CRYOLOR ASIA PACIFIC PVT LTD

escription ing No. ial Specification	C290222 HC002573	RADIOC	GRAPI	HIC EXA	Repor	t No.	1 REP	ORT	C290222/A1/RT/001
ing No.	HC002573	3 Rev.A							C290222/A1/RT/001
		3 Rev.A							
ial Specification						of Test			28/ 11 /17
	SA240 TY	PE 304			Techn	ique			SWSI
Thickness& orcement	6.7mm+0.	6+0.6mm			Selecti	ion of IÇ	ĮΙ		ASTM 1B
lure Ref. & Rev. No.	CAP/QA/	P.07 Rev.02	2		Placer	nent of I	QI		Source Side
e condition	AS Welde	d							0.1mm
ng Process(es)	SAW								O/IIIIII
e to object distance	1000mm				Film n	nanufact	ture & d	esignation.	AGFA D7
ice from source side of	7 9mm				Extent	of test			100%
o film	7.7111111				Exposi	ure Time	e:		1.0 (Minute)
tance standard	ASME Sec	VIII Div.1			Sensiti	ivity			Wire ASTM No.06
	KV: 250				No. of	Radiogr	aphs		05
	mA:3.0								Single wall
	Focal spot	: 3x3							Yes / No
B letter			3mm H	eight					Not visible
								e	One
		Film					Dalboott		One
Job Identification	Segment	Size mm	IQI	Weld	Weld	HAZ	HAZ	Type of Discontinuity	Evaluation
CAP C290222 RVTA19	0-1	400×100	2.25	2.25				NSD	ACC
A1 CAP010 6.7mm	1-2	400x100	2.42						ACC
	2-3		2.42						ACC
	3-4		2,25				1		ACC
	4-5	400×100	2.42						ACO PEPAN
	7							1100.11	eco peru
	1	\							
					-				
						/			/
						-			ASIA
									(6)
									S PV (R) 444) S
								-	(In) 199005 FE
								For Inspection Aut	ority INSPECTOR
A.Satheesh		Name	: A.Sathe	eesh				Name · DD	1111
e: Ohlth				1 140				- W.	MASS IIV
Addin		Date :		ALTE	177			Signature:	10.1
				20/11/2	8//			Date: 39 11	2017
vel II		NDEI	evel II	6			- 1	Daniem C	Ann and an
vel II		NDE L Evalua		21111				Designation	WITH TEIA
t	ng Process(es) to object distance ce from source side of o film ance standard B letter Job Identification CAP C290222 RVTA19 A1 CAP010 6.7mm	e condition AS Welder ng Process(es) SAW to object distance 1000mm ce from source side of of film ance standard ASME Second Min 1.5mr Job Identification Segment CAP C290222 RVTA19 0-1 A1 CAP010 6.7mm 1-2 2-3 3-4 4-5 A.Satheesh	e condition	e condition	AS Welded SAW SAW	AS Welded Lead Le	Carrell Carr	Condition	Condition

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot

ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWSI-single Wall Single Image
DWSI-Double will Single Image
DWDI-Double Will Double
Image



CRYOLOR ASIA PACIFIC PVT LTD

									VILID	
Tola Y	Non-mi-ti		RADIO	FRAPI	HIC EX.			REPO	ORT	
	Description	C290222				Repor				C290222/A1/RT/002
	ving No.	HC00257					of Test			07/ 12 /17
	rial Specification	SA240 TY	PE 304			Techn	ique			SWSI
Rein	l Thickness& forcement	6.7mm+0.	6+0.6mm			Selecti	ion of IÇ	ĮΙ		ASTM 1B
	edure Ref. & Rev. No.	CAP/QA/	P.07 Rev.02	2		Placer	nent of I	QI		Source Side
Surfa	ce condition	AS Welde	ed				creens			0.1mm
Weld	ing Process(es)	SAW								W. A. Miller
Sour	ce to object distance	1000mm				Film n	nanufaci	ture & d	esignation.	AGFA D7
	nce from source side of	7.9mm				Extent	of test			100%
weld	to film	7.9111111				Exposi	ure Time	e;		1.0 (Minute)
Acce	ptance standard	ASME Sec	VIII Div.1			Sensiti	vity			Wire ASTM No.06
		KV: 250				No. of	Radiogr	aphs		01
X-Ray	/	mA: 3.0					f viewir			
		Focal spot	· 3x3				ent of B			Single wall
Size c	f B letter		n thick & 1	3mm H	aight.		tion of E			Yes / No
			market Of Li		CIPILL					Not visible
			Film				ıım per	Cassette	2	One
Sl. Vo.	Job Identification	Segment	Size	IQI	Weld min	Density Weld max	HAZ min	HAZ max	Type of Discontinuity	Evaluation
)1	CAP C290222 RVTA19	4-5	400×100	2.42	2.42	2.52	2.65	2.70	NSD	ACC &S
	A1 CAP002 6.7mm									1100 (13
	R1									
		()								
		1								
_			-							
				1						
-				_						
						/				
										Section Control Section
										(15)
or CA									For Inspection Ayd	97it 2 19/01/2005
	A.Satheesh		Name:	A.Sathe	esh				Name : PRAKASH	
ignatu	re: A. Ath		Signatu		ONAL				Signature:	All the second
ate :	10/17		Date :		747	m				SPECTOR 2 12017
	The Part of the Pa			aval II	12 2	1				
DE L	evel II		NDE L	CACLII	0.01				Degionation	
DE L	evel II		Evaluat		00,				Designation Reviewed By	ASIA

