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| 01 | Customer | M/s. Schindler Ind. Pvt. Ltd-INW Plant. |
| 02 | Project | BENGALURU METRO |
| 03 | Truss Type | 9700-30-S |
| 04 | Job Name/No./Identification | LH Ladder |
| 05 | Contract No. | 690077116 |
| 06 | Drg. No. | Z43803854, Z599576, Z599500 |
| 07 | Material Specification | IS2062 E 250 A |
| 08 | Welding Process | GMAW |
| 09 | Stage of Inspection | After Final Welding |
| 10 | Test Equipment   1. Calibration date 2. Due date of calibration | GE-USM GO (12075200)  18.09.2021  17.09.2022 |
| 11 | Probes | 4 MHz, Size 8X9 mm,70:Angle Probe  4 MHz, Size Dia 10 mm, TR Probe |
| 12 | Search unit cable type and length | Co-axial, Mini Lemo to mini Lemo, 2 mtrs. |
| 13 | Couplant | Oil |
| 14 | Calibration Block | 2( K2) |
| 15 | Technique | Pulse Echo, Contact Method |
| 16 | Calibration (I)Range (II)Sensitivity (III)Ref dB  (IV)Scanning dB | 0-125 (for Angle Probe) & 0-25 (for TR Probe) DAC on 3 mm SDH  70:= 45 dB,0: TR Probe = 47 dB  Ref dB + 6 dB |
| 17 | Scanning Surface & Extent of Scanning | Ground Flush & Full Skip Distance From Both Sides |
| 18 | UT Specification &  Acceptance Criteria/Limit | EN ISO 17640:2019  EN ISO 11666:2018, Acceptance level 2 |
| 19 | Evaluation Level | H₀- 8 dB |
| 20 | Recording level | Acceptance level – 4 dB |
| 21 | Result: The weld joint with identification as below were ultrasonically tested for internal defects and found acceptable as per specification requirement. | |

Tested Part Details: -

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| **Weld length & thickness** | | | | | | | **Qty** | | |
| (125+75) X 12 mm Thick & (125+75) X 12 mm Thick | | | | | | | Four Joints each | | |
| **Joint Identification** | | Defect Position (mm) | | | Defect  Equivalent (mm) | Defect  Length (mm) | Repair  Times | Conclusion | Remarks |
| **Sr. No.** | LH | X  (Level) | Y  (Vertical) | Z  (Depth) |
| 1. | 25 | / | / | / | / | / | 0 | Acceptable |  |
| 2. | 27 | / | / | / | / | / | 0 | Acceptable |  |
| 3. | 31 | / | / | / | / | / | 0 | Acceptable |  |
| 4. | 71 | / | / | / | / | / | 0 | Acceptable |  |
| 5. | 73 | / | / | / | / | / | 0 | Acceptable |  |

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| Tested By | For, Kailash Vahan | Inspection Authority |
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| 01 | Customer | M/s. Schindler Ind. Pvt. Ltd-INW Plant. |
| 02 | Project | BENGALURU METRO |
| 03 | Truss Type | 9700-30-S |
| 04 | Job Name/No./Identification | RH Ladder |
| 05 | Contract No. | 690077116 |
| 06 | Drg. No. | Z43803854, Z599576, Z599500 |
| 07 | Material Specification | IS2062 E 250 A |
| 08 | Welding Process | GMAW |
| 09 | Stage of Inspection | After Final Welding |
| 10 | Test Equipment   1. Calibration date 2. Due date of calibration | GE-USM GO (12075200)  18.09.2021  17.09.2022 |
| 11 | Probes | 4 MHz, Size 8X9 mm,70:Angle Probe  4 MHz, Size Dia 10 mm, TR Probe |
| 12 | Search unit cable type and length | Co-axial, Mini Lemo to mini Lemo, 2 mtrs. |
| 13 | Couplant | Oil |
| 14 | Calibration Block | 2( K2) |
| 15 | Technique | Pulse Echo, Contact Method |
| 16 | Calibration (I)Range (II)Sensitivity (III)Ref dB  (IV)Scanning dB | 0-125 (for Angle Probe) & 0-25 (for TR Probe) DAC on 3 mm SDH  70:= 47 dB,0: TR Probe = 47 dB  Ref dB + 6 dB |
| 17 | Scanning Surface & Extent of Scanning | Ground Flush & Full Skip Distance From Both Sides |
| 18 | UT Specification &  Acceptance Criteria/Limit | EN ISO 17640:2019  EN ISO 11666:2018, Acceptance level 2 |
| 19 | Evaluation Level | H₀- 8 dB |
| 20 | Recording level | Acceptance level – 4 dB |
| 21 | Result: The weld joint with identification as below were ultrasonically tested for internal defects and found acceptable as per specification requirement. | |

Tested Part Details: -

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| **Weld length & thickness** | | | | | | | **Qty** | | |
| (125+75) X 12 mm Thick & (100+75) X 12 mm Thick | | | | | | | Four Joints each | | |
| **Joint Identification** | | Defect Position (mm) | | | Defect  Equivalent (mm) | Defect  Length (mm) | Repair  Times | Conclusion | Remarks |
| **Sr. No.** | RH | X  (Level) | Y  (Vertical) | Z  (Depth) |
| 1. | 26 | / | / | / | / | / | 0 | Acceptable |  |
| 2. | 28 | / | / | / | / | / | 0 | Acceptable |  |
| 3. | 32 | / | / | / | / | / | 0 | Acceptable |  |
| 4. | 72 | / | / | / | / | / | 0 | Acceptable |  |
| 5. | 74 | / | / | / | / | / | 0 | Acceptable |  |

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| Tested By | For, Kailash Vahan | Inspection Authority |
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