



FORTH ESTUARY TRANSPORT AUTHORITY

**L.P.I. WELD INSPECTION REPORT**

Technician:	Inspection Qualification:	Date. <b>22/11/10</b>
Signature:	<b>P.C.N. LEVEL 2</b>	
Work Pack . : <b>004</b>	Drg No. : N/A	Inspection Part. <b>Kingpost no 22.</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)	<b>1</b>	<b>2</b>	<b>3</b>
Area Examined:(BSEN571-1)	Welds & Heat Affected Zone		
Process Type( Highlighted)	<b>Fluorescent</b>	<b>Colour Contrast</b>	<b>Combined</b>
Type/Make of Consumables:	Rocol Flaw: Cleaner, Penetrant, Developer		
Method of Application:	Spraying/ <b>Brushing</b>		
Penetration Time:	20mins to 30mins		
Development Time:	15mins		
Surface Condition:	<b>As Welded</b>	Dressed	
Surface Preparation:	Dry & free of all dirt, grease, scale, spatter, oil etc.		
Illumination:	<b>Natural</b>	Auxiliary	
Fabrication Stage:	Fabrication Complete.		
Purpose of Test:	To find all surface breaking defects/ indications.		

Name of Welder:	I.D. No: <b>FE. 002.</b>	Results:
<u>Comments:</u> ALL WELDS VISUALLY INSPECTED 100%. ALL WELDS L.P.I. TESTED . ALL WELDS SATISFACTORY. LOCALIZED AREAS OF SLIGHT UNDERCUT EVIDENT.		<u>Accept:</u>
		<b>YES</b>
		<u>Reject:</u>

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