

# Liquid Penetrant Examination Report

Procedure: WI-10-26 (Revision 10/20/04)		Developer Type: Magnaflux SKD-SZ		Lighting: General lighting assisted by portable lighting, 100 F.T.C. minimum			
Liquid Penetrant Type: Visible		Cleaner: Spot Check: SKC-5					
Penetrant Type: Magnaflux SKL-WP or SKL-HF/SKL-6		All Personnel Certified to ASME and SNT-TC-1A Level II					
<p><b>Use the following abbreviations for Material Thickness of items tested:</b></p> <p>Mat'l Thickness: HB) Header Body EP) End Piece(s) N) Nozzle D) Disk PP) Perforated Plate SP) Splitter Plate MS) Mercury Strips          G) Gusset(s) IN) Injection Nozzle TJ) Transition Joint E) Elbow SGP) Sparge Pipe</p> <p><b>Use the following abbreviations for Mapped Indications of items tested:</b></p> <p><i>If more than one indication of the same type is on the same weld joint use the following abbreviation: (#) (Where # is the number of indications).</i>  <b>Material Description:</b> 1) End Piece/Header Body Welds 2) Nozzle/Header Body Welds 3) Header Body Seam Welds 4) Nozzle Seam Welds 5) Perm. Disk          6) Perm. Disk/Nozzle Weld 7) Pipe Seam Weld 8) Elbow Seam Weld 9) Transition Seam Weld 10) Mercury Strip Welds 11) Perforated Plate Welds          12) Splitter Plate 13) Sparge Pipe Welds 14) Header Body Material 15) Nozzle Material 16) Mitered End Piece Material</p> <p><b>Indication:</b> 0) No Indications 1) Linear 3) Porosity 4) Non-Fusion 5) Cold Roll 6) Splitter 7) Lamination Relevant Indications: N) Non-rejectable R) Rejectable (Must Repair)</p> <p><b>Use the following abbreviations for accepting/rejecting of item tested</b></p> <p>Results: A) Accepted R) Rejected AR) Accepted after Repair(s)</p> <p><b>Example of a Mapped Indication:</b> A pipe seam weld with 4 relevant linear indications that needs repaired would be (4)7-2-R (if it were only 1 repair it would just be 7-2-R)</p>							
		Sales Order #		509.8-10			
Item # (s)	Description of Weld Joint or Material LPT Examined	Material & Thickness	Map of Indications	Test Date	Test Time	Examiner	Results
1302	A-IN	5083 MATERIAL (HB.375)&(EP1.00)&(N.375W)	0	3/2/2005	05:30	P4 WOODY	A
1303	A-OUT	5083 MATERIAL (HB.250)&(EP.500)&(N.322W) (PERM. DISK .625)	0	3/2/2005	04:30	P4 WOODY	A
1304	B-IN	(HB1.00)(EP1.00)(N.432)	1-2-R 2-1-R	3/1/2005	0745	P7/P7	AR
1305	B-OUT	HB.750-EP.750-N.432	0	3/1/2005	1230	P14	A
1306	C-IN	(HB.750)(EP.750)(N.237)	0	2/27/2005	1100	P7	A
1307	C-OUT	5083 MATERIAL (HB.375)&(EP.625)&(N.216W)	0	3/4/2005	06:00	P4 WOODY	A
1308	D-IN	(HB.375)(EP.625)(N.154)	0	3/1/2005	0845	P7	H
1309	D-OUT	(HB.500)(EP1.00)(N.237)	0	2/28/2005	1030	P7	A

# Liquid Penetrant Examination Report

Procedure: WI 10-26 (Revision 10/20/04) Liquid Penetrant Type: Visible Penetrant Type: Magnaflux SKL-WF or SKL-HF/SKL-6		Developer Type: Magnaflux SKD-S2 Cleaner: Spot Check SKC-5 All Personnel Certified to ASME and SNT-TC-1A Level II		Lighting: General lighting assisted by portable lighting, 100 Ftc minimum			
<b>Mat'l Thickness: HB) Header Body EP) End Piece(s) N) Nozzle D) Disk PP) Perforated Plate SP) Splitter Plate MS) Mercury Strips</b> <b>G) Gusset(s) IN) Injection Nozzle TJ) Transition Joint E) Elbow SGP) Sparge Pipe</b>							
<b>Use the following abbreviations for Material Thickness of Items tested:</b>							
<b>Use the following abbreviations for Mapped Indications of Items tested:</b>							
<b>If more than one indication of the same type is on the same weld joint use the following abbreviation: (#) (Where # is the number of indications)</b> <b>Material Description:</b> 1) End Piece/Header Body Welds 2) Nozzle/Header Body Welds 3) Header Body Seam Welds 4) Nozzle Seam Welds 5) Perm. Disk 6) Perm Disk/Nozzle Weld 7) Pipe Seam Weld 8) Elbow Seam Weld 9) Transition Seam Weld 10) Mercury Strip Welds 11) Perforated Plate Welds 12) Splitter Plate 13) Sparge Pipe Welds 14) Header Body Material 15) Nozzle Material 16) Mitered End Piece Material <b>Indication:</b> 0) No Indications 1) Rounded 2) Linear 3) Porosity 4) Non-Fusion 5) Cold Roll 6) Splatter 7) Lamination Relevant Indications: N) Non-rejectable R) Rejectable (Must Repair)							
<b>Use the following abbreviations for accepting/rejecting of item tested</b> Results: A) Accepted R) Rejected AR) Accepted after Repair(s)							
Example of a Mapped Indication: A pipe seam weld with 4 relevant linear indications that needs repaired would be (4)7-2-R (if it were only 1 repair it would just be 7-2-R)							
		Sales Order #		509.8-10			
Item # (s)	Description of Weld Joint or Material LPT Examined	Material & Thickness	Map of Indications	Test Date	Test Time	Examiner	Results
1310	E-IN	5083 MATERIAL (HB.203W)&(EP.375)&(N.145W)	0	3/2/2005	04:00	P4 WOODY	A
1311	E-OUT	(HB.375)(EP1.00)(N.216C)	0	2/28/2005	1300	P7	A
1312	F-IN	HB.250-EP.375-N.365	0	3/1/2005	1100	P14	A
1313	F-OUT	(HB.250)(EP.375)(N.375)	0	3/1/2005	1100	P7	A
1314	G-IN	5083 MATERIAL (HB..250)&(EP.375)&(N.250)	0	3/3/2005	01:00	P4 WOODY	A
1315	G-OUT	(HB.250)(EP.500)(N.250)	0	3/2/2005	1300	P7	A
1477	PERM DISK B/4	(D.625)	0	2/24/2005	0930	P7	A
1464	NOZZEL SEAM	(N.250)	0	2/28/2005	0945	P7	A

