

MAGNETIC PARTICLE EXAMINATION REPORT

REPORT No.: **MT - 2506 - 01 - EDP**

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Client: **TAQA North**
District: **North Area** LSD: **C-032-H/094-H-08**
Facility: **Chinchaga Gas Plant**
Item(s) Examined: **WFMPI Weld Repair on West Head Outer Circumference Weld Between WHT3 and WHT4**
Acceptance Criteria: **ASME Sec VIII Div. 1 Article 6** Rev. / Date: **2013**
Procedure No.: **ITS-MT04** Rev. / Date: **Rev. 1 / Oct. 2011**
Technique No.: **ITS-MT04-Tech03** Rev. / Date: **Rev. 1 / Oct. 2011**

ITS Job No.: **2506**
Date: **November 5, 2013**
Time: **10:30 AM**
W.O. No.: **N/A**
P.O. No.: **N/A**
Cost Code: **N/A**
AFE: **N/A**
Other: **N/A**

Equipment Data:

PRN: (A) **0601541** Serial No.: **393508** Equip. No.: **603VP005** CRN: **K0576.1**
Material: **Carbon Steel** Thickness: **Shell- 17.09mm / Head- 11.07mm** Other: **N/A**

Surface Condition:

☒ Base Metal ☐ Machined ☐ Shot Blasted ☒ Wire Wheeled ☐ As Ground ☐ As Welded ☐ Painted ☐ Coated ☐ Other: **N/A**
☐ < -20°C (-5°F) ☒ -20°C (-5°F) to 54°C (130°F) ☐ 55°C (131°F) to 315°C (600°F) ☐ > 315°C (600°F)

Equipment:

Equipment	Serial No.	Cal. Due Date	MT Technique and Examination Medium:	
<input checked="" type="checkbox"/> Hand Yoke: Contour Probe	9335	3-Sep-14	<input checked="" type="checkbox"/> AC <input type="checkbox"/> DC	<input checked="" type="checkbox"/> Continuous <input type="checkbox"/> Residual
<input type="checkbox"/> Perm. Magnet:			<input checked="" type="checkbox"/> Wet <input type="checkbox"/> Dry	<input checked="" type="checkbox"/> Fluorescent <input type="checkbox"/> Visible
<input type="checkbox"/> Coil:			Manufacturer: MagnaGlo	Batch No.:
<input checked="" type="checkbox"/> Blacklight: Spectroline	1724870	10-Apr-14	<input type="checkbox"/> Cleaner:	
<input checked="" type="checkbox"/> Light Meter: Spectroline	1706821	10-Apr-14	<input type="checkbox"/> Color Contrast:	
<input type="checkbox"/> Visible Light: >	Footcandles		<input checked="" type="checkbox"/> Particles: 14AM	13D12K
Fluorescent Examination Blacklight Intensity Check; Pre: 2230 $\mu\text{W}/\text{cm}^2$ Post: 2250 $\mu\text{W}/\text{cm}^2$			<input type="checkbox"/> Other:	

Examination Details:

SCOPE: A Wet Fluorescent Magnetic Particle examination was performed on the following; weld repair on west head outer circumference weld between WHT3 and WHT4.


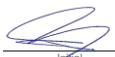
Refer to MT-1829-01-EDP for linear indication on west head.

RESULTS: No relevant indications were found on the weld repair area on the west head outer circumference weld between WHT3 and WHT4.

CONCLUSION: Based on the results of this examination of the horizontal bullet it is acceptable to the above mentioned acceptance criteria .

Client Representative: _____ Sign: _____ Date: _____

Technician(s):

Sign: 	Sign: 
Print: Erwin Pederson	Print: Adriana Nauta
1 st Technician	2 nd Technician / Assistant
CGSB: _____ SNT: _____ ACCP/ASNT: _____	CGSB: _____ SNT: _____ ACCP/ASNT: _____
Level: 2	Level: _____
Certification No.: 11157	Certification No.: _____

CONTINUATION EXAMINATION REPORT

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Client: **TAQA North**

ITS Job No.: **2506**

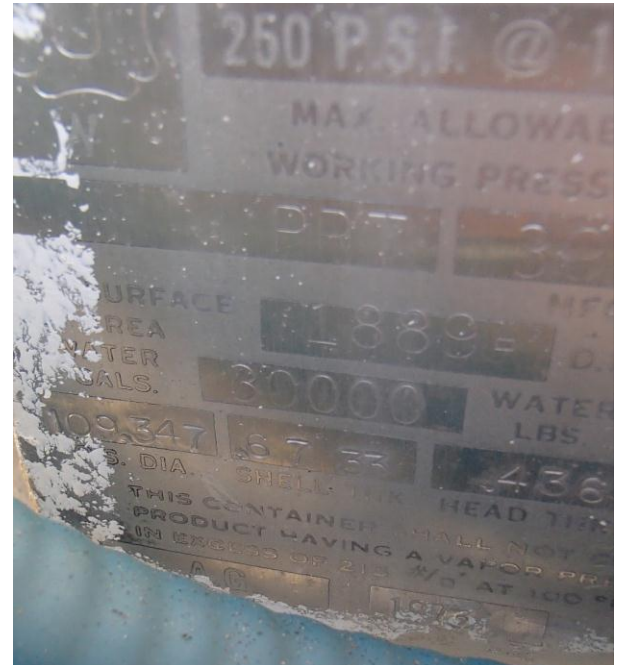
Item(s) Examined: **WFMPI Weld Repair on West Head Outer Circumference Weld Between
WHT3 and WHT4**

