

rotterdam nuclear



NONDESTRUCTIVE EXAMINATION REPORT		Report No. 30810-66100-004-00-3040
Customer: Cockerill	Customer Ref: 4/61/31285	Item description: Vesselling 004
Manufact. Order: 30810	Sub order: 66100	Part examined: Complex Weldprep (acc. to spec.)
Sequence: 3040	Drawing: DD-007 sh.1 rev.1	Inspection by: Cockerill/Framatome/RN-QC
Item: 004		

Description of Examination

MT	A.C. D.C. _____ Prod Yoke Coil Central conductor _____ Dry Wet Fluoresc	
	Apparatus: _____ No. ID: _____	Type of powder: _____
	Prod. distance: _____	Oil water suspended _____
	Ampere per inch: _____	Degmagnetised: yes no _____
	Specification: _____	
PT	Colour contrast Fluorescent	
	Type penetrant: _____	batch no.: _____
	Type cleaner: _____	batch no.: _____
	Type developer: _____	batch no.: _____
	Specification: _____	
UT	Long. Shear Time base: 250-500 min. Amplification: acc. to spec	
	Apparatus: <i>USM 2</i> No. ID: 311	
	Transducers: <i>B25, WB45 2444 and WB60 2444</i>	
	Couplant: <i>PS Oil</i>	
	Reference standard No.: <i>C.K.L. 003</i>	
Specification: <i>PS-21.74-2 + ASME Code section XI incl. Winter 1973 add.</i>		

Other Tests:

Surface condition: *Machined*

Results:

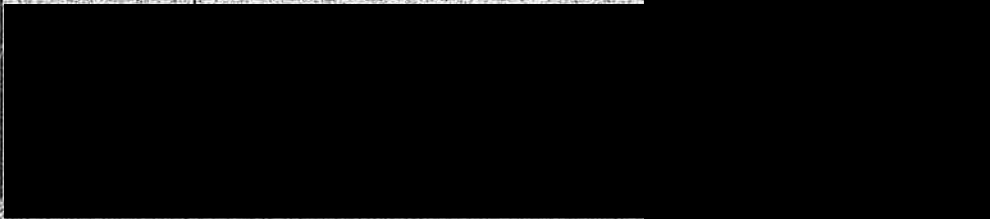
ACCEPTABLE
REPORTABLE INDICATIONS
NOT ACCEPTABLE

Remarks:

Attachments: *3*

Var. required *NO* See Var. Report:

Dev. required *NO* See Dev. Request:





UT CALIBRATION RECORD

Sheet No. 1

Straight beam examination weld edges

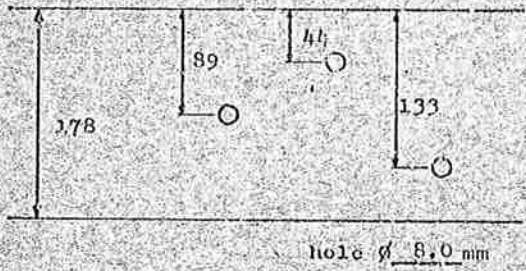
APPARATUS Krautkrämer type USIP10W Serial No. ID-
 USM2 Serial No. ID-311

SEARCH UNIT Krautkrämer type B2S Serial No. 303
 Crystal size 24 mm ϕ
 Frequency 2 MHz

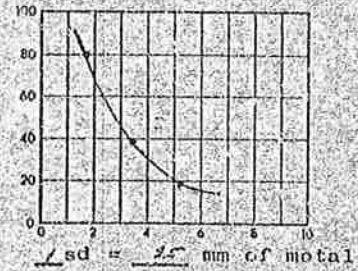
INSTRUMENT SETTINGS Test range 150 mm
 Gain 50 dB
 Frequency _____ MHz (for USIP10W)
 Pulse energy 1

COUPLANT Starch D
 Other oil

CALIBRATION BLOCK No. CKL 003



RESULTS



CALIBRATION RECHECK

Time					
Initials					

REMARKS _____

Examiners _____ Level _____

Reviewed by _____ Level _____
 Date _____



UT CALIBRATION RECORD

Sheet No. 2

Angle beam examination weld edges

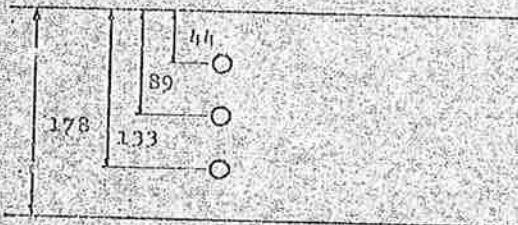
APPARATUS Krautkrämer type US110W Serial No. TD
 USN2 Serial No. 11-211

SEARCH UNIT Krautkrämer type WB45 WB60 Serial No. 108
 Crystal size 20x22 mm
 Frequency 2 MHz

INSTRUMENT SETTINGS Test range 150 mm
 Gain 56 dB
 Frequency _____ MHz (for US110W)
 Pulse energy 1

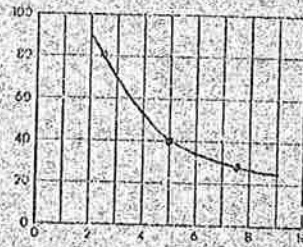
COUPLANT Starch
 Other oil

CALIBRATION BLOCK No. CKI. 003



hole ϕ 8.0 mm

RESULTS



$\lambda_{sd} = 25$ mm of metal

CALIBRATION RECHECK

Time				
Initials				

REMARKS

Examiners _____ Level _____

Reviewed by _____ Level _____

Date _____

rotterdam nuclear



UT CALIBRATION RECORD

Sheet No. 3

Angle beam examination weld edges

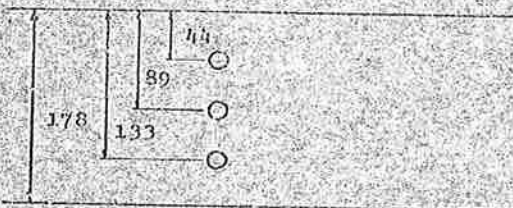
APPARATUS Krautkrämer type US1PT0V Serial No. 10-
USM2 Serial No. 11-311

SEARCH UNIT Krautkrämer type WB45 WB60 Serial No. 307
Crystal size 20x22 mm
Frequency 2 MHz

INSTRUMENT SETTINGS Test range 500 mm
Gain 50 dB
Frequency _____ MHz (for US1PT0V)
Pulse energy 1

COUPLANT Starch
Other oil

CALIBRATION BLOCK No. GKL 003



hole ϕ 8.0 mm

RESULTS



$t_{sd} = 50$ mm of metal

CALIBRATION RECHECK

Time					
Initials					

REMARKS

Examiners Level

Reviewed by _____ Level _____

Date _____