

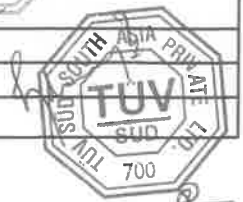



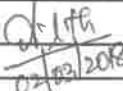

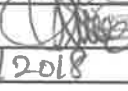

CRYOLOR ASIA PACIFIC PVT LTD.

LIQUID PENETRANT EXAMINATION REPORT

Client	STOCK	Project No	C290222	
Job Description	Dish end Long seams, shell Long seams, Dish end Nozzles and Attachment Welding	Report No.	C290222/PT-ACS/001	
Drawing No.	HC002573 Rev. A	Date of Test	09.03.2018	
Material	SA 240M TYPE 304, SA 182 F304, SA 312M TP 304	Penetrant	VISIBLE	
Thickness (mm)	8.0, 6.7, 12, 3.68, 2.77, 6.0, 2.87	Cleaner/Remover	SKC-1 (17J02)	
Procedure No. With Rev. No.	CAP/QA/P-08 Rev.02	Developer	SKD-S2 (17F0S)	
Surface condition	As welded	Dwell Time	8 Minutes	
Surface Temp.	26°C	Lighting Equipment	WHITE LIGHT (100 W Hand Lamp at a distance of 12 inch)	
Penetrant System	SKL-SP1 (17J11)	Light Intensity	WHITE 1000 LUX	
Technique	Solvent removable	Development Time	13 Minutes	
Acceptance standard	SME Sec. VIII Div.1			
S.No	PART NO / WELD NO	INTERPRETATION		RESULTS
		TYPE of Discontinuity	DIMENSION (Diameter/Length)	
1	A1 – Shell long seam welding	NSD	-	Acceptable
2	A2 – Shell long seam welding		-	Acceptable
3	A3 – Shell long seam welding		-	Acceptable
4	A4 – Shell long seam welding		-	Acceptable
5	Main Support Plate Welding with shell (M1a & M1b)		-	Acceptable
6	Pipe support rod welding (M4a to M4f)		-	Acceptable
7	Lifting lug to dish end welding (M2a, M2b & M2c)		-	Acceptable
8	Support for absorbent bag to dish end welding (M5a to M5h)		-	Acceptable
9	Name Plate support rod to top dish end welding (M7a to M7d)		-	Acceptable
10	Top dish nozzle welding (D1 to D5)		-	Acceptable
11	Bottom dish nozzle welding (D7 to D12)		-	Acceptable
12	Top and Bottom long seam Welding in Dish		-	Acceptable
For CAP		For Inspection Authority		
Name: A.SATHEESH	Name: A.SATHEESH	Name: PRAKASH NAIK		
Signature:	Signature:	Signature:		
Date: 09/03/2018	Date: 09/03/2018	Date: 29/03/2018		
NDE Level II:	NDE Level II:	Designation:		
Performed By:	Interpreted & Evaluated By:	Witnessed/Reviewed By:		

Legend – LI – Linear indication; RI – Rounded indication, NSD-No Significant Discontinuity.



 CRYOLOR ASIA PACIFIC PVT LTD.				
LIQUID PENETRANT EXAMINATION REPORT				
Client	STOCK	Project No	C290222	
Job Description	Temporary attachment area	Report No.	C290222/PT-BCS/003	
Drawing No.	HC002573 Rev A	Date of Test	02.03.2018	
Material	SA 240M TYPE 304	Penetrant	VISIBLE	
Thickness (mm)	6.7, 8.0	Cleaner/Remover	SKC-1 (17J02)	
Procedure No. With Rev. No.	CAP/QA/P-08 Rev.02	Developer	SKD-S2 (17F0S)	
Surface condition	As ground	Dwell Time	12 Minutes	
Surface Temp.	26°C	Lighting Equipment	WHITE LIGHT (100 W hand lamp at a distance of 12 inch)	
Penetrant System	SKL-SP1 (17J11)	Light Intensity	WHITE <u>1000</u> LUX	
Technique	Solvent removable	Development Time	13 Minutes	
Acceptance standard	ASME Sec. VIII Div.1			
S.No	PART NO / WELD NO	INTERPRETATION		RESULTS
		Type of Discontinuity	DIMENSION (Diameter/Length)	
1	Temporary attachments removed area at Top Dish	NSD	-	Acceptable
2	Temporary attachments removed area at Bottom Dish		-	Acceptable
3	Temporary attachments removed area at Shell 1		-	Acceptable
4	Temporary attachments removed area at Shell 2		-	Acceptable
5	Temporary attachments removed area at Shell 3		-	Acceptable
6	Temporary attachments removed area at Shell 4		-	Acceptable
7	Temporary attachments removed area at Top Dish nozzle		-	Acceptable
8	Temporary attachments removed area at Bottom Dish nozzle		-	Acceptable
For CAP		For Inspection Authority		
Name: A.SATHEESH	Name: A.SATHEESH	Name: PRAKASH NAIK		
Signature: 	Signature: 	Signature: 		
Date: 02/03/2018	Date: 02/03/2018	Date: 07/03/2018		
NDE Level II:	NDE Level II:	Designation:		
Performed By:	Interpreted & Evaluated By:	Witnessed/Reviewed By: 		

Legend – LI – Linear indication; RI – Rounded indications; NSD-No Significant Discontinuity





CRYOLOR ASIA PACIFIC PVT LTD.

