLE CONTRACT SPECIFICATIONS**		N/A	

NOTES:

1) Processes that are listed in this QCP are solely based on SOI capabilities.
2) The applicability and requirements shall be based on the Individual Licensor’s Technical Package for each Premium Connection.
3) Notification for TPI to be done 48hrs before activity.
4) Any additional requirement beyond this QCP may be specified in addendum.

LEGENDS:

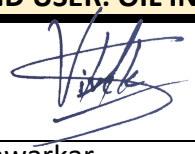
WI	WORK INSTRUCTION
SPEC	SPECIFICATION
IWO	INTERNAL WORK ORDER
SOI	SOBENA OFFSHORE INC.
API RP	API RECOMMENDED PRACTICE
QSP	QUALITY SYSTEM PROCEDURE

INSPECTION POINT:

H	HOLD POINT – 48 HRS NOTICE
M	MONITORING / RANDOM CHECK
100%	100% INSPECTION
R	DOCUMENTS REVIEW
RA	REVIEW & APPROVE
W	WITNESS – 48 HRS NOTICE
WR	RANDOM WITNESS

THIS QUALITY CONTROL PLAN IS SOLELY PROPRIETARY OF SOBENA OFFSHORE INC. SDN. BHD.

	SOBENA OFFSHORE INC SDN BHD		
SIGNATURE			
	Prepared by	Reviewed by	Reviewed by
NAME	AHMAD TARMIDZI JANTAN	MOHD NOOR B. SALLEH	IZNUL HADI B. PANIS
TITLE	QAQC MANAGER	OPERATION MANAGER	PLANT MANAGER
DATE	21st MAY 2025	21st MAY 2025	21st MAY 2025

	LICENSOR: JFE/JFETC	CUSTOMER: MITA/MSL	END USER: OIL INDIA KAKINADA
SIGNATURE	Terry Tan		 **Note:** Approved as it is proprietary connection
NAME	TERRY TAN		Vivek Sawarkar
TITLE	OPERATIONS MANAGER		SED
DATE	21 MAY 2025		02.06.2025

NO	ACTIVITY	INSPECTION	ACCEPTANCE CRITERIA *(*latest Revision)*	REFERENCE DOCUMENT *(*latest Revision)*	RECORD	INSPECTION INTERVENTION				REMARKS
						SOI	JFE	MITA / MSL	END USER / TPI	
1	**CONTRACT REVIEW**	- License to Manufacture - Materials and Consumable Stock - Technical Specification - Scope of Work - Production Schedule - Delivery Time	- Within specification and requirement in Purchase Order	- QSP2000-ML05 – Contract Review, Determination and Review of Requirements - QSP2000-MR07 – Process Control Documents and Quality Control Plan	- F3000-ML01 – Contract Review - F3000-ML02 – Internal Work Order	H R	-		RA	- Internal Work Order issued to plant once order is confirmed before process starts. - All reference standards shall be the latest revision.
2	**RECEIVING OF PIPES & COUPLING STOCK**	- 10% Visual Body Inspection - Dimensional check - ID/OD Wall Thickness, Length, and Straightness - Quantity Check - Materials Defect - Materials Identification (Heat Number, Mfg. number, Pipes & CS number and Lot Number)	- Within requirements in WI3000-ML01 – Receiving and Inspection of Product and Material - WI3000-ML02 – Product and Material Handling and Storage - Review of mill cert	- WI3000-ML01 – Receiving and Inspection of Product and Material - WI3000-ML02 – Material Handling and Storage - API Spec 5CT – Specification for Casing and Tubing	- F3000-ML03 - Material Log (Receiving data) - F3000-QC08 - Material Receiving Inspection (dimensional check)	10% or 100% H	-		-	As per SOI Incoming Inspection Plan – 10% or 100% if the Quantity is ≤ 10.
3	**RECEIVING OF SUPPORTING MATERIALS**	- CNC Program Verification - Gauge Calibration - Tooling Inspection - Insert Inspection - Storage Compound - Chemical - Thread protector	- Within specification and requirement in Purchase Order - Tooling – as per requirement - Insert – compare with connection overlay - Chemical and storage compound – refer to COA and SDS - Thread protector as per API 5CT Annex F (Class-designation: 5CTA)	- QSP2000-PC09 – Procurement Control - QSP2000-QC18 - Inspection/Test Status, Inspection, Testing, and Verification, and Product Release - SDS – Safety Data Sheet - COA – Certificate of Analysis	- F3000-PC15 – Incoming Good Material Inspection	H R	-		-	

