

## RADIOGRAPHIC EXAMINATION REPORT

[illegible]

Reviewed By

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image



## RADIOGRAPHIC EXAMINATION REPORT




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

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

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double  
Image

## RADIOGRAPHIC EXAMINATION REPORT

[illegible]

For CAP		For Inspection Authority	
Name : A. Satheesh	Name : A. Satheesh	Name : PRAKASH NARAYAN	19/01/2005
Signature: 	Signature: 	Signature: 	
Date : 28/11/2017	Date : 29/11/2017	Date : 29/11/2017	
NDE Level II	NDE Level II	Designation	
Performed By	Evaluated By	Reviewed By	

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image



Reviewed By

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image

## RADIOGRAPHIC EXAMINATION REPORT

Job Description	C290222	Report No.	C290222/A4/RT/001
Drawing No.	HC002573 Rev.A	Date of Test	28/ 11 /17
Material Specification	SA240 TYPE 304	Technique	SWSI
Weld Thickness& Reinforcement	6.7mm+0.6+0.6mm	Selection of IQI	ASTM 1B
Procedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02	Placement of IQI	Source Side
Surface condition	AS Welded	Lead screens	0.1mm
Welding Process(es)	SAW	Film manufacture & designation.	AGFA D7
Source to object distance	1000mm		
Distance from source side of weld to film	7.9mm	Extent of test	100%
		Exposure Time :	1.0 (Minute)
Acceptance standard	ASME Sec VIII Div.1	Sensitivity	Wire ASTM No.06
X-Ray	KV : 250	No. of Radiographs	05
	mA : 3.0	Type of viewing	Single wall
	Focal spot : 3x3	Placement of B letter	Yes / No
Size of B letter	Min 1.5mm thick & 13mm Height	Evaluation of B letter	Not visible
		No of Film per Cassette	One

[illegible]

For CAP

Name : A.Satheesh

Signature: \_\_\_\_\_

Date : \_\_\_\_\_

NDE Level II

---

Performed By

Name : A.Satheesh

Signature: \_\_\_\_\_

Date :

NDE Level II

Evaluated By

For Inspection Author:

Name : PRAKASH NAIK

Signature: \_\_\_\_\_

Date : \_\_\_\_\_

Designation

Reviewed By

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

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

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

SWSI Single Wall Single Image  
DWSI Double Wall Single Image  
DWD Double Wall Double  
Image



# CRYOLOR ASIA PACIFIC PVT LTD

## RADIOGRAPHIC EXAMINATION REPORT

Job Description	C290222	Report No.	C290222/B1/RT/001
Drawing No.	HC002573 Rev.A	Date of Test	06 / 03 /18
Material Specification	SA240 TYPE 304	Technique	DWSI
Weld Thickness& Reinforcement	6.7mm+4+(With Back Strip)	Selection of IQI	ASTM 1B
Procedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02	Placement of IQI	Source Side
Surface condition	AS Welded	Lead screens	0.1mm
Welding Process(es)	GTAW+SAW	Film manufacture & designation.	AGFA D7
Source to object distance	1000mm	Extent of test	100%
Distance from source side of weld to film	10.4mm	Exposure Time :	1.0 (Minute)
Acceptance standard	ASME Sec VIII Div.1	Sensitivity	ASTM Wire No.06
X-Ray	KV : 250 mA : 3.0 Focal spot : 3x3	No. of Radiographs	18
Size of B letter	Min 1.5mm thick & 13mm Height	Type of viewing	Single wall
		Placement of B letter	Yes / No
		Evaluation of B letter	Not visible
		No of Film per Cassette	One

Sl. No.	Job Identification	Segment	Film Size mm	Density					Type of Discontinuity	Evaluation
				IQI	Weld min	Weld max	HAZ min	HAZ max		
01	CAP C290222 RVT A19	0-1	400x100	2.12	2.12	2.25	2.42	2.52	NSD	ACC
	B1 CAP031/003 6.7mm	1-2	400x100	2.25	2.25	2.40	2.42	2.48	NSD	ACC
		2-3	400x100	2.20	2.20	2.25	2.40	2.42	NSD	ACC
		3-4	400x100	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	400x100	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	400x100	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	400x100	2.00	2.00	2.20	2.42	2.45	NSD	ACC
		10-11	400x100	2.42	2.42	2.52	2.60	2.62	NSD	ACC
		11-12	400x100	2.42	2.42	2.52	2.62	2.66	NSD	ACC
		12-13	400x100	2.25	2.25	2.30	2.42	2.50	NSD	ACC
		13-14	400x100	2.35	2.35	2.42	2.60	2.62	NSD	ACC
		14-15	400x100	2.25	2.25	2.45	2.60	2.62	NSD	ACC
		15-16	400x100	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

