



FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician:	Inspection Qualification:	Date: 01/09/08
Signature:	P.C.N. LEVEL 2	
Work Pack No. 4 Workshop fabrication	Drg No.	Inspection Part: KINGPOSTS
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:		Results:
<u>Comments:</u> Two kingposts were inspected, due to lack of I.D. I have numbered them kingpost KP001 & KP002. All welds passed, but both butt welds have had their cap welds removed, which causes concern when the job the kingpost does is taken into consideration, i.e. strength. KP001 also has a slight kick at the butt and the end plate (nearest the butt) is also off the square.		<u>Accept:</u>
		YES (welds only)
		<u>Reject:</u>