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWSI- Sing Wall in Industrial DWSI-Double Will Double Image



CRYOLOR ASIA PACIFIC PVT LTD

									VILLID	
Jak T	D		ADIOG	RAPI	HIC EXA			REPC	ORT	
	Description	C290222				Repo				C290222/A1/RT/003
	ving No.	HC00257					of Test			11/ 12 /17
	erial Specification	SA240 T	YPE 304			Techr	nique			SWSI
Rein	d Thickness& forcement	6.7mm+0	0.6+0.6mm			Select	ion of IÇ	QI		ASTM 1B
Proc	edure Ref. & Rev. No.	CAP/QA	/P.07 Rev.0	2		Placer	ment of l	OI		Source Side
Surfa	ace condition	AS Weld	ed				screens	~		0.1mm
Weld	ling Process(es)	SAW								O.IIIIII
Sour	ce to object distance	1000mm				Film r	nanufac	ture & d	esignation.	AGFA D7
	nce from source side of	7.9mm					t of test			100%
weia	to film					Expos	ure Time	e:		1.0 (Minute)
Acce	ptance standard	ASME Se	c VIII Div.1			Sensit	ivity			Wire ASTM No.06
		KV: 250				No of	Radiogr	anho		01
X-Ray	У	mA:3.0					of viewir			01
		Focal spo	t:3x3				nent of B			Single wall
Size c	of B letter		m thick & 1	3mm F	Teiöht		ation of I			Yes / No
			ari tritical de a	DIIIII I	reight		Film per			Not visible
01			Film			Density	riiii per	Cassett	e	One
SI. No.	Job Identification	Segment	Size	IQI	Weld	Weld	HAZ min	HAZ max	Type of Discontinuity	Evaluation
01	CAP C290222 RVTA19	4-5	400×100	2.20	2.20	2.23	2.55	2.63	NSD	100
	A1 CAP002 6.7mm RS					2.20	2.00	2.00	INSD	ACC
										(E)
										ASIA N
or CA	P A.Satheesh								For Inspection Autl	O PVIRIAM S
ignatu:			Name : A		sh laf				Name: PRAKAS	WIK 2 19/01/2005 17
ate :			Signatur	1 ()	12	-			Signature:	AMAGO
NDE Level II			Date: NDE Level II 2 2017						Date: 1211	2 DOIX ABPENTAN
eriorm	ed By		Evaluate	d By					Reviewed By	ADDRESS ASTA
RI-Rou	andedIndication ILI-	ation		ACC A	nontod				TIVE	

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWSI-Sime Vallering
DWSI-Dund Wall Double
Image



	AOIA FAOIFIC		KIUI							
7 1			RADIO	GRAP	HIC EX	AMIN.	ATIO	N REP	ORT	
	Description	C290222				Repo	rt No.			C290222/A2/RT/001
	wing No.	HC00257				Date	of Test			28/ 11 /17
	erial Specification	SA240 TY	YPE 304			Techr	nique			SWSI
Reir	d Thickness& forcement	6.7mm+0	.6+0.6mm			Select	ion of I	QI		ASTM 1B
Proc	edure Ref. & Rev. No.	CAP/QA	/P.07 Rev.0	2		Placer	ment of	IOI		Source Side
Surf	ace condition	AS Welde					screens	1Q1		
Wel	ding Process(es)	SAW				Deut.	acreens			0.1mm
	ce to object distance	1000mm				Film r	nanufac	cture & d	lesignation.	AGFA D7
	nce from source side of	7.9mm				Exten	t of test			100%
weld	to film	7.5000				Expos	ure Tim	ie:		1.0 (Minute)
Acce	ptance standard	-	c VIII Div.1			Sensit		-		Wire ASTM No.06
		KV:250				No. of	Radiog	raphs		05
(-Ra	y,	mA:3.0				Type	of viewi	ng:		Single wall
		Focal spot				Placen	nent of I	B letter		Yes / No
ize	of B letter	Min 1.5mm	m thick & 1	3mm H	leight		ation of			Not visible
								r Cassett	e e	One
31.			Film			Density	and per	Cubacti		1 OTE
ĭo.	Job Identification	Segment	Size	IQI	Weld	Weld	HAZ, min	HAZ	Type of Discontinuity	Evaluation
1	CAP C290222 RVTA19	0-1	400×100	2.00	2.00	2.12	2.25	2.30	NSD	ACC
	A2 CAP010 6.7nm	. 1-2	400×100	2.12	2.12	2.25	2.40	2.42	NSD	
		2-3	400x100	2.00	2.00	2.12 -	2.25	2.30	NSD	ACC .
		3-4	400×100	2.00	2.00	2.15	2.25	2.32	NSD	ACC
		4-5	400×100	2,12	2.12	2.20	2.30	 		ACC
					2.12	2,20	2,00	2.30	NSD	ACC
		1				-		 		
							-			
								ļ		, , , , , , , , , , , , , , , , , , , ,
-										
			1							
			_							
				5						
				_						
-										
_									-	Waterstopping of showing to specific remaining property of the
						1				
										/
										AN ASIA
										(60)
										NO PV (RIMAS) SIL
r CA	l'								For Inspection Aut	19/01/2005
mo.	A.Sofheesi:		Name ·	A.Sathe	eedh				Nome DD AT ACT	11
กกร์เ			Signatu						Name : PRAKASH	NA V
te :	(N'STENT		Date :	(J'Atto	-			Signature:	MILE
	evel il OX/11/201		NDE L	evel II	29/11/2	01/			Date: 29111	2014
E L			1 - 122 70	o rea ti	-				Designation	1 14-
	ed By		Evaluat						Reviewed By	