For CAP		For Inspection Authority	
Name : A.Satheesh	Name : A.Satheesh	Name : PRAKASH NAIK	
Signature: <i>[Signature]</i>	Signature: <i>[Signature]</i>	Signature: <i>[Signature]</i>	
Date : 06/03/2018	Date : 07/03/2018	Date : 07/03/2018	
NDE Level II	NDE Level II	Designation	
Performed By	Evaluated By	Reviewed By	

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

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

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





SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image





## RADIOGRAPHIC EXAMINATION REPORT

[illegible]

For CAP		For Inspection Authority	
Name : A.Satheesh	Name : A.Satheesh	Name : PRAKASH K	PV (R) 444 K19/01/2005
Signature: 	Signature: 	Signature: 	
Date : 01/03/2018	Date : 01/03/2018	Date : 01/03/2018	
NDE Level II	NDE Level II	Designation	
Performed By	Evaluated By	Reviewed By	

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
Image  
DWSI-Double Wall Double Image





# CRYOLOR ASIA PACIFIC PVT LTD

## RADIOGRAPHIC EXAMINATION REPORT

Job Description	C290222	Report No.	C290222/B2/RT/001
Drawing No.	HC002573 Rev.A	Date of Test	27/ 11 /17
Material Specification	SA240 TYPE 304	Technique	SWSI
Weld Thickness& Reinforcement	6.7mm+4+4mm	Selection of IQI	ASTM 1B
Procedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02	Placement of IQI	Source Side
Surface condition	AS Welded	Lead screens	0.1mm
Welding Process(es)	SAW	Film manufacture & designation.	AGFA D7
Source to object distance	1000mm	Extent of test	100%
Distance from source side of weld to film	14.7mm	Exposure Time :	1.0 (Minute)
Acceptance standard	ASME Sec VIII Div.1	Sensitivity	ASTM Wire No.08
X-Ray	KV : 250 mA : 3.0 Focal spot : 3x3	No. of Radiographs	18
Size of B letter	Min 1.5mm thick & 13mm Height	Type of viewing	Single wall
		Placement of B letter	Yes / No
		Evaluation of B letter	Not visible
		No of Film per Cassette	One

Sl. No.	Job Identification	Segment	Film Size mm	Density					Type of Discontinuity	Evaluation
				IQI	Weld min	Weld max	HAZ min	HAZ max		
01	CAP C290222 RVTA19	0-1	400x100	2.00	2.00	2.25	3.25	3.30	NSD	ACC
	B2 CAP003 6.7mm	1-2	400x100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
		2-3	400x100	2.00	2.00	2.25	3.15	3.22	NSD	ACC
		3-4	400x100	2.00	2.00	2.24	3.15	3.20	NSD	ACC
		4-5	400x100	2.00	2.00	2.24	3.20	3.22	NSD	ACC
		5-6	400x100	2.00	2.00	2.25	3.12	3.18	NSD	ACC
		6-7	400x100	2.00	2.00	2.25	3.15	3.20	NSD	ACC
		7-8	400x100	2.00	2.00	2.25	3.10	3.20	NSD	ACC
		8-9	400x100	2.00	2.00	2.30	3.15	3.22	NSD	ACC
		9-10	400x100	2.00	2.00	2.22	3.12	3.20	NSD	ACC
		10-11	400x100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
		11-12	400x100	2.00	2.00	2.25	3.20	3.25	NSD	ACC
		12-13	400x100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
		13-14	400x100	2.00	2.00	2.20	3.12	3.16	NSD	ACC
		14-15	400x100	2.00	2.00	2.25	3.16	3.22	NSD	ACC
		15-16	400x100	2.00	2.00	2.25	3.15	3.20	NSD	ACC
		16-17	400x100	2.00	2.00	2.24	3.15	3.20	NSD	ACC
		17-0	400x100	2.00	2.00	2.26	3.15	3.21	NSD	ACC

For CAP		For Inspection Authority	
Name : A.Satheesh	Name : A.Satheesh	Name : PRAKASH NAIK	PV (R) 444
Signature:	Signature:	Signature:	19/01/2005
Date : 28/11/2017	Date : 28/11/2017	Date : 28/11/2017	
NDE Level II	NDE Level II	Designation	
Performed By	Evaluated By	Reviewed By	

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

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

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

SWSI- Single Wall Single Image  
DWSI- Double Wall Single Image  
SUD- Single Image  
DWDI- Double Wall Double Image





