



## FORTH ESTUARY TRANSPORT AUTHORITY

### L.P.I. WELD INSPECTION REPORT

Technician:	Inspection Qualification:	Date. 13/08/09
Signature:	<b>P.C.N. LEVEL 2</b>	
Work Pack : <b>No. 004</b>	Drg No. : BC08 11-04-09	Inspection Part. . <b>KINGPOST REF. : KP011.</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)	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: <b>FE.003.</b>	Results:
<b>Comments:</b> WELD SPATTER EVIDENT ON LOCALISED AREAS OF WELD. SLIGHT UNDERCUT EVIDENT IN LOCALISED AREAS OF WELD. SOME WELD SPATTER INCLUSION. WELDS INSPECTED 100% VISUALLY & L.P.I		<u>Accept:</u>  <b><u>YES</u></b>
		<u>Reject:</u>