RI-RoundedIndication
LI- Linear Indication
DRS-Dress&Reshoot

IUI-Isolated Indication RT/RS --Retake/ Reshoot FM-Film Mark

ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion



CRYOLOR ASIA PACIFIC PVT LTD

ASIA PACIFIC							DEDOD	т	121 E
10		ADIOGR	APHI	C EXA			REPUR	.1	C290222/A3/RT/001
scription									28/ 11 /17
ng No.									SWSI
al Specification	SA240 TYP	E 304			recnniq	ue			5.102
Thickness&	6.7mm+0.6+	-0.6mm			Selection	n of IQI			ASTM 1B
	CAP/QA/P	.07 Rev.02			Placeme	ent of IQ	Į		Source Side
					Lead sc	reens			0.1mm
_	1000mm				Film ma	anufactu	ıre & desi	gnation.	AGFA D7
					Extent of	of test			100%
ce from source side of o film	7.9mm						:		1.0 (Minute)
tance standard	ASME Sec	VIII Div.1			Sensitiv	rity			Wire ASTM No.06
	T/37 . 250				No. of I	Radiogra	aphs		05
									Single wall
,		. 22							Yes / No
	Focal spot	: 3X3	Us	idebt					Not visible
f B letter	Min 1.5mn	n thick & la	mm He	ngitt					One
		T217	_			mit per	Casserre		
						Н 47	HAZ.		Evaluation
Job Identification	Segment	- I	IQI		1 1			Discontinuity	
								NSD	ACC
CAP C290222 RVTA19									ACC
A3 CAP010 6.7mm									ACC
	2-3								ACC
	3-4								ACC
	4-5	400x100	2.42	2.42	2.60	2.60	2.62	NSD	ricc
							-		
					ļ				
						<u> </u>			
	1								
 		1							
		—	1						
						_			
				1					
									TY ASIA
									GOLD ASIA
									IS PY (R) 44 20
								For Inspection A	Adirocity 101/200
CAP									ME!
CAP e: A.Satheesh			e : A.Sa	theesh	h			Name : PRA	ME!
		Sign	ature:	theesh	h			Name : PRA Signature:	SHVAIR
e : A.Satheesh		Sign Date	ature:	2/1	h 72019			Name : PRA Signature:	SHVAIR
e : A.Satheesh ature:		Sign Date	ature:	2/1	h 2017			Name : PRA Signature:	SHVAIR
	scription ng No. al Specification Thickness& reement ture Ref. & Rev. No. e condition ng Process(es) e to object distance ree from source side of o film tance standard f B letter Job Identification CAP C290222 RVTA19	C290222	C290222	## RADIOGRAPHI Scription	## Cap	RADIOGRAPHIC EXAMINAT Report Repo	RADIOGRAPHIC EXAMINATION Secreption C290222 Report No. Date of Test	RADIOGRAPHIC EXAMINATION REPOREST: Secreption C290222 Report No.	RADIOGRAPHIC EXAMINATION REPORT Scription C290222 Report No. Date of Test Date of Test Date of Test Technique Selection of IQI Placement of IQI Lead screens Placement of IQI Lead screens Film manufacture & designation. Sensitivity Sensi

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWSI- ingle will one edinage DWSI-Double Well Double Will Double Image

CRYOLOR ASIA PACIFIC PVT LTD

								22201	200	
			ADIOG	RAPH	IC EXA			KEPO1	KT .	C000000 / A 4 /DT /001
	escription	C290222				Report				C290222/A4/RT/001
	ing No.	HC002573				Date of				28/ 11 /17
	rial Specification	SA240 TYP	E 304			Technic	lue			SWSI
	Thickness& orcement	6.7mm+0.6	+0.6mm			Selection	n of IQI			ASTM 1B
roce	dure Ref. & Rev. No.	CAP/QA/P	.07 Rev.02			Placem	ent of IÇ	QI.		Source Side
	ce condition	AS Welded				Lead so	reens			0.1mm
	ing Process(es)	SAW								
	e to object distance	1000mm	=			Film m	anufactu	ıre & des	ignation.	AGFA D7
2:-1	nce from source side of					Extent	of test			100%
	to film	7.9mm					re Time	:		1.0 (Minute)
Ассеј	otance standard	ASME Sec	VIII Div.1			Sensitiv	vity			Wire ASTM No.06
		KV: 250				No. of l	Radiogra	phs		05
(-Ray	.7	mA:3.0					f viewin			Single wall
IXay	y	Focal spot	· 3×3				ent of B			Yes / No
	(Dlatter	Min 1.5mn		mm He	aioh t		tion of B			Not visible
oize c	of B letter	TATTLE L'OURIE	i unck of It	/411111 1 1¢	.igitt			Cassette		One
			Film			Density	mir per	Laberre		
61.	Job Identification	Segment	Size		Weld	Weld	HAZ	HAZ	Type of	Evaluation
Jo.	Job Identification	GERMEIN	mm	IQI	min	max	min	max	Discontinuity	
1	CAP C290222 RVTA19	0-1	400×100	2.25	2.25	2.42	2,40	2.50	NSD	ACC
1	A4 CAP010 6.7mm	1-2	400×100	2.12	2.12	2.20	2.25	2.32	NSD	ACC
_	THE CHI OLO OF THE	2-3	400×100	2.00	2.00	2.16	2.22	2.25	NSD	ACC
		3-4	400×100	2.12	2.12	2.22	2.26	2.30	NSD	ACC
		4-5	400×100	2.00	2.00	2.25	2.40	2.42	NSD	ACC
		- 10	20071200							
	1									
	<u> </u>									
_										
	1									
				_						
				_						
										ASIA ASIA
										160
For C	CAP								For Inspection At	athority PV (1994 A 19/01/2005 m
For C Name	CAP c: A.Satheesh			e: A.Satl	neesh				Name : PRAK	athority PV (1994 A 19/01/2005 m
Name	e : A.Satheesh		Name Signa		neesh				Name : PRAK	19/01/2005 m
Name Signa	e : A.Satheesh ature:		Signa Date	ture:	CALT	2017			Name : PRAKAS Signature:	athority PV (1994 A 19/01/2005 m
Name Signa Date	e : A.Satheesh ature:		Signa Date	ture:	Chl	12017			Name : PRAK	19/01/2005 m