# CRYOLOR ASIA PACIFIC PVT LTD

## RADIOGRAPHIC EXAMINATION REPORT

Job Description	C290222	Report No.	C290222/B3/RT/001
Drawing No.	HC002573 Rev.A	Date of Test	27/ 11 /17
Material Specification	SA240 TYPE 304	Technique	SWSI
Weld Thickness& Reinforcement	6.7mm+4+4mm	Selection of IQI	ASTM 1B
Procedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02	Placement of IQI	Source Side
Surface condition	AS Welded	Lead screens	0.1mm
Welding Process(es)	SAW	Film manufacture & designation.	AGFA D7
Source to object distance	1000mm		
Distance from source side of weld to film	14.7mm	Extent of test	100%
		Exposure Time :	1.0 (Minute)
Acceptance standard	ASME Sec VIII Div.1	Sensitivity	ASTM Wire No.08
X-Ray	KV : 250	No. of Radiographs	18
	mA : 3.0	Type of viewing	Single wall
	Focal spot : 3x3	Placement of B letter	Yes / No
Size of B letter	Min 1.5mm thick & 13mm Height	Evaluation of B letter	Not visible
		No of Film per Cassette	One

Sl. No.	Job Identification	Segment	Film Size mm	Density					Type of Discontinuity	Evaluation
				IQI	Weld min	Weld max	HAZ min	HAZ max		
01	CAP C290222 RVTA19	0-1	400x100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
	B3 CAP003 6.7mm	1-2	400x100	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	400x100	2.00	2.00	2.25	3.10	3.16	NSD	ACC
		4-5	400x100	2.00	2.00	2.25	3.12	3.20	NSD	ACC
		5-6	400x100	2.00	2.00	2.30	3.15	3.20	NSD	ACC
		6-7	400x100	2.00	2.00	2.26	3.15	3.22	NSD	ACC
		7-8	400x100	2.00	2.00	2.28	3.16	3.22	NSD	ACC
		8-9	400x100	2.00	2.00	2.30	3.20	3.22	NSD	ACC
		9-10	400x100	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	ACC
		17-0	400x100	2.00	2.00	2.25	3.15	3.20	NSD	ACC

For CAP

Name : A.Satheesh

Signature:

Date :

NDE Level II

Performed By

Name : A.Satheesh

Signature:

Date :

NDE Level II

Evaluated By

For Inspection Authority

Name : PRAKASH AIK

Signature:

Date :

Designation

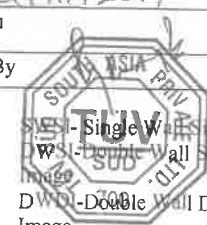
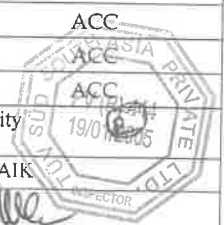
Reviewed By

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

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

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

SWI- Single Wall Single Image  
DWSI- Double Wall Single Image  
DWDI- Double Wall Double Image





## CRYOLOR ASIA PACIFIC PVT LTD

### RADIOGRAPHIC EXAMINATION REPORT

Job Description	C290222	Report No.	C290222/B4/RT/001
Drawing No.	HC002573 Rev.A	Date of Test	27/ 11 /17
Material Specification	SA240 TYPE 304	Technique	SWSI
Weld Thickness& Reinforcement	6.7mm+4+4mm	Selection of IQI	ASTM 1B
Procedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02	Placement of IQI	Source Side
Surface condition	AS Welded	Lead screens	0.1mm
Welding Process(es)	SAW	Film manufacture & designation.	AGFA D7
Source to object distance	1000mm		
Distance from source side of weld to film	14.7mm	Extent of test	100%
		Exposure Time :	1.0 (Minute)
Acceptance standard	ASME Sec VIII Div.1	Sensitivity	ASTM Wire No.08
X-Ray	KV : 250	No. of Radiographs	18
	mA : 3.0	Type of viewing	Single wall
	Focal spot : 3x3	Placement of B letter	Yes / No
Size of B letter	Min 1.5mm thick & 13mm Height	Evaluation of B letter	Not visible
		No of Film per Cassette	One

Sl. No.	Job Identification	Segment	Film Size mm	Density					Type of Discontinuity	Evaluation
				IQI	Weld min	Weld max	HAZ min	HAZ max		
01	CAP C290222 RVTA19	0-1	400x100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
	B4 CAP002 6.7mm	1-2	400x100	2.00	2.00	2.25	3.10	3.12	NSD	ACC
		2-3	400x100	2.00	2.00	2.25	3.12	3.15	NSD	ACC
		3-4	400x100	2.00	2.00	2.20	3.00	3.12	NSD	ACC
		4-5	400x100	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	400x100	2.00	2.00	2.25	3.12	3.15	NSD	ACC
		7-8	400x100	2.00	2.00	2.25	3.12	3.14	NSD	ACC
		8-9	400x100	2.00	2.00	2.20	3.10	3.12	NSD	ACC
		9-10	400x100	2.00	2.00	2.20	3.12	3.16	NSD	ACC
		10-11	400x100	2.00	2.00	2.24	3.12	3.20	NSD	ACC
		11-12	400x100	2.00	2.00	2.25	3.15	3.20	NSD	ACC
		12-13	400x100	2.00	2.00	2.22	3.10	3.16	NSD	ACC
		13-14	400x100	2.00	2.00	2.25	3.12	3.16	NSD	ACC
		14-15	400x100	2.00	2.00	2.20	3.00	3.10	NSD	ACC
		15-16	400x100	2.00	2.00	2.26	3.10	3.15	NSD	ACC
		16-17	400x100	2.00	2.00	2.24	3.10	3.15	NSD	ACC
		17-0	400x100	2.00	2.00	2.20	3.00	3.12	NSD	ACC

