



RG  
 P-00000  
 T-8-2 / T-8-3  
 Ref: 426958  
 OP#1296197

5 March 2004

Part no. 120630, 6" FIG 1002 Union Butt Weld Sch 160  
 Part no. 120640, 6" FIG 1002 Union Butt Weld Sch XXH  
 Part no. 130640, 6" FIG 1003 Union BW XXH  
 Part no. 9130640, 6" FIG 1003 Union with BW XXH (H2S)  
 Part no. 120530, 5" FIG 1002 Union Butt Weld Sch 160  
 Part no. 120540, 5" FIG 1002 Union Butt Weld Sch XXH  
 MAWP: 7,500 PSI  
 Corrosion Allowance: .118 inches  
 Minimum Design Temperature: -20°F  
 Drawings as per Attachment

Kemper Valve and Fittings  
 3001 Darrell Rd  
 Island Lake, IL 60042

Attention: Mr. Ken Klingbail

We have your letter of 18 February 2004 submitting copies of plans and documentation as listed therein on the above subject and with regard thereto have to advise that provided the details and arrangements be adhered to, the work is to the satisfaction of the Surveyors, and the Rules in all other respects are complied with, the same will be approved, in association with the following comments:

1. The design review of the subject equipment was in accordance with ABS "January 2004, Guide for the Certification of Drilling Systems" and is based on the following design conditions as specified in the submitted documentation:

*MAXIMUM WORKING PRESSURE: 7500 psi*  
*CORROSION ALLOWANCE: 3 mm / .118 inches*  
*MINIMUM DESIGN TEMPERATURE: -20°F*  
*H2S SERVICE (for Part no. 9130640 only)*

2. Hydrostatic tests for the subject Union Assemblies are to be carried out into final assembly to the satisfaction of the attending Surveyor.
3. Copies of the certified material test reports are to be made available to the attending Surveyor and are to be traceable to the material used in accordance with Section 6.13 of the January 2004 CDS Guide.
4. Non-destructive examination (NDE) is to be carried out in accordance with Section 7.11 of the January 2004 CDS Guide to the satisfaction of the attending Surveyor.



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5. Surveyor to verify the minimum forging reduction ratio of 3:1 in accordance with section 6.9.5 of January 2004 CDS Guide.
6. Welding is to be performed in accordance with the approved procedures. Procedure qualification records as well as production welding are to be to the satisfaction of the attending Surveyor.

An invoice to cover the cost of this review is enclosed. Please forward your remittance as per instructions on the invoice.

Documents submitted for our review are being retained for our records and files.

If we may be of further assistance, please do not hesitate to contact Raj Gadapa (281) 877-6232 or the undersigned at (281) 877-6640.

Very truly yours,

A handwritten signature in black ink that reads "Ken Huang". The signature is written in a cursive, flowing style.

Ken Huang  
Principal Engineer  
Offshore Engineering Department – Equipment Group

cc: ABS Chicago (F.O.) - w/ copy of invoice  
Mfg. File  
Project File - w/ print  
KYH



ATTACHMENT FOR ABS LETTER TO KEMPER VALVE AND FITTINGS  
DATED 5 MARCH 2004, REF: 426958

DOCUMENT LIST

	<u>DRAWING NUMBER</u>	<u>REV.</u>	<u>DESCRIPTION</u>
1.)	120630/120640	A	6" FIG # 1002 B/W XXH / 160 UNION
2.)	120631/120641	C	6" FIG # 1002 MALE
3.)	120632/120642	D	6" FIG # 1002 FEMALE
4.)	1206XXF	A	6" FIG #1002 MALE AND FEMALE B/W FORGING
5.)	120693	A	6" FIG # 1002 NUT
6.)	120693F	A	6" FIG # 1002 NUT FORGING
7.)	9130640	A	6" FIG # 1002 B/W XXH H2S
8.)	130640	A	6" FIG # 1002 B/W XXH UNION
9.)	130641	C	6" FIG # 1003 MALE
10.)	130642	C	6" FIG # 1002 FEMALE
11.)	1205XXF	A	6" FIG #1002 MALE AND FEMALE B/W FORGING
12.)	130693	A	6" FIG # 1002 NUT
13.)	130693F	D	6" FIG # 1003 NUT FORGING
14.)	120530/120540	A	5" FIG # 1002 B/W XXH / 160 UNION
15.)	120531/120541	C	5" FIG # 1002 MALE
16.)	120532/120542	D	5" FIG # 1002 FEMALE
17.)	1205X1F	A	5" FIG #1002 MALE AND FEMALE B/W FORGING
18.)	120593	A	5" FIG # 1002 NUT
19.)	120593F	A	5" FIG # 1002 NUT FORGING