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion



CRYOLOR ASIA PACIFIC PVT LTD

			RADIO	GRAJ	PHIC EX	KAMIN.	ATION	I REPO	ORT	
_	Description	C29022	2			Repor				C290222/B1/RT/001
	wing No.		573 Rev.A			Date o				06 / 03 /18
	terial Specification	SA2407	TYPE 304			Techn	ique			DWSI
Reir	d Thickness& nforcement	6.7mm+	+4+(With Ba	ack Strip))	Selecti	ion of IQ	I		ASTM 1B
	cedure Ref. & Rev. No.	CAP/Q	A/P.07 Rev.	.02		Placen	nent of I(Source Side
Surf	ace condition	AS Weld	ded			Lead s		K.*		0.1mm
Wel	ding Process(es)	GTAW+	SAW							V.IIIII
Sour	ce to object distance	1000mm	ı			Film m	nanufacti	are & des	signation.	AGFA D7
	ance from source side of I to film	10.4mm				Extent				100%
		-				Exposi	ure Time	-		1.0 (Minute)
Acce	ptance standard	ASME Se	ec VIII Div.	.1		Sensitiv	vity			ASTM Wire No.06
		KV: 250				No. of 1	Radiogra	mhs		18
X-Ra	у	mA:3.0					f viewing			Single wall
*:		Focal spo					ent of B l			Yes / No
Size	of B letter	Min 1.5m	nm thick &	13mm F	Height		tion of B			Not visible
	1						ilm per C			One
SI.	7.1.73		Film			Density				One
No.	Job Identification	Segment	mm	IQI	Weld min	Weld max	HAZ min	HAZ max	Type of Discontinuity	Evaluation
01	CAP C290222 RVTA19	0-1	400x100	2.12	2.12	2.25	2.42	2.52	NSD	ACC
	B1 CAP031/003 6.7mm	1-2	400×100	2.25	2.25	2.40	2.42	2.48	NSD	ACC
		2-3	400×100	2.20	2.20	2.25	2.40	2.42	NSD	ACC
		3-4	400×100	2.00	2.00	2.25	2.42	2.45	NSD	ACC
		4-5	400x100	2.25	2.25	2.40	2.42	2.50	NSD	ACC
		5-6	400×100	2.25	2.25	2.30	2.42	2.50	NSD	ACC
		6-7	400x100	2.20	2.20	2.25	2.40	2,45	NSD	ACC
		7-8	400×100	2.25	2.25	2.30	2.40	2.42	NSD	ACC
		8-9	400x100	2.20	2.20	2.30	2.40	2.42	NSD	ACC
		9-10	400×100	2.00	2.00	2.20	2.42	2.45	NSD	
		10-11	400×100	2.42	2.42	2.52	2.60	2.62	NSD	ACO RIPRIO
		11-12	400×100	2.42	2.42	2.52	2.62	2.66	NSD	ACC
-		12-13	400×100	2.25	2.25	2.30	2,42	2.50	NSD	ACC
		13-14	400×100	2.35	2.35	2.42	2.60	2.62	NSD	ACC
_		14-15	400×100	2.25	2.25	2.45	2.60	2.62	NSD	ACC
		15-16	400×100	2.12	2.12	2.25	2.40	2.42	NSD	ACC
_		16-17	400x100	2.25	2.25	2.40	2.42	2.46	NSD	ACC
		17-0	400x100	2.20	2.20	2.24	2.40	2.42	NSD	ACC ACC
or CAl	P A.Satheesh								For Inspection Auth	ACC Phority PV(R) 434 > 19/01/2005 m
gnatur				: A.Sathe	esh				Name : PRAKASH	NADA
	TATA I VI		Signatu	ire:	1.176				Signature:	OC SECTOR
ate : DE Le	Vel II 00/03/2018		Date :		2 A2 20 K	8			Date: 07/0	3 2018
			NDE L	evel II	011001				Designation	212010
erforme	ed By		Evaluat	ted By					Reviewed By	ABIA
DI Day	ndedIndication II I I								Noviewed By	App.