# Liquid Penetrant Examination Report

Procedure: WI 10-26 (Revision 10/20/04)		Developer Type: Magnaflux SKD-S2		Lighting: General lighting assisted by portable lighting, 100 F1C minimum	
Liquid Penetrant Type: Visible		Cleaner: Spot Check: SKC-5			
Penetrant Type: Magnaflux SKL-WP or SKL-HF/SKL-6		All Personnel Certified to ASME and SNT-TC-1A Level II			
<p><b>Use the following abbreviations for Material Thickness of items tested:</b></p> <p>Mat'l Thickness: HB) Header Body EP) End Piece(s) N) Nozzle D) Disk PP) Perforated Plate SP) Splitter Plate MS) Mercury Strips          G) Gusset(s) IN) Injection Nozzle T-J) Transition Joint E) Elbow SGP) Sparge Pipe</p>					
<p><b>Use the following abbreviations for Mapped Indications of items tested:</b></p> <p><i>If more than one indication of the same type is on the same weld joint use the following abbreviation: (#) (Where # is the number of indications)</i></p> <p><b>Material Description:</b> 1) End Piece/Header Body Welds 2) Nozzle/Header Body Welds 3) Header Body Seam Welds 4) Nozzle Seam Welds 5) Perm. Disk          6) Perm. Disk/Nozzle Weld 7) Pipe Seam Weld 8) Elbow Seam Weld 9) Transition Seam Weld 10) Mercury Strip Welds 11) Perforated Plate Welds          12) Splitter Plate 13) Sparge Pipe Welds 14) Header Body Material 15) Nozzle Material 16) Mitered End Piece Material  <b>Indication:</b> 0) No Indications 1) Rounded 2) Linear 3) Porosity 4) Non-Fusion 5) Cold Roll 6) Splatter 7) Lamination Relevant Indications: N) Non-rejectable R) Rejectable (Must Repair)</p>					
<p><b>Use the following abbreviations for accepting/rejecting of item tested</b></p> <p>Results: A) Accepted R) Rejected AR) Accepted after Repair(s)</p>					
<p><b>Example of a Mapped Indication:</b> A pipe seam weld with 4 relevant linear indications that needs repaired would be (4)7-2-R (if it were only 1 repair it would just be 7-2-R)</p>					
		Sales Order #		509.8-10	
Item # (s)		Description of Weld Joint or Material LPT Examined		Material & Thickness	
1468		NOZZEL SEAM		(N.250)	
		Map of Indications		O	
		Test Date		2/28/2005	
		Test Time		0945	
		Examiner		P7	
		Results		A	

# LIQUID PENETRANT EXAMINATION REPORT

Procedure: WI 10-26 (Revision 10/20/04)  
 Liquid Penetrant Type: Visible  
 Penetrant Type: Magnaflux SKL-WP or SKL-HF/SKL-6  
 Developer Type: Magnaflux SKD-S2  
 Cleaner: Spot Check: SKC-5  
 All Personnel Certified to ASME and SNT-TC-1A Level II  
 Lighting: General lighting assisted by portable lighting, 100 FTC minimum

Area Being Examined	Examiner	Test Date & Time	Weld Joint	Material & Thickness	Map of Indications	Results
A IN			HDR TO CORE	HB .375 N. 375	0	A
A OUT			HDR TO CORE	HB .250 N. 322	0	A
B IN			HDR TO CORE	HB 1.0 N. 452	IN (.12)	A
B OUT			HDR TO CORE	HB .750 N. 216	0	A
C IN			HDR TO CORE	HB .750 N. 237	0	A
C OUT			HDR TO CORE	HB .375 N. 216 N. 237	0	A
D IN			HDR TO CORE	HB .375 N. 194	0	A
D OUT			HDR TO CORE	HB .500 .237	0	A
E IN			HDR TO CORE	HB .103 N. 145	0	A
E OUT			HDR TO CORE	HB .375 N. 246	0	A
F IN			HDR TO CORE	HB .250 N. 365	0	A
F OUT			HDR TO CORE	HB .250 N. 375	IN (.12)	A
G IN			HDR TO CORE	HB .250 N. 250	0	A
G OUT			HDR TO CORE	HB .250 N. 250	0	A
ANGLE			EDGE		2N (.19)	A
ANGLE			FILLET		2N (.19)	A