LIQUID PENETRANT EXAMINATION REPORT

Client	STOCK	Project No	C290222
Job Description	Dish end Nozzles	Report No.	C290222/PT-BCS/002
Drawing No.	HC0025733 Rev.A	Date of Test	04.12.2017
Material	SA 240M TYPE.304 to SA 312 TP 304	Penetrant	VISIBLE
Thickness (mm)	8.0, 2.77, 3.68, 2.87	Cleaner/Remover	SKC-1 (17J02)
Procedure No. With Rev. No.	CAP/QA/P-08 Rev.02	Developer	SKD-S2 (17F0S)
Surface condition	As ground	Dwell Time	6 Minutes
Surface Temp.	27°C	Lighting Equipment	WHITE LIGHT (100 W Hand Lamp at a distance of 12 inch)
Penetrant System	SKL-SP1 (17J11)	Light Intensity	WHITE 1000 LUX
Technique	Solvent removable	Development Time	11 Minutes
Acceptance standard	ASME Sec. VIII Div.1		

S.No	PART NO / WELD NO	INTERPRETATION		RESULTS
		Type of Discontinuity	DIMENSION (Diameter/Length)	
1	Bottom dish – D7(After Root Backchip)		-	Acceptable
2	Bottom dish – D8(After Root Backchip)		-	Acceptable
3	Bottom dish – D9(After Root Backchip)		-	Acceptable
4	Bottom dish – D10(After Root Backchip)		-	Acceptable
5	Bottom dish – D11(After Root Backchip)		-	Acceptable
6	Bottom dish – D12(After Root Backchip)		-	Acceptable

For CAP		For Inspection Authority
Name: P.DEVANATHAN	Name: P.DEVANATHAN	Name: PRAKASH NAIK
Signature:	Signature:	Signature:
Date: 04/12/17	Date: 04/12/17	Date: 11/12/2018
NDE Level II:	NDE Level II:	Designation:
Performed By:	Interpreted & Evaluated By:	Witnessed/Reviewed By:

Legend – LI – Linear indication; RI – Rounded indications; NSD-No Significant Discontinuity

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LIQUID PENETRANT EXAMINATION REPORT

Client	STOCK	Project No	C290222
Job Description	Dish end Nozzles	Report No.	C290222/PT-BCS/001
Drawing No.	HC002573 Rev.A	Date of Test	23.11.2017
Material	SA 240M TYPE.304 to SA 312M TP 304	Penetrant	VISIBLE
Thickness (mm)	8.0, 2.77, 3.68	Cleaner/Remover	SKC-1 (17J02)
Procedure No. With Rev. No.	CAP/QA/P-08 Rev.02	Developer	SKD-S2 (17F0S)
Surface condition	As ground	Dwell Time	6 Minutes
Surface Temp.	27°C	Lighting Equipment	WHITE LIGHT (100 W Hand Lamp at a distance of 12 inch)
Penetrant System	SKL-SP1(17J11)	Light Intensity	WHITE 1000 LUX
Technique	Solvent removable	Development Time	11 Minutes

Acceptance
standard ASME Sec. VIII Div.1

S.No	PART NO / WELD NO	INTERPRETATION		RESULTS
		Type of Discontinuity	DIMENSION (Diameter/Length)	
1	Top dish – D1(After Root Backchip)	NSD	-	Acceptable
2	Top dish – D2(After Root Backchip)		-	Acceptable
3	Top dish – D3(After Root Backchip)		-	Acceptable
4	Top dish – D4(After Root Backchip)		-	Acceptable
5	Top dish – D5(After Root Backchip)		-	Acceptable

For CAP

Name: P.DEVANATHAN

Signature: *P. Devanathan*

Date: 23/11/17

NDE Level II:

Performed By:

Name: P.DEVANATHAN

Signature: *P. Devanathan*

Date: 23/11/17

NDE Level II:

Interpreted & Evaluated By:

For Inspection Authority

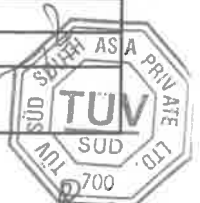
Name: PRAKASH NAIK

Signature: *P. Prakash Naik*

Date: 28/11/2017

Designation:

Witnessed/Reviewed By: *h*



Legend – LI – Linear indication; RI – Rounded indications; NSD-No Significant Discontinuity