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4	**SWAGING PLAIN END**	- Visual - Swage Length - To measure ID and OD pipe after swage. - Calculation for deformation.	Within requirements: - Internal Work Order - JFELION-TP-E-001 – Swaging Deformation and Stress Relieving Procedure for JFELION	- F3000-ML02 – Internal Work Order - JFELION-TP-E-001 – Swaging Deformation and Stress Relieving Procedure for JFELION - WI3000-PD03 – Swaging and Expanding - QSP2000-QC14 – Identification and Traceability. - QSP2000- QC18 - Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-PD11 – Record Sheet Swaging/ Expand	100%	M		R	- Swaging Procedure available for review at threading facility
5	**THREADING OF PIN**	- Thread gauging - Visual and Dimensional Thread and Seal. - First and Last Article Inspection. - Casting - Overlays Inspection - Gauge Calibration	- Dimension and visual inspection within requirement of JFELION-TP-G-001 – JFELION Thread Inspection and Gauging Procedure for Pin - JFELION Drawing (Pin) and Inspection Sheet - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing - No Burrs	- F3000-ML02 – Internal Work Order - JFELION-TP-G-001 – JFELION Thread Inspection and Gauging Procedure for Pin - JFELION Drawing (Pin) and Inspection Sheet - WI3000-PD06 – Threading of Pipe, Coupling and Accessories. - WI3000-QC19 – Gauging Pin and Box. - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and	- JFELION Inspection Sheet (Pin)	100%	M		R	- Traceability of gauging records to individual connection. - PU foam bung shall be used at pipe ID. - Nonconformance product shall be marked with red paint, segregated before proceeding with rework process. Type of reject shall be indicated on threading form and rejected pipe. Gauging procedures are available at threading facility. - Apply alternate Bore ID as per JFELION procedure.

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						SOI	JFE	MITA / MSL	END USER / TPI	
				Verification, and Product Release. - API Spec 5B – Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing						
6	**SURFACE TREATMENT OF PIN END**	- Visual Inspection. - Blasting shall cover all thread, shoulder area and seal area. - Check Roughness (RA) via profilometer only.	- Within requirements in JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connections. - Good surface. - No burrs.	- F3000-ML02 – Internal Work Order - JFELION-TP-D-001 – Process Control Procedure for Manufacturing of JFELION Connections - JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connections. - WI3000-PD09 – Bead Peening. - QSP2000-QC14 – Identification and Traceability. - QSP2000- QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-PD17 – Record Sheet - Blasting Field End / Mill End	100%	M		R	- Procedure available for review at threading facility - Media: Aluminium oxide - Required grit size: 54-100
7	**SAW CUT COUPLING**	- Saw cut length and square check - Straightness check - Traceability	- Within requirements in: - Internal Work Order (IWO)	- F3000-ML02 - Internal Work Order - WI3000-PD07 - Saw Cut and Marking OCTG	- F3000-PD14 – Record Sheet - Saw-cut Coupling	100%	-		-	

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						SOI	JFE	MITA / MSL	END USER / TPI	
			- API Spec 5CT - Specification of Casing and Tubing - Products for Use as Casing, Tubing, Coupling Stock, and Accessory Material - JFELION Technical Procedure - JFELION Drawing for (Box)	- QSP2000-QC14 – Identification and Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - JFELION Drawing (Box)						
8	**OD BLANKING COUPLING**	- Visual and Dimensional - Marking verification - Stamping verification - Traceability	- Within requirements in Licensor Technical procedure - JFELION Drawing for Box - Traceability marking	- F3000-ML02 - Internal Work Order - WI3000-PD08 - Blanking - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - JFELION Drawing (Box)	- F3000-PD13 – Record Sheet OD Blanking	100%	-		-	- Non-Conformance product marked with red paint, write details of nonconformance on coupling body and segregated.
9	**THREADING OF COUPLING** (Bevel 45°) Note: Any special bevel required shall be captured in addendum.	- Thread gauging - Visual and Dimensional Thread and Seal - First and Last Article Inspection - Casting - Overlays Inspection - Gauge Calibration	- Dimension and visual inspection within requirement of JFELION-TP-G-101 – JFELION Thread Inspection and Gauging Procedure for Box - JFELION Drawing (Box) - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads.	- F3000-ML02 - Internal Work Order - JFELION-TP-G-101 – JFELION Thread Inspection and Gauging Procedure for Box - JFELION Drawing (Box) and Inspection Sheet - WI3000-PD06 - Threading of Pipe, Coupling and Accessories	- JFELION Inspection Sheet (Box)	100%	M		R	- Traceability of gauging records to individual coupling. - Non-Conformance product shall be marked with red paint and segregated. Type of reject will be indicated on threading form and rejected coupling. - Procedure available for review at threading facility.

