NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)
No. 5, Jalan Anggerik Mokara 31/45, Seksyen 31, Kota Kemuning, 40460 Shah Alam, Selangor Darul Ehsan, Malaysia.
Tel: 03-5122 9766/7/8 Fax: 03-5122 8766/7 E-mail: info@nusatek.com

Our Ref. : NT/103127/18-03

Report No: NDT/RT/180135-01/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Seremban Engineering Berhad
Project :	A17012NKT Utility Receiver Vessel
Material:	SA 240 GR 316L
Welding Process :	GTAW
Examination Code :	ASME V
Acceptance Code:	ASME Sect. VIII Div.1 : 2015 Ed. & PTS 12.20.01
Examination Date:	06 March 2018

Procedure No:	NT/RT/ASME REV 6.0
IQI type :	ASTM 1B
Film Manufacturer/Type :	FUJI 100(class II)
Density :	2.0-3.5
Sensitivity:	0.33mm(5 wires visible)
Source to Object Distance :	400mm
Source Side of Object to Film Distance:	(8+3)mm
No of Radiograph(exposure) :	Single Exposure
No. of Film Each Cassette :	1 Film
Radiographic Technique :	SWSI
Film Viewing Technique :	Single Wall Viewing
Source Type/Size :	Iridium192 (3.2mm)
Location Markers :	Source Side

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
V-5430 U125								
CS 1 (WN-189)	11	3	–	8	0 - 1	NRI	Accept	
					1 - 2	NRI	Accept	
					2 - 3	NRI	Accept	
					3 - 4	Por	Accept	
					4 - 5	NRI	Accept	
					5 - 6	NRI	Accept	
					6 - 7	NRI	Accept	
					7 - 0	Uc	Accept	

End of Report

Legend:

TI : Tungsten Inclusion	*NRI : No Relevant Indication