



FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician:	Inspection Qualification:	Date. : 06/06/12.
Signature:	P.C.N. LEVEL 2	
Work Pack : : No. 642.	Drg No. : BC. 25 – 09.02. 11- H.	Inspection Part. CARRIAGEWAY GRILLAGE BARRIER HANDRAIL EXPANSION JOINT SECTIONS.. NORTH WEST MAINSPAN.

Inspection Document Conforming To BSEN 571-1:1997& BSEN1289:1998.
Additional Info see FETA WP 15 &16

Acceptance Standard:	BSEN 1289: 1998		
Acceptance Level:(Highlighted)	1	2	3
Area Examined:(BSEN571-1)	Welds & Heat Affected Zone		
Process Type(Highlighted)	Fluorescent	Colour Contrast	Combined
Type/Make of Consumables:	Rocol Flaw: Cleaner, Penetrant, Developer		
Method of Application:	Spraying/Brushing		
Penetration Time:	20mins to 30mins		
Development Time:	15mins		
Surface Condition:	As Welded	Dressed	
Surface Preparation:	Dry & free of all dirt, grease, scale, spatter, oil etc.		
Illumination:	Natural	Auxiliary	
Fabrication Stage:	Fabrication Complete.		
Purpose of Test:	To find all surface breaking defects/ indications.		
Name of Welder: S. WEST.	I.D. No: FE 003.		Results:



Locations inspected expansion joints at. PPs, 48,50,52,54,56 & 58 North west main-span. All section welded **butt joints** inspected visually & by liquid penetration testing. **12 in total inspected . All satisfactory.** All section vertical fillet joints **6 in total inspected . All satisfactory.** no relevant indications found. **Inner penetration of welded butt joints unable to be carried out.**

Results:

Accept:

YES

Reject:

