|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **ULTRASONIC THICKNESS MEASUREMENT REPORT** | | | | | | | | | | |
| Company/Client | | **NCOC N. V.** | | Project | | **Eskene West** | | Location | | **Gas 2 Tr 2** |
| Line No/Tag No: | | **A1-330-VJ-202**  **Amin Regenerator** | | Material | | **According to table** | | Día × Nominal Thickness | | **According to table** |
| Procedure No: | | **QP-11-UTT-Q01 Rev 03**  **GOST 28702-90** | | Calibration Block | | **CS Step wedge** | | Probe  S/N | | **D790-SM**  **1196661** |
| Calibration block Range | | **6.5-25.0 mm** | | Angle | | **0º** |
| Manufacturing Code | | **ASME Sec VIII D1** | | Calibration Temp | | **+6º** | | Frequency | | **5 MHz** |
| Object Temp | | **+104º** | | Size | | **11 mm** |
| Acceptance Standard: | | **Acc. to the client specif.** | | Correction factors | | **Calculated by 38DL in high temperature mode automatically** | | Crystal | | **Dual** |
| Surface condition | | **Coated** | | Couplant | | **High temperature UT Gel ʺHiTempco"** | | Accuracy | | **± 0,1 mm** |
|  | | | | | | | | | | |
| S. No | Equipment/  Material Name | | Manufacturer | | Serial No | | Calibration certificate No | | Calibration Expiry date | |
|  | DL-38 | | OLYMPUS | | 171421601 | | BK-01-0674 | | 20-03-2020 | |
|  | Step wedge calibration block | | OLYMPUS | | 145414 | | - | | - | |
| **Job description:**   1. UT measurements were conducted on the Amin Regenerator A1-330-VJ-202 2. Echo-to-echo UT technique was used. | | | | | | | | | | |
| Notes:  N/A – not applicable.  FSH - Full Screen Height | | | | | | | | | | |

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| --- |
| **Drawing** |
| **A1-330-VJ-202** |

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| --- |
| **3D drawing** |
| **Loc R**  **Loc T** |

|  |  |
| --- | --- |
| **Inspection photos** | |
|  | **Plate**  **Shell** |
| **Loc R** | |
| **IMG_20191111_092507** | **Shell**  **Plate**  **Top**  123  113  103  9  8  7  6  5  4  3  2  1  63  163  153  143  133  123  113  103  93  83  73  53  43  3  2  1  260 mm  600 mm  **South**  **Bottom**  **North** |
| **Loc T** | |
| 1   * spot check   730 mm X 250 mm  - plate size | |

|  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- |
| **Inspection results, mm** | | | | | | | | |
| **S/N** | **Item description** | **Spot location** | **Nominal thickness shell, mm** | **Shell, mm** | | **Nominal thickness plate , mm** | | **Plate , mm** |
| 1 | Loc R | Spot-1 | \*20+3 | 20.58 | | No information | | 19.66 |
| 2 | Spot-2 | 20.61 | | 19.65 |
| 3 | Spot-3 | 20.60 | | 19.66 |
| 4 | Spot-4 | 20.64 | | 19.63 |
| 5 | Spot-5 | 20.64 | | 19.69 |
| 6 | Spot-6 | 20.60 | | 19.65 |
| 7 | Spot-7 | 20.61 | | 19.64 |
| 8 | Spot-8 | 20.61 | | 19.67 |
| 9 | Spot-9 | 20.63 | | 19.66 |
| 10 | Spot-10 | 20.64 | | 19.69 |
| 11 | Spot-11 | 20.57 | | 19.66 |
| 12 | Spot-12 | 20.58 | | 19.67 |
| 13 | Spot-13 | 20.60 | | - |
| 14 | Spot-14 | 20.62 | | - |
| 15 | Spot-15 | 20.63 | | - |
| 16 | Spot-16 | 20.60 | | - |
| 17 | Loc T | Spot-1 | \*20+3 | 20.71 | | No information | | 19.59 |
| 18 | Spot-2 | 20.73 | | 19.60 |
| 19 | Spot-3 | 20.69 | | 19.60 |
| 20 | Spot-4 | 20.69 | | 19.58 |
| 21 | Spot-5 | 20.67 | | 19.60 |
| 22 | Spot-6 | 20.72 | | 19.63 |
| 23 | Spot-7 | 20.70 | | 19.63 |
| 24 | Spot-8 | 20.68 | | 19.61 |
| 25 | Spot-9 | 20.72 | | 19.64 |
| 26 | Spot-10 | 20.74 | | 19.59 |
| 27 | Spot-11 | 20.73 | | 19.60 |
| 28 | Spot-12 | 20.73 | | 19.61 |
| 29 | Spot-13 | 20.68 | | - |
| 30 | Spot-14 | 20.69 | | - |
| 31 | Spot-15 | 20.75 | | - |
| 32 | Spot-16 | 20.70 | | - |
| Notes: \*Nominal thickness is taken according to Technical passport KE01-A1-PPFM001-L27-0007-000 | | | | | | | | |
| Examined by  UT L II cert. No 628  expiry date: 19.12.2022 | | Name: Dariskaliyev Nurdaulet | | | Signature: ...................... | | Date: 12 November 2019 | |
| Approved by  UT L III cert. No 2B 189/16  expiry date 31.05.2021 | | Name: Klindukhou Viachaslau | | | Signature: ...................... | | Date: 12 November 2019 | |
| Client Representative: | | ………………………….…. | | | Signature: ...................... | | Date: .................. | |