Date: **November 5, 2013**

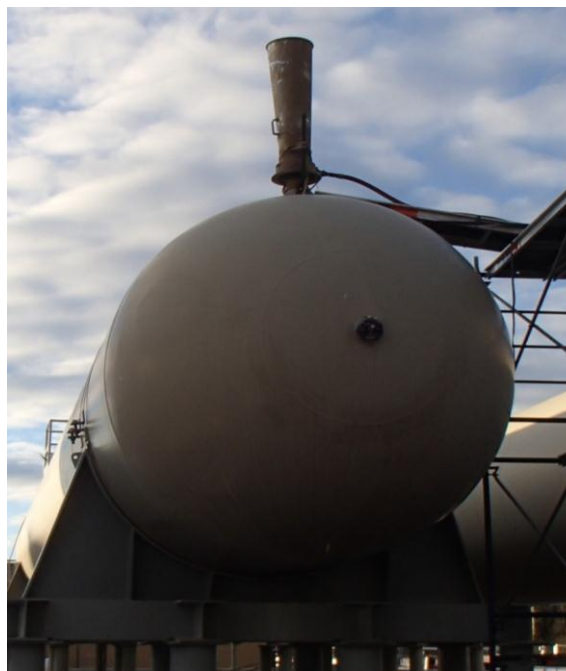
PHOTOS



603VP005



NAME PLATE



OVERALL VIEW

1st Technician:

Print: **Erwin Pederson**

Sign: *Erwin Pederson*

CONTINUATION EXAMINATION REPORT

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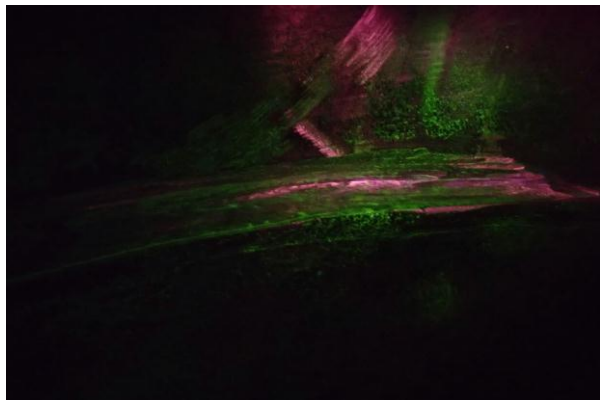
Client: **TAQA North**

ITS Job No.: **2506**

Item(s) Examined: **WFMPI Weld Repair on West Head Outer Circumference Weld Between**

Date: **November 5, 2013**

WFMT Done After Grinding



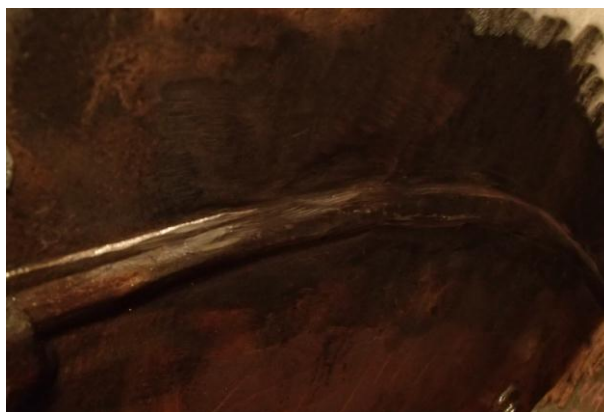
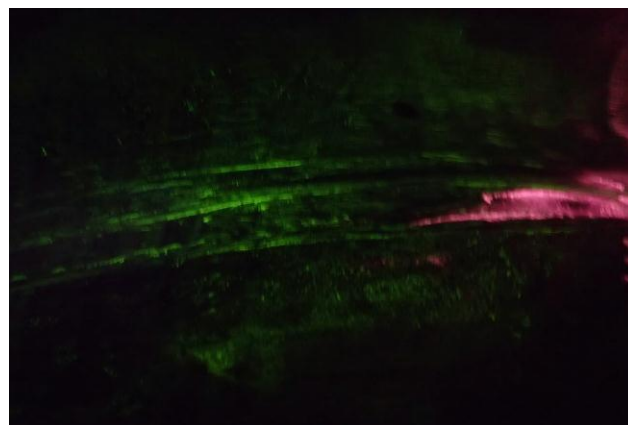
Grinding Length Approx. 254 mm Long



Grinding Width Approx. 19.05 mm Wide x 4.45 mm Deep



WFMT After Welding



1st Technician:

Print: **Erwin Pederson**

Sign: *Erwin Pederson*