For CAP

Name : A.Satheesh

Signature:

Date : 27/11/2017

NDE Level II

Performed By

Name : A.Satheesh

Signature:

Date : 27/11/2017

NDE Level II

Evaluated By

For Inspection Authority

Name : PRAKASH NAIK

Signature:

Date : 27/11/2017

Designation

Reviewed By

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

ILI-Isolated Indication  
RT/RS -Retake/ Reshoot  
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ACC - Accepted  
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LF-Lack of Fusion

SWSI- Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image





# CRYOLOR ASIA PACIFIC PVT LTD

## RADIOGRAPHIC EXAMINATION REPORT

Job Description	C290222	Report No.	C290222/B5/RT/001
Drawing No.	HC002573 Rev.A	Date of Test	26/02/18
Material Specification	SA240 TYPE 304	Technique	SWSI
Weld Thickness& Reinforcement	6.7mm+4+4mm	Selection of IQI	ASTM 1B
Procedure Ref. & Rev. No.	CAP/QA/P.07 Rev.02	Placement of IQI	Source Side
Surface condition	As Welded	Lead screens	0.1mm
Welding Process(es)	SAW	Film manufacture & designation.	AGFA D7
Source to object distance	1000 mm		
Distance from source side of weld to film	14.7mm	Extent of test	100%
		Exposure Time :	1.0 (Minute)
Acceptance standard	ASME Sec VIII Div.1	Sensitivity	ASTM Wire No.08
X-Ray	KV : 250	No. of Radiographs	18
	mA : 3.0	Type of viewing	Single wall
	Focal spot : 3x3	Placement of B letter	Yes / No
Size of B letter	Min 1.5mm thick & 13mm Height	Evaluation of B letter	Not visible
		No of Film per Cassette	One

Sl. No.	Job Identification	Segment	Film Size mm	Density					Type of Discontinuity	Evaluation
				IQI	Weld min	Weld max	HAZ min	HAZ max		
01	CAP C290222 RVTA19	0-1	400x100	2.25	2.25	2.55	2.60	2.65	NSD	ACC
	B5 CAP015/003 6.7mm	1-2	400x100	2.42	2.42	2.55	2.62	2.66	LI	Repair
		2-3	400x100	2.25	2.25	2.45	2.60	2.65	NSD	ACC
		3-4	400x100	2.42	2.42	2.50	2.60	2.65	NSD	ACC Repair
		4-5	400x100	2.42	2.42	2.60	2.72	2.75	NSD	ACC
		5-6	400x100	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	400x100	2.55	2.55	2.60	2.62	2.70	NSD	ACC
		8-9	400x100	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	400x100	2.60	2.60	2.70	2.72	2.76	NSD	ACC
		11-12	400x100	2.45	2.45	2.70	2.72	2.76	NSD	ACC
		12-13	400x100	2.62	2.62	2.72	2.84	2.90	NSD	ACC
		13-14	400x100	2.50	2.50	2.55	2.60	2.65	NSD	ACC
		14-15	400x100	2.42	2.42	2.52	2.66	2.72	NSD	ACC CS
		15-16	400x100	2.54	2.54	2.60	2.72	2.76	NSD	ACC
		16-17	400x100	2.51	2.51	2.65	2.70	2.75	NSD	ACC
		17-0	400x100	2.35	2.35	2.40	2.62	2.70	NSD	ACC

For CAP	For Inspection Authority
Name : A.Satheesh	Name : A.Satheesh
Signature: <i>[Signature]</i>	Signature: <i>[Signature]</i>
Date : 26/02/2018	Date : 27/02/2018
NDE Level II	NDE Level II
Performed By	Evaluated By
	Reviewed By

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

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

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

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image  
700

(14-15) - Surface examined & perfect weld & Reshoot. *[Signature]*

## RADIOGRAPHIC EXAMINATION REPORT

SWSI-Single Wall Single Image  
DWSI-Double Wall Single Image  
DWDI-Double Wall Double Image