

Liquid Penetrant Examination Report

Procedure: WI 10-26 (Revision 10/20/04) Liquid Penetrant Type: Visible Penetrant Type: Magnalux SKL-WP or SKL-HF/SKL-6		Developer Type: Magnalux SKD-52 Cleaner: Spot Check: SKC-5 All Personnel Certified to ASME and SNT-TC-1A Level II		Lighting: General lighting assisted by portable lighting, 100 FC minimum			
Use the following abbreviations for Material Thickness of Items tested: 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							
Use the following abbreviations for Mapped Indications of Items tested: <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> Material Description: 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 Indication: 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)							
Use the following abbreviations for accepting/rejecting of item tested 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 #	509.8-11				
Item # (s)	Description of Weld Joint or Material LPT Examined	Material & Thickness	Map of Indications	Test Date	Test Time	Examiner	Results
1302	A-IN	(HB.375)&(EP1.00)&(N.375W)	0	3/3/2005	06:00	P4 WOODY	A
1303	A-OUT	(HB.250)(EP.500)(N.322) (D.625)	0	3/10/2005	0845	P7	A
1304	B-IN	(HB1.00)(EP1.00)(N.432)	2-1-N	3/2/2005	1145	P7	A
1305	B-OUT	HB.750 EP.750 N.432W	0	3/7/2005	1300	P6	A
1306	C-IN	(HB.750)&(EP.750)&(N.237W)	0	3/3/2005	02:00	P4 WOODY	A
1307	C-OUT	(HB.375)&(EP.625)&(N.216W)	0	3/3/2005	02:00	P4 WOODY	A
1308	D-IN	(HB.375)&(EP.625)&(N.154W)	0	3/3/2005	00:30	P4 WOODY	A
1309	D-OUT	(HB.500)(EP1.00)(N.237)	2-1-N	3/2/2005	1300	P7	A

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Procedure: WI 10-26 (Revision 10/20/04)		Developer Type: Magnaflux SKO-S2		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>Use the following abbreviations for Material Thickness of items tested:</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</p> <p>G) Gusset(s) IN) Injection Nozzle TJ) Transition Joint E) Elbow SGP) Sparge Pipe</p>							
<p>Use the following abbreviations for Mapped Indications of items tested:</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>Material Description: 1) End Piece/Header Body Welds 2) Nozzle/Header Body Welds 3) Header Body Seam Welds 4) Nozzle Seam Welds 5) Perm. Disk</p> <p>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</p> <p>12) Splitter Plate 13) Sparge Pipe Welds 14) Header Body Material 15) Nozzle Material 16) Mitered End Piece Material</p> <p>Indication: 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>Use the following abbreviations for accepting/rejecting of item tested</p> <p>Results: A) Accepted R) Rejected AR) Accepted after Repair(s)</p>							
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 #		509.8-11					
Item # (s)	Description of Weld Joint or Material LPT Examined	Material & Thickness	Map of Indications	Test Date	Test Time	Examiner	Results
1310	E-IN	(HB.203)(EP.375)(N.145)	14-1-N	3/4/2005	1100	P7	A
1311	E-OUT	(HB.375)(EP1.00)(N.216)	0	3/2/2005	0945	P7	A
1312	F-IN	(HB.250)&(EP.375)&(N.365W)	0	3/4/2005	03:00	P4 WOODY	A
1313	F-OUT	(HB.250) &(EP.375)&(N.375W)	0	3/4/2005	03:00	P4 WOODY	A
1314	G-IN	HB.250 EP.375 N.250	0	3/7/2005	1000	P6	A
1315	G-OUT	(HB.250)&(EP.500)&(N.250)	0	3/4/2005	06:30	P4 WOODY	A
1464	NOZZLE SEAM	(N.250)	0	2/28/2005	0730	P7	A
1468	NOZZLE SEAM	(N.250)	0	2/28/2005	0730	P7	A

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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 F-1C minimum	
Use the following abbreviations for Material Thickness of items tested: 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					
Use the following abbreviations for Mapped Indications of items tested: <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> Material Description: 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 Indication: 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)					
Use the following abbreviations for accepting/rejecting of item tested 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 #		509.8-11			
Item # (s)	Description of Weld Joint or Material LPT Examined	Material & Thickness	Map of Indications	Test Date	Test Time
1477	PERM DISK B/4	(D.625)	0	3/2/2005	1145
				P7	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	PK	3-15-05	FILET	HB .375 N .375	0	A
A OUT	PK	3-15-05	FILET	HB .250 N .322	0	A
B IN	PK	3-15-05	FILET	HB 1.0 N .432	0	A
B OUT	PK	3-15-05	FILET	HB .750 N .432	0	A
C IN	PK	3-15-05	FILET	HB .750 N .237	0	A
C OUT	PK	3-15-05	FILET	HB .375 N .216	0	A
D IN	PK	3-15-05	FILET	HB .375 N .154	0	A
D OUT	PK	3-15-05	FILET	HB .500 N .237	0	A
E IN	PK	3-15-05	FILET	HB .203 N .145	0	A
E OUT	PK	3-15-05	FILET	HB .375 N .216	0	A
F IN	PK	3-15-05	FILET	HB .250 N .365	2 (19) R	RA
F OUT	PK	3-15-05	FILET	HB .250 N .375	0	A
G IN	PK	3-15-05	FILET	HB .250 N .250	0	A
G OUT	PK	3-15-05	FILET	HB .250 N .250	3 0	A
ANGLE	PK	3-15-05	FILET		2 (1.250)	RA
ANGLE	PK	3-15-05	FILET		2 (19)	RA