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot

ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark

ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWS Single Wall'S In Image
DW Do bis Wall ing
Image
DWDI-D Do bis Wall ing

Image



CRYOLOR ASIA PACIFIC PVT LTD

	710171701110								VILID	
Tob 1	Description	C290222	RADIO	JKAP	HIC EX			REPO	RT	
	wing No.	HC00257				Report				C290222/B1/RT/002
	erial Specification	SA240 T				Date of		-		07 / 03 /18
	d Thickness&	JAZ40 I	11 E 304			Technic	que			DWSI
Rein	forcement	6.7mm+4	l+(With Bac	k Strip)		Selection	on of IQI			ASTM 1B
	edure Ref. & Rev. No.	CAP/QA	/P.07 Rev.0	2		Placem	ent of IQ	I		Source Side
Surfa	ace condition	AS Weld	ed			Lead so	reens			0.1mm
Weld	ding Process(es)	GTAW+S	SAW							
Sour	ce to object distance	1000mm				Film ma	anufactu	re & des	ignation.	AGFA D7
Dista	ance from source side of					Extent	of test			100%
	to film	10.4mm					re Time :			1.0 (Minute)
						Emposa	re rinte.			110 (Millitate)
Acce	ptance standard	ASME Se	c VIII Div.1			Sensitiv	rity			ASTM Wire No.06
		KV:250				No. of R	Radiograp	ohs		01
X-Ra	у	mA:3.0					viewing			Single wall
		Focal spo	t : 3x3				ent of B le	etter		Yes / No Not visible
Size	of B letter	Min 1.5m	m thick & 1	3mm H	leight	Evaluati	ion of B l	etter		
						No of Fi	lm per C	assette		One
Sl.	T-1-77 - 020 - 0		Film			Density			T	
No.	Job Identification	Segment	Size mm	IQI	Weld min	Weld max	HAZ min	HAZ max	Type of Discontinuity	Evaluation
01	CAP C290222 RVTA19	9-10	400×100	2.25	2.25	2.30	2.40	2.42	NSD	ACC
	B1 CAP 023 6.7mm R1									
-										
-										
-										
-										
										AIDE
For CA	A.Satheesh		Nome	A (1-41-					For Inspection Aut	PV (R) 444
Signatu			Signati	A.Sathe	esn	b.			Name : PRAKASH	K19/01/2003
Date :	CX PERSON				CAND	10			Signature:	Mary Lill
IDE L	evel II O 103 TEN		Date : NDE L	evel Ti	01/03	2018			Date: 07/03	20 Norted Inc.
					O W				Designation	
eriorm	ned By		Evaluat	ed By					Reviewed By	Arcia
R I_R o	undedIndication II I-I	colated India							().	ST TOO

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark

ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWSI-Single was Single Image DWSI-Double Wall Single Image SUD DWDI-Double Wall Couble





			RADIO	GRAP	HIC EX	AMINA	TION	REPO	RT	
Job I	Description	C290222				Report				C290222/B2/RT/001
Drav	ving No.	HC00257	73 Rev.A			Date of				27/ 11 /17
Mate	erial Specification	SA240 T	YPE 304			Technic	que			SWSI
	d Thickness& forcement	6.7mm+4					on of IQI			ASTM 1B
Proc	edure Ref. & Rev. No.	CAP/OA	/P.07 Rev.0	12		Placem	ent of IQ			Source Side
Surfa	ace condition	AS Weld				Lead so		1		0.1mm
Weld	ling Process(es)	SAW				Lead Sc	reens			U.IMIN
	ce to object distance	1000mm				Film m	anufactu	re & des	ignation.	AGFA D7
Dista	ince from source side of					Extent	of test			100%
weld	to film	14.7mm					re Time :			1.0 (Minute)
Acce	ptance standard	ASME Se	ec VIII Div.	L		Sensitiv				ASTM Wire No.08
		KV: 250				No. of F	Radiogra	ohs		18
X-Ra	у	mA:3.0					viewing			Single wall
		Focal spo	t:3x3			Placeme	ent of B le	etter		Yes / No
Size o	of B letter	Min 1.5m	m thick &	l3mm F	Ieight	Evaluat	ion of B l	etter		Not visible
						No of Fi	ilm per C	assette		One
1.	T 1 T 1 100 11		Film			Density			Type of	
Vo.	Job Identification	Segment	Size mm	IQI	Weld min	Weld max	HAZ min	HAZ max	Discontinuity	Evaluation
1	CAP C290222 RVTA19	0-1	400×100	2.00	2.00	2.25	3.25	3.30	NSD	ACC
	B2 CAP003 6.7mm	1-2	400×100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
_		2-3	400×100	2.00	2.00	2.25	3.15	3.22	NSD	ACC
		3-4	400×100	2.00	2.00	2.24	3.15	3.20	NSD	ACC
		4-5	400×100	2.00	2.00	2.24	3.20	3.22	NSD	ACC
_		5-6	400×100	2.00	2.00	2.25	3.12	3.18	NSD	ACC
		6-7	400×100	2.00	2.00	2.25	3.15	3.20	NSD	ACC
_		7-8	400×100	2.00	2.00	2.25	3.10	3.20	NSD	ACC
		8-9	400×100	2.00	2.00	2.30	3.15	3.22	NSD	ACC
		9-10	400×100	2.00	2.00	2.22	3.12	3.20	NSD	ACC
		10-11	400×100	2.00	2.00	2.25	3.12	3,20	NSD	ACC
		11-12	400×100	2.00	2.00	2.25	3.20	3.25	NSD	ACC
_		12-13	400×100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
		13-14	400×100	2.00	2.00	2.20	3.12	3.16	NSD	ACC
		14-15	400×100	2.00	2.00	2.25	3.16	3.22	NSD	ACC
		15-16	400×100	2.00	2.00	2.25	3.15	3.20	NSD	ACC
		16-17	400×100	2.00	2.00	2.24	3.15	3.20	NSD	AAAACQ
		17-0	400×100	2.00	2.00	2.26	3.15	3.21	NSD	ACC P
or CA			12.						For Inspection Aut	E 19/01/2005
	A.Satheesh			: A.Sath	eesh				Name : PRAKASH	NAME OF THE PARTY
gnatı	ire:		Signat		JUN K	10_			Signature: (
ate:	avol II 4/1/2011		Date :		29/11/25	N. I			Date: 88111	120175
	evel II od///		NDE I Evalua		20.				Designation Control of the Province of the Pro	la Th
			Lyaiua	Бу					Reviewed By	SULASIA

