

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. <u>Four in No locations</u> were randomly selected. Photographs & information recorded below, with recorded Liquid penetration inspection records.

Plate SE. 3. <u>Three in No locations</u> 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.





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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



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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



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L.P.I. WELD INSPECTION REPORT				
Technician:	Inspection Qualification:	Date. 08/1	0/11	
Signature:	P.C.N. LEVEL 2			
Work Pack .: N/A	Drg No. : N/A	DEMAG P	Part. ME3 POS. 7 INT LOCK	
Inspection Document Conforming 1 Additional Info see FETA WP 15 &		1289:1998.		
Acceptance Standard:	BSEN 1289: 1998			
Acceptance Level:(Highlighted)	1 <mark>2</mark>	(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/ indic	cations.	
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.			Accept: YES	
No new defects found.			Reject:	



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L.P.I. WELD INSPECTION REPORT				
Technician:	Inspection Qualific	ation:	Date. 08/10)/11
Signature:	P.C.N. LEVEL 2			
Work Pack . : N/A	Drg No. : N/A		Inspection I DEMAG PO GUIDE BLO	OS. 14 INT OCK
Inspection Document Conforming To Info see FETA WP 15 &16	3SEN 571-1:1997&	BSEN128	39:1998.	Additional
Acceptance Standard:	BSEN 1289: 1998			
Acceptance Level:(Highlighted)	1	2	3	
Area Examined:(BSEN571-1)	Welds & Heat Affe	cted Zone	9	
Process Type(Highlighted)	Fluorescent Combined		olour Contrast	
Type/Make of Consumables:	Rocol Flaw: Clean	er, Penet	rant, 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 dir	t, grease	, scale, spatter, o	il etc.
Illumination:	Natural		Auxiliary	
Fabrication Stage:	Fabrication Comple	ete.		
Purpose of Test:	To find all surface	breaking	defects/ indicatio	ns.
Name of Welder: N/A	I.D. No: N	'A		Results:
<u>Comments:</u> 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 <u>NEW</u> 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:	



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L.P.I. WELD INSPECTION REPORT				
Technician:		tion Qualification:	Date. 08/1	0/11
Signature:		. LEVEL 2		
Work Pack . : N/A		o. : N/A	BEARING BLO PLATE (E)	Part. ME3 END OCK ON ROCKER
Inspection Document Conforming Additional Info see FETA WP 15 &		N 571-1:1997& BSI	EN1289:1998.	
Acceptance Standard:	BSEN	1289: 1998		
Acceptance Level:(Highlighted)		1	<mark>2</mark>	3
Area Examined:(BSEN571-1)	Welds	& Heat Affected Zo	one	
Process Type(Highlighted)	Fluore		Colour Contra	st
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:		ation Complete.		
Purpose of Test:	To find	d all surface breaking	ng defects/ indic	ations.
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:	



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L.P.I.	WELD INSPECTION REPO	ORT			
Technician:	Inspection Qualification:	Date. 08/1	0/11		
Signature:	P.C.N. LEVEL 2				
Work Pack . : N/A	Drg No. : N/A	BEARING BLO PLATE (E)	Part. ME3 END OCK ON TONGUE		
Inspection Document Conforming Additional Info see FETA WP 15		EN1289:1998.			
Acceptance Standard:	BSEN 1289: 1998				
Acceptance Level:(Highlighted)	1	<mark>2</mark>	3		
Area Examined:(BSEN571-1)	Welds & Heat Affected Z	one			
Process Type(Highlighted)	Fluorescent Combined	Colour Contra	st		
Type/Make of Consumables:	Rocol Flaw: Cleaner, Per	netrant, Develop	er		
Method of Application:	Spraying/Brushing				
Penetration Time:	20mins to 30mins	20mins to 30mins			
Development Time:	15mins				
Surface Condition:	As Welded	Dressed			
Surface Preparation:	Dry & free of all dirt, grea	Dry & free of all dirt, grease, scale, spatter, oil etc.			
Illumination:	Natural	Auxiliary			
Fabrication Stage:	Fabrication Complete.	•			
Purpose of Test:	To find all surface breaki	ng defects/ indic	ations.		
Name of Welder: N/A	I.D. No: N/A		Results:		
Comments: Inspection of existin					
penetrant testing as specified to BS EN 1289. : 1998. These tests we			Accept:		
defects have appeared, other tha			YES		
Only defects to be found were ori	,		. 20		
No new defects found.			Reject:		



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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	BEARING BL PLATE (E)	n Part. se3. end ock on tongue			
	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 Zor	ne				
Process Type(Highlighted)	Fluorescent Combined	olour Contra	st			
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 Natural	Auxiliary				
Fabrication Stage:	Fabrication Complete.	•				
Purpose of Test:	To find all surface breaking	g defects/ indic	ations.			
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:			



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L.P.I. WELD INSPECTION REPORT				
Technician:	Inspection Qualification:	Date. 08/10/11		
Signature:	P.C.N. LEVEL 2			
Work Pack . : N/A	Drg No. : N/A	Inspection Part. se3. end BEARING BLOCK ON ROCKER PLATE (E)		
Inspection Document Conformir Additional Info see FETA WP 15	ng To BSEN 571-1:1997& BSEN128 5 &16	9:1998.		
Acceptance Standard:	BSEN 1289: 1998			
Acceptance Level:(Highlighted)	1 <mark>2</mark>	3		
Area Examined:(BSEN571-1)	Welds & Heat Affected Zone			
Process Type(Highlighted)	Fluorescent Colour C Combined	ontrast		
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 Dr	essed		
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	Results:			
	ing welds by Visual testing and Liqui			
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	YES			
Only defects to be found were original: small indications of defects.				
No new defects found.		Reject:		



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L.P.I. WELD INSPECTION REPORT				
Technician:	Inspection Qualification		Date. 08/	10/11
Signature:	P.C.N. LEVEL 2			
Work Pack . : N/A	Drg No. : N/A		POS. 4 INT GI	n Part. se3. demag UIDE BLOCK
Inspection Document Conforming Info see FETA WP 15 &16	8.	Additional		
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	20mins to 30mins		
Development Time:	15mins			
Surface Condition:	As Welded	Dre	ssed	
Surface Preparation:	Dry & free of all dirt, gre	ase, scale, sp	oatter, oil e	tc.
Illumination:	Natural Natural	А	uxiliary	
Fabrication Stage:	Fabrication Complete.			
Purpose of Test:	To find all surface break	king defects/ i	ndications.	
Name of Welder: N/A I.D. No: N/A				Results:
Comments: Inspection of existing				
testing as specified to British standards: BS EN 13018.: 2001 BS EN 1289.:				Accept:
1998 . These tests were carried out de	<u> </u>	ts have appe	ared,	
other than any old defects. No new defects found. Only defects to be found were original: small indications of defects.No new			147	YES
defects found.	jiriai. Siriaii iiiUlCaliUliS Ul U	ierecto.INO He	vv	Dainat
dologio lodila.				<u>Reject:</u>



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