



FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician:	Inspection Qualification:	Date. 13/08/09
Signature:	P.C.N. LEVEL 2	
Work Pack . : No. 004	Drg No. : BC08 11-04-09	Inspection Part. . KINGPOST REF. : KP011.

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.003.	Results:
<u>Comments:</u> 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>
		<u>YES</u>
		<u>Reject:</u>