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS –Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion





			DADIO						VILID	
Tob 1	Description	C290222	RADIO	GKAP	HIC EX			REPO	RT	
	wing No.		73 Rev.A			Report				C290222/B3/RT/001
	erial Specification	SA240 T				Date of				27/ 11 /17
		3A240 I	11 E 304			Techni	que			SWST
	d Thickness& nforcement	6.7mm+4	1+4mm			Selection	on of IQI			ASTM 1B
	edure Ref. & Rev. No.	CAP/QA	/P.07 Rev.()2		Placem	ent of IQ	I		Source Side
Surf	ace condition	AS Weld	led			Lead so	reens			0.1mm
Wel	ding Process(es)	SAW								
Sour	ce to object distance	1000mm				Film m	anufactu	re & des	ignation.	AGFA D7
Dista	ance from source side of					Extent	of test			100%
	l to film	14.7mm				-	re Time :			1.0 (Minute)
						- iposu	TO THING .			(
Acce	eptance standard	ASME Se	ec VIII Div.	1		Sensitiv	rity			ASTM Wire No.08
		KV: 250				No. of F	Radiogra	ohs		18
X-Ra	у	mA:3.0					viewing			Single wall
		Focal spo	t:3x3			Placeme	ent of B le	etter		Yes / No
Size	of B letter	Min 1.5m	m thick & :	l3mm F	leight	Evaluat	ion of B l	etter		Not visible
						No of Fi	ilm per C	assette		One
Sl.	Tala T.J C.C C.		Film			Density			Type of	
No.	Job Identification	Segment	Size mm	IQI	Weld min	Weld max	HAZ min	HAZ max	Discontinuity	Evaluation
01	CAP C290222 RVTA19	0-1	400×100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
	B3 CAP003 6.7mm	1-2	400×100	2.00	2.00	2.25	3.12	3.16	NSD	ACC
		2-3	400x100	2.00	2.00	2.25	3.12	3.16	NSD	ACC
		3-4	400×100	2.00	2.00	2.25	3.10	3.16	NSD	ACC
		4-5	400×100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
		5-6	400×100	2.00	2.00	2.30	3.15	3.20	NSD	ACC
-		6-7	400×100	2.00	2.00	2.26	3.15	3.22	NSD	ACC
-		7-8	400×100	2.00	2.00	2.28	3.16	3.22	NSD	ACC
_		8-9	400×100	2.00	2.00	2.30	3.20	3.22	NSD	ACC
		9-10	400×100	2.00	2.00	2.32	3.20	3.25	NSD	ACC
-		10-11	400x100	2.00	2.00	2.30	3.24	3.26	NSD	ACC
		11-12	400x100	2.00	2.00	2.26	3.15	3.20	NSD	ACC
		12-13	400x100	2.00	2.00	2.30	3.14	3.20	NSD	ACC
		13-14	400x100	2.00	2.00	2.25	3.12	3.16	NSD	ACC
		14-15	400x100	2.00	2.00	2.30	3.14	3.22	NSD	ACC
		15-16	400x100	2.00	2.00	2.26	3.20	3.25	NSD	ACC
_		16-17	400x100	2.00	2.00	2.25	3.22	3.30	NSD	ACCOM
		17-0	400×100	2.00	2.00	2.25	3.15	3.20	NSD	I ACC
or CA									For Inspection Aut	hority 3 19/0
	: A.Satheesh		Name	: A.Sath	eesh				Name : PRAKAS	MAIK
ignatı	ire:		Signat	ure: /	V= 1962				Signature:	ECTOR
oate :	3/1/2011		Date:		octub	10			Date: 29 11	112017
IDE L	evel II	-	NDE L	evel II	DI	Designation Designation				0
erforn	ned By		Evalua	ted Bv					Reviewed By	NSIA XX
									Reviewed By	A COLUMN TO A COLU
									11 237	e 1 1 1/2/11

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS --Retake/ Reshoot FM-Film Mark

ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion - Single Will ingle Image
W - bould all ingle
D - Double