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						SOI	JFE	MITA / MSL	END USER / TPI	
			- API Spec 5CT - Specification of Casing and Tubing - No Burrs	- WI3000-QC19 – Gauging Pin and Box - QSP2000-QC14 – Identification and Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads. - API Spec 5CT - Specification of Casing and Tubing					
10	**MPI FOR COUPLING – (Magnetic Particle Inspection)**	- Visual Inspection on: Thread, Seal, OD & Bearing Face - Interpret and evaluate the discontinuity indications.	- Interpret and evaluate the discontinuity indications - Within requirements in WI3000-QC18 – Magnetic Particle Inspection - API Spec 5CT - Specification of Casing and Tubing - ASTM E709 – Standard Guide for Magnetic Particle Inspection - ASTM E1444 – Standard Practice for Magnetic Particle Inspection	- F3000-ML02 - Internal Work Order - WI3000-QC18 – Magnetic Particle Inspection - WI3000-QC23 – Written Practice for NDT - ASTM E709 – Standard Guide for Magnetic Particle Inspection - ASTM E1444 – Standard Practice for Magnetic Particle Inspection - E3024 / E3024M - Standard Practices for Magnetic Particle	- F3000-QC21 – Magnetic Particle Inspection	100%	M		R	- Longitudinal - Transverse ID and OD - Remark “OK” at the coupling OD to identify acceptance of MPI inspection. - To be removed at clean/coat process prior to delivery. - Perform by ASNT Level 2 Inspector.

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						SOI	JFE	MITA / MSL	END USER / TPI	
				Testing for General Industry - API Spec 5CT - Specification of Casing and Tubing						
11	**SURFACE TREATMENT OF COUPLING**	- Visual Inspection - Blasting shall cover all seal and shoulder area only.	- Within requirements in JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connection - Good surface. - No burrs.	- F3000-ML02 – Internal Work Order - JFELION-TP-D-001 - Process Control Procedure for Manufacturing of JFELION Connections - JFE-TP-H-001 – Bead Peening Treatment for JFE Premium Connection - WI3000-PD09 – Bead Peening. - QSP2000-QC14 – Identification and Traceability - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-PD16 – Record Sheet – Blasting Coupling	100%	M		R	- Procedure available for review at threading facility - Media: Aluminium oxide - Required grit size: 120-220
12	**PHOSPHATING OF COUPLING** (MATERIAL GRADE: CARBON STEEL LOW ALLOY)	- Coating type: Manganese Phosphate - VBI & VTI - Adhesion Test – Eraser	- Each product shall be visually inspected, and the coating should be a consistent greyish/ black finish with no voids or uncoated areas. - No Flacking or Peeling - JFE-TP-H-201 – Phosphate Procedure	- Internal Work Order (F3000-ML02) - WI3000-PD10 – Phosphating - JFE-TP-H-201 – Phosphate Procedure for JFE Premium Connections - API Spec 5B - Threading, Gauging and Inspection of Casing,	- F3000-PD19 – Phosphating Coupling	100%	M		R	- The non-conforming parts shall be stripped and reprocessed - Procedure available for review at threading plant - Coating weight: 9 – 43 g/m² (Frequency: Beginning of each shift)

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			for JFE Premium Connections - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads.	Tubing and Line Pipe Threads.						
13	**DRIFTING (Special Drift)**	- Drift dimension shall be verified - Full Length Drift	- The drift shall pass thru. - Within requirements in WI3000-PD12 – Drifting. - API Spec 5CT - Specification of Casing and Tubing - If found drift out of tolerance at the beginning of the shift, to inspect whole lot from previous shift.	- WI3000-PD12 - Drifting - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - F3000-MR32A- Drift Size - API Spec 5CT - Specification of Casing and Tubing	- F3000-QC17- Power Tong - F3000-QC19 – Final Inspection	100%	M		M	- Non-Conformance product marked with red paint and segregated. - FLD will be perform after make-up process. - Drift material: MC NYLON - Drift OD minimum dimension: **215.90 mm** - Drift Length minimum dimension: **305 mm**
14	**MAKE-UP PIN END WITH COUPLING**	- Visual Thread Inspection - Type of dope - Torque Values - Make-Up area - Feeler gauge - End Drift –from face to pass make up jaw area.	- Torque value / Make-up Graph are within requirements in: - JFE-TP-J-001 – JFE Connection Make-Up Procedure - JFELION-TP-J-101 – Make-Up Torque for JFELION Connections - Feeler gauge.	- F3000-ML02 – Internal Work Order - JFE-TP-J-001 – JFE Connection Make-Up Procedure - JFELION-TP-J-101 – Make-Up Torque for JFELION Connections - WI3000-PD13 – Buck on Coupling and Accessories.	- F3000-QC17 - Power Tong	100%	M		M	- Thread Compound: API Modified - Low Alloy Criteria: OD Size (inch) / Coupling OD Max Grip Mark (inch) as per API 5CT E.31 / Pipe OD Max Grip Mark as per API 5CT SR2 Requirement (JFE-TC Recommendation) 6 5/8" – 20" / 0.040 / 5% of Nominal Wall Thickness
15	**END FINISHING / STENCILLING**	- Visual Thread Inspection - Visual Body Inspection	- ID/OD Pipe shall be clean and free from scales.	- F3000-ML02 – Internal Work Order. - QSP2000-QC14 –	- F3000-QC19 – Final Inspection	100%	M		M	- Check ID free from foreign materials before close the protector.

