



# FORTH ESTUARY TRANSPORT AUTHORITY

## L.P.I. WELD INSPECTION REPORT

Technician:	Inspection Qualification:	Date. <b>26/06/11</b>
Signature:	<b>P.C.N. LEVEL 2</b>	
Work Pack . : <b>004</b>	Drg No. :	Inspection Part. <b>Kingpost No 25.</b>

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)	<b>1</b> <b>2</b> <b>3</b>
Area Examined:(BSEN571-1)	Welds & Heat Affected Zone
Process Type( Highlighted)	<b>Fluorescent</b> <b>Colour Contrast</b> <b>Combined</b>
Type/Make of Consumables:	Rocol Flaw: Cleaner, Penetrant, Developer
Method of Application:	Spraying/ <b>Brushing</b>
Penetration Time:	20mins to 30mins
Development Time:	15mins
Surface Condition:	<b>As Welded</b> Dressed
Surface Preparation:	Dry & free of all dirt, grease, scale, spatter, oil etc.
Illumination:	<b>Natural</b> Auxiliary
Fabrication Stage:	Fabrication Complete.
Purpose of Test:	To find all surface breaking defects/ indications.

Name of Welder:	I.D. No: <b>FE. 002.</b>	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>  <b>YES</b>
		<u>Reject:</u>

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