CRYOLOR ASIA PACIFIC PVT LTD

									VILID	
Tal- 1	D		RADIO	GRAP	HIC EX			REPO	RT	
	Description	C290222				Report				C290222/B4/RT/001
	wing No.	HC00257				Date of				27/ 11 /17
	erial Specification	SA240 T	YPE 304			Techni	que			SWSI
	d Thickness& forcement	6.7mm+4	1+4mm			Selection	on of IQI			ASTM 1B
Proc	edure Ref. & Rev. No.	CAP/QA	/P.07 Rev.0)2		Placem	ent of IQ	I		Source Side
Surfa	ace condition	AS Weld	.ed			Lead so				0.1mm
Weld	ling Process(es)	SAW								
Sour	ce to object distance	1000mm				Film m	anufactu	re & des	ignation.	AGFA D7
Dista	nce from source side of					Extent	of test			100%
	to film	14.7mm					re Time :			1.0 (Minute)
Acce	ptance standard	ASME Se	ec VIII Div.:	1		Sensitiv				ASTM Wire No.08
		KV:250				No. of I	Radiogra	phs		18
X-Ray	y	mA:3.0					viewing			Single wall
_		Focal spo				Placeme	ent of B le	etter		Yes / No
Size c	of B letter	Min 1.5m	m thick &	13mm I	I eight	Evaluat	ion of B l	etter		Not visible
				,		No of Fi	ilm per C	Cassette		One
S1,	Tale I dans (Co., C		Film			Density	_		Type of	
No.	Job Identification	Segment	Size mm	IQI	Weld min	Weld max	HAZ min	HAZ max	Discontinuity	Evaluation
01	CAP C290222 RVTA19	0-1	400×100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
	B4 CAP002 6.7mm	1-2	400×100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
		2-3	400×100	2.00	2.00	2.25	3.12	3.15	NSD	ACC
		3-4	400×100	2.00	2.00	2.20	3.00	3.12	NSD	ACC
		4-5	400×100	2.00	2.00	2.25	3.10	3.15	NSD	ACC
		5-6	400x100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
		6-7	400×100	2.00	2.00	2.25	3.12	3.15	NSD	ACC
		7-8	400×100	2.00	2.00	2.25	3.12	3.14	NSD	ACC
		8-9	400×100	2.00	2.00	2.20	3.10	312	NSD	ACC
		9-10	400×100	2.00	2.00	2.20	3.12	3.16	NSD	ACC
		10-11	400×100	2.00	2.00	2.24	3.12	3.20	NSD	ACC
		11-12	400×100	2.00	2.00	2.25	3.15	3.20	NSD	ACC
		12-13	400×100	2.00	2.00	2.22	3.10	3.16	NSD	ACC
		13-14	400×100	2.00	2.00	2.25	3.12	3.16	NSD	ACC
		14-15	400×100	2.00	2.00	2.20	3.00	3.10	NSD	ACC
		15-16	400×100	2.00	2.00	2.26	3.10	3.15	NSD	ACC
		16-17	400×100	2.00	2.00	2.24	3.10	3.15	NSD	ACC
		17-0	400×100	2.00	2.00	2.20	3.00	3.12	NSD	MACCA
or CA	P A.Satheesh								For Inspection Aut	hority 6 PV R
				: A.Sath	eesh				Name : PRAK	NAIS 19/01/2005 m
Signature: Signature:						Signature:				
ate ·	Date: NDE Level II Date: NDE Level II								Date: 29 11	20 FSPECTOR
			NIDET	evel II	V-4 1.				Designation	1
DE L	ned By		Evalua						Reviewed By	

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot

ILI-Isolated Indication RT/RS -Retake/ Reshoot FM-Film Mark

ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone

LF-Lack of Fusion

SWSI- Single wall Single image DWSI- Sound Wall Single Image Image
DWDI-Do ble Wali D ble