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			- To ensure thread and pipe body are clear from any defect or dent.	Identification and Traceability. - QSP2000- QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.						
		- ID/OD Clean and Coat	- ID/OD Coating shall be as thin as possible if the pipes already been mill coated to ensure no overflow of coating excess when opening the thread protector.	- WI3000-PD15 – Clean and Coat - API Spec 5CT – Specification of Casing and Tubing	- F3000-QC19 – Final Inspection	100%	-		M	- ID Cleaning by using Mechanical brush/ Rattling Motor and high-pressure Air. - ID Coat: Synergen 718/Light oil (OPTIONAL) - OD Coat: Plusco 315
		- Tally from end of the box to end of the pin	- Within requirement API Spec 5CT – Specification of Casing and Tubing - Customer Requirement	- WI3000-PD15 – Clean and Coat - QSP2000-QC14 – Identification and Traceability.	- F3000-QC19 – Final Inspection	100%	-		M	- Calibrated measuring tape shall be used. - Tally in Meter (m) round to two decimal places.
		- Storage Compound	- Covered Fully on Threaded Surface	- QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.		100%	-		M	- OCTG Orange Kendex shall be used as storage compound.
		- Stencilling / colour band	- Stencilling 2' from box end. - Colour band as per requirement. - JFE-TP-K-001 – JFE Connection Stencilling Procedure	- WI3000-PD15 – Clean and Coat - JFE-TP-K-001 – JFE Connection Stencilling Procedure - QSP2000-QC14 – Identification and Traceability	- F3000-QC19 – Final Inspection	100%	M		M	- Details of marking on final product: TBA by MITA in every service instruction/order. Stencil low stress & Handheld inkjet marking shall include: 1. Connection name 2. Material grade 3. Connection size & weight 4. **Special drift (SD)** 5. Licensee code

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		- Tightening both end of protectors.	- Wrench tight. - JFE-TP-N-001 – Thread Protector of JFE Premium Connection	- QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - JFE-TP-N-001 – Thread Protector of JFE Premium Connection		100%	-		M	Protector type: CENL with 3mm vent hole.
16	**STORAGE**	- Stacking.	- As per API RP 5C1 – Recommended Practice for Care and Use of Casing and Tubing	- QSP2000-ML17 – Packaging, Storing and Handling - WI3000-ML02 – Material, Handling and Storage.	- F3000-ML14 – Inventory Assessment	100%	-		-	
17	**PRODUCT RELEASE INSPECTION**	- Visual Thread Inspection - Storage compound coverage - Protector fitting - Stencilling & colour band	- As per requirement in QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - Thread shall be free from any defect. - Storage compound shall cover full thread and seal area. - Protector shall be snug tight. - Stencilling & colour band as per requirement.	- F3000-ML02 – Internal Work Order. - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 —– Inspection/Test Status, Inspection, Testing, and Verification, and Product Release. - API Spec 5CT – Specification of Casing and Tubing - API Spec 5B - Threading, Gauging and Inspection of Casing, Tubing and Line Pipe Threads.	- F3000-QC20 – Product Release	10%	-		H	

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18	**DELIVERY**	- Certificate of Conformance - Tally Sheet - Delivery Order - Documentation	- Within requirements in QSP2000-MR04 Control of Records.	- WI3000-ML22 – Delivery of Product. - QSP2000-MR04 – Control of Records. - QSP2000-QC14 – Identification and Traceability. - QSP2000-QC18 – Inspection/Test Status, Inspection, Testing, and Verification, and Product Release.	- F3000-QC20 - Product Release - F3000-ML03 - Material Log. - F3000-QC04 – Certificate of Conformance	M R	-		H RA	- Size/grade delivered loose.

M: Monitor

Include wide variety of action taken by charge person to inspect, check, control of activities and their sequence by means of observation, information, collection, notice, verify the routing and supporting documents (hardware and/or software) for the purpose of proper expedition. Any nonconformity found during above mentioned inspection shall be reported to CUSTOMER and CLIENT / END USER immediately.

W: WITNESS

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The inspection process includes random witnessing to ensure impartial evaluation and adherence to quality standards.