

rotterdam nuclear



NONDESTRUCTIVE EXAMINATION REPORT		Report No. 30810-61150-002-00-3220
Customer : Cockerill	Customer Ref. : 0/61/31285	Item description: Spherical Ring 002
Manufact. Order: 30810	Sub order : 61150	Part examined: Complete
Sequence : 3220	Drawing : ED 006 -1-1	Inspection by: Cockerill
Item : 002		Primatoms RN/DO

Description of Examination

MT	A.C. D.C. _____ Prod Yoke Coil Central conductor _____	Dry Wet Fluorescent
	Apparatus: _____ No.: ID- _____	Type of powder: _____
	Prod distance: _____	Oil water suspended
	Ampere per inch: _____	Degmagnalised: yes/no
	Ampere turns: _____	
Specification: _____		
PT	Colour contrast Fluorescent	
	Type penetrant: _____	batch no.: _____
	Type cleaner: _____	batch no.: _____
	Type devel per: _____	batch no.: _____
	Specification: _____	
0 0 0 UT	Long Shear _____ Time base: <i>500</i> _____ mm.	Amplification: _____
	Apparatus: <i>1500</i> _____ No.: ID- <i>311</i>	<i>400</i> _____
	Transducers: <i>Sp & wave (Luna)</i>	
	Couplant: <i>oil</i>	
	Reference standard No.: <i>india</i>	
Specification: <i>PS 31.61 rev.4 + app. rev.1.</i>		

Other Tests:

Surface condition: *inspected*

Results:

<input checked="" type="checkbox"/> ACCEPTABLE
<input type="checkbox"/> REPORTABLE INDICATIONS
<input type="checkbox"/> NOT ACCEPTABLE

Remarks:

Attachments: *2*

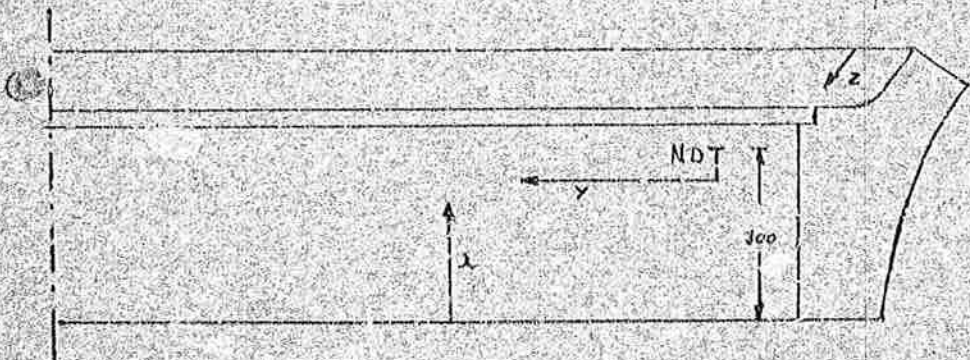
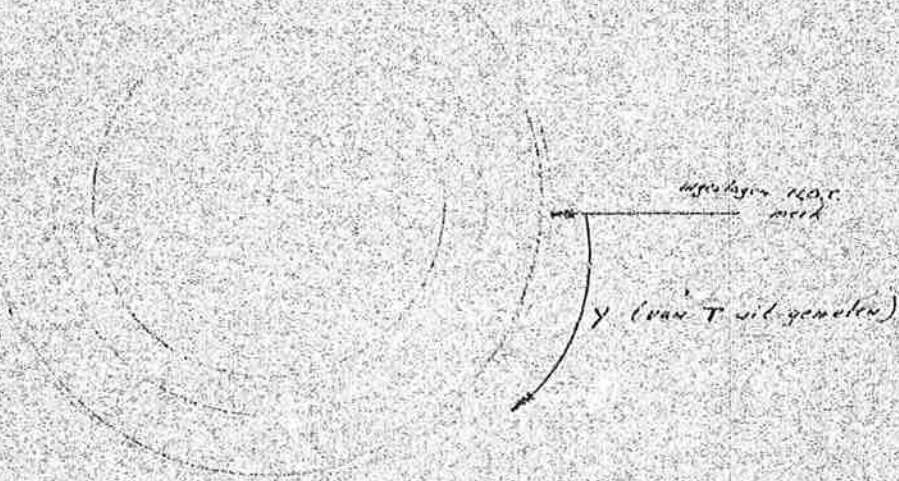
Var. required <i>Ac</i>	See Var. Report
Dev. required <i>No</i>	See Dev. Request

Reviewed by Inspector:

Date:



Spherical ring 003.



spherical ring 002

Indication No.	Length in mm	Depth in mm	Distance Y from reference	Distance Y in mm	Distance X in mm	Indication height in % of the reference standard				Type of transducer	Type of defect	Send. No.
						Long		Shear				
						a	u/r/a	w	u/r/a			
1	P.V.	130	NOT	445	265	30	a					
2	P.V.	185	NOT	2000	105	40	a		100%	100%	13.1.1	
3	P.V.	140	NOT	3225	330	75	a					
4	P.V.	160	NOT	3750	390	75	a					
NB =			Inclusionen reportable minusc inclusies de lvs. S.P. 528 Inclusionen acceptabel in 10% de lvs inclusies de d'edge d'afval									

- u = unacceptable
- r** = reportable
- a = acceptable

Type of defects:

- slag inclusion.....x undercut.....som
- slagline.....xxx lack of fusion.....som
- scattered slag inclusion, x lack of penetration, =
- found but no identified indications...?? crack.....som

P.V. = postvering