Image

2

CRYOLOR ASIA PACIFIC PVT LTD

	ASIA PACIFIC								ILID	
			RADIO	GRAPH	IC EXA	MINAT	ION R	EPOR	T	
	Description	C290222				Report	No.			C290222/B5/RT/001
	wing No.	HC00257	3 Rev.A			Date o	f Test			26/ 02 /18
Mate	erial Specification	SA240 TY	PE 304			Techni	que			SWSI
	d Thickness& forcement	6.7mm+4	+4mm			Selection	on of IQI			ASTM 1B
Proc	edure Ref. & Rev. No.	CAP/QA	P.07 Rev.02)		Placem	ent of IQ	ΣΙ		Source Side
Surfa	ace condition	As Welde	ed			Lead se	creens			0.1mm
Welc	ding Process(es)	SAW								
Sour	ce to object distance	1000 mm				Film m	anufactı	ıre & de	signation.	AGFA D7
Dista	ance from source side of					Extent	of test			100%
	to film	14.7mm				Exposu	ıre Time	:		1.0 (Minute)
Acce	ptance standard	ASME Sec	c VIII Div.1			Sensitiv				ASTM Wire No.08
		KV: 250				No. of	Radiogra	phs		18
X-Ra	У	mA:3.0				Type o	f viewinį	3		Single wall
		Focal spo				Placem	ent of B	letter		Yes / No
Size	of B letter	Min 1.5m	m thick & 1	3mm Hei	ght		tion of B			Not visible
							ilm per	Cassette		One
Sl. No.	Job Identification	Segment	Film Size mm	IQI	Weld min	Density Weld max	HAZ	HAZ max	Type of Discontinuity	Evaluation
01	CAP C290222 RVTA19	0-1	400×100	2.25	2.25	2.55	2.60	2.65	NSD	ACC
	B5 CAP015/003 6.7mm	1-2	400×100	2.42	2.42	2.55	2.62	2.66	LI	Repair
		2-3	400×100	2.25	2.25	2.45	2.60	2.65	NSD	ACC
		3-4	400×100	2.42	2.42	2.50	2.60	2.65	NSD	(ACC) Repub
		4-5	400x100	2.42	2.42	2.60	2.72	2.75	NSD	ACC
		5-6	400×100	2.42	2.42	2.52	2.62	2.66	NSD	ACC
		6-7	400x100	2.35	2.35	2.42	2.52	2.56	NSD	ACC
		7-8	400×100	2.55	2.55	2.60	2.62	2.70	NSD	ACC
		8-9	400×100	2.36	2.36	2.52	2.60	2.66	NSD	ACC
		9-10	400x100	2.35	2.35	2.48	2.60	2.62	NSD	ACC
		10-11	400×100	2.60	2.60	2.70	2.72	2.76	NSD	ACC
		11-12	400×100	2.45	2.45	2.70	2.72	2.76	NSD	ACC
		12-13	400×100	2.62	2.62	2.72	2.84	2.90	NSD	ACC
		13-14	400×100	2.50	2.50	2.55	2.60	2.65	NSD	ACC
		14-15	400×100	2.42	2.42	2.52	2.66	2.72	NSD	ACC CS
		15-16	400×100	2.54	2.54	2.60	2.72	2.76	NSD	ACC
		16-17	400×100	2.51	2.51	2.65	2.70	2.75	NSD	ACCA
		17-0	400×100	2.35	2.35	2.40	2.62	2.70	NSD	ACC PL
For Ca	AP : A.Satheesh	=	Nama · /	A.Satheesh					For Inspection Au	19/0 提前 四
Signat			Signature		140				Name : PRAKAS	114
Date:	1 1 1 1			. (1)	12/2018				Signature:	INDICATOR
	Level II 26/02/2018		Date : NDE Lev	el II	חוטיורייי				Date: 7112 Designation	12017
Perfor	med By		Evaluate	d By					Reviewed By	ASIA S
									- /	20%

RI-RoundedIndication Ll- Linear Indication DRS-Dress&Reshoot

ILI-Isolated Indication RT/RS -Retake/ Reshoot FM-Film Mark

ACC – Accepted NSD – No Significant Discontunity HAZ -Heat Affected Zone

LF-Lack of Fusion

(4-15)-Surface examined & poeter weld & Reshoot. Alth



									ILLID		
Ioh	Description	C290222	RADIO	KAPH	IC EXAP			CEPOI	CT	Cooper me maior	
	wing No.	HC002573 Rev.A				Report No.				C290222/B5/RT/002	
	erial Specification	SA240 TYPE 304			Date of Test				27/ 02 /18		
		SA240 11FE 304				Technique				SWSI	
Weld Thickness& Reinforcement		6.7mm+4+4mm				Selection of IQI				ASTM 1B	
Proc	cedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02				Placement of IQI				Source Side	
Surf	ace condition	As Welded				Lead screens				0.1mm	
Welding Process(es)		SAW									
Source to object distance		1000 mm				Film manufacture & designation.				AGFA D7	
Dist	ance from source side of	1.5				Extent of test				100%	
weld to film		14.7mm				Exposure Time :				1.0 (Minute)	
Acceptance standard		ASME Sec VIII Div.1				Sensitivity				ASTM Wire No.08	
X-Ray Size of B letter		KV: 250				No. of Radiographs				03	
		mA:3.0				Type of viewing				Single wall	
		Focal spot : 3x3				Placement of B letter				Yes / No	
Size	or B letter	Min 1.5mm thick & 13mm Height				Evaluation of B letter No of Film per Cassette			Not visible		
							ilm per (Cassette		One	
SI. No.	Job Identification	Segment	Film Size mm	IQI	Weld min	Weld max	HAZ min	HAZ max	Type of Discontinuity	Evaluation	
01	CAP C290222 RVTA19	1-2	400x100	2.25	2.25	2.35	2.45	2.50	NSD	ACC	
	B5 CAP007 6.7mm R1	3-4	400×100	2.35	2.35	2.42	2.60	2.62	NSD	ACC	
	CAP C290222 RVTA19	14-15	400×100	2.42	2,42	2.50	2.62	2.70	NSD	ACC	
	B5 CAP006 6.7mm RS										
	_										
		-									
_		_									
			_	_							
_											
_											
						_	_				
										ASIA A	
										(67)	
or C									For Inspection Aut	thority 19/01/2005	
	: A.Satheesh		Name : A.Satheesh						Name : PRAKASH AK		
ignat	ure: With		Signature:						Signature:		
ate :		Date:						Date: 28	12 2017		
IDE I	Level II 2		NDE Level II						Designation		
erfor	med By		Evaluated By						Reviewed By	land	
	•		1	- /					TOUTOMOU DY	MOVEL MOIN	

RI-RoundedIndication LI- Linear Indication DRS-Dress&Reshoot ILI-Isolated Indication RT/RS --Retake/ Reshoot FM-Film Mark ACC – Accepted NSD – No Significant Discontunity HAZ –Heat Affected Zone LF-Lack of Fusion SWSI Single Wall Single Image
DWSI Du le Wall Single Image
DWD - Dobe Wall Source
Image 700