



FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician:	Inspection Qualification:	Date. 26/06/11
Signature:	P.C.N. LEVEL 2	
Work Pack . : 004	Drg No. :	Inspection Part. Kingpost No 24.

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:	I.D. No: FE. 002.	Results:
<u>Comments:</u> ALL WELDS VISUALLY INSPECTED 100%. ALL WELDS L.P.I. TESTED . ALL WELDS SATISFACTORY. LOCALIZED AREAS OF SLIGHT UNDERCUT EVIDENT. SPORADIC WELD SPATTER.		<u>Accept:</u> YES
		<u>Reject:</u>

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