FORTH ROAD BRIDGE

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

Following the successful removal of the South Main Tower expansion joint plates ME3 & SE3, weld inspections were required to be carried out on randomly selected welds on both plates.

Prior to commencement of weld testing procedure, assistance was required to remove excessive paint protection from the welds selected for inspection. Heat treatment was applied and all paint removed. This ensured that an accurate method of inspection could be carried out as required.

Plate ME 3. Four in No locations were randomly selected. Photographs & information recorded below , with recorded Liquid penetration inspection records.

Plate SE. 3. Three in No locations were randomly selected. Photographs & information recorded below , with recorded Liquid penetration inspection records.

British Standards. :

Visual testing. : BS EN 13018. : 2001.
Penetrant testing of welds. Acceptance levels. BS EN 1289. : 1998.

It should be recorded that time restraints were placed on the amount of inspections and related information recorded due to event sequences, consultant inspections, remedial works and inclement weather. Following concerns, consultation with the maintenance manager was taken and following brief discussions, an agreement was reached and instruction was given to gather what relevant information that could be taken in the time possible.

It should be recorded that also that additional 10 mm packer plates were fitted behind support bearing block to remove deference of levels of ME3 tongue plate end and adjacent bitumen plate.

Weld inspection (Photographs) . M/E 3.

ME3 DEMAG POS. 7 INT GUIDE BLOCK WAS ALSO TESTED VISUALLY & LPI. No photograph taken. (INCLEMENT WEATHER) HEAVY RAIN

ME3 END BEARING BLOCK ON TONGUE PLATE (E) CLEANED.

ME3 END BEARING BLOCK ON ROCKER PLATE (E) SHOWING WELDS CLEANED & TESTED.

ME3 DEMAG POS. 14 INT GUIDE BLOCK W SHOWING WELDS TESTED & INSPECTED

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

Weld inspections . (Photographs) S/E 3.

SE3. END BEARING BLOCK ON ROCKER PLATE (E) TESTED & INSPECTED

SE3. DEMAG POS. 4 INT GUIDE BLOCK TESTED & INSPECTED

SE3. END BEARING BLOCK ON TONGUE PLATE (E) TESTED & INSPECTED

FORTH ROAD BRIDGE

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician: Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date. **08/10/11**
Work Pack . : N/A	Drg No. : N/A	Inspection Part. **ME3 DEMAG POS. 7 INT GUIDE BLOCK**

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: N/A	I.D. No: **N/A**	Results:
Comments: Inspection of existing welds by Visual testing and Liquid penetrant testing as specified **to British standards** : BS EN 13018. : 2001.. BS EN 1289. : 1998 . These tests were carried out determine if any **NEW** defects have appeared, other than any old defects. No new defects found. Only defects to be found were original: small indications of defects. No new defects found.		Accept: YES Reject:

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician: Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date. **08/10/11**
Work Pack . : N/A	Drg No. : N/A	Inspection Part. **ME3 DEMAG POS. 14 INT GUIDE BLOCK**
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: N/A	I.D. No: N/A	Results:

Comments: Inspection of existing welds by Visual testing and Liquid penetrant testing as specified **to British standards** : BS EN 13018. : 2001.. BS EN 1289. : 1998 . These tests were carried out determine if any **NEW** defects have appeared, other than any old defects. No new defects found. Only defects to be found were original: small indications of defects.
No new defects found.

Accept:

YES

Reject:

FORTH ROAD BRIDGE

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician:. Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date. **08/10/11**
Work Pack . : N/A	Drg No. : N/A	Inspection Part. **ME3 END BEARING BLOCK ON ROCKER PLATE (E)**

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: **N/A**	I.D. **N/A**	Results:

Comments: Inspection of existing welds by Visual testing and Liquid penetrant testing as specified **to British standards** : BS EN 13018. : 2001.. BS EN 1289. : 1998 . These tests were carried out determine if any **NEW** defects have appeared, other than any old defects. No new defects found. Only defects to be found were original: small indications of defects. No new defects found.

Accept:

YES

Reject:

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician: Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date.**08/10/11**
Work Pack . : N/A	Drg No. : N/A	Inspection Part. **ME3 END BEARING BLOCK ON TONGUE PLATE (E)**

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	
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Name of Welder: N/A	I.D. No:**N/A**	Results:
Comments: Inspection of existing welds by Visual testing and Liquid penetrant testing as specified **to British standards** : BS EN 13018. : 2001.. BS EN 1289. : 1998 . These tests were carried out determine if any **NEW** defects have appeared, other than any old defects. No new defects found. Only defects to be found were original: small indications of defects. No new defects found.		Accept: YES
		Reject:

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician: Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date. **08/10/11**
Work Pack . : **N/A**	Drg No. : **N/A**	Inspection Part. **SE3. END BEARING BLOCK ON TONGUE PLATE (E)**

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	
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Purpose of Test:	To find all surface breaking defects/ indications.	

Name of Welder: **N/A**	I.D. No: **N/A**	Results:
Comments: Inspection of existing welds by Visual testing and Liquid penetrant testing as specified **to British standards** : BS EN 13018. : 2001.. BS EN 1289. : 1998 . These tests were carried out determine if any **NEW** defects have appeared, other than any old defects. No new defects found. Only defects to be found were original: small indications of defects. No new defects found.		Accept: YES Reject:

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician: Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date. **08/10/11**
Work Pack . : **N/A**	Drg No. : **N/A**	Inspection Part. **SE3. END BEARING BLOCK ON ROCKER PLATE (E)**

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	
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FORTH ROAD BRIDGE

INSPECTION DEPARTMENT
Weld inspections. ME 3 & SE 3. .
DATE. 08/10/11.

FORTH ROAD BRIDGE

FORTH ESTUARY TRANSPORT AUTHORITY

L.P.I. WELD INSPECTION REPORT

Technician:. Signature:	Inspection Qualification: **P.C.N. LEVEL 2**	Date. **08/10/11**
Work Pack . : **N/A**	Drg No. : **N/A**	Inspection Part. **SE3. DEMAG POS. 4 INT GUIDE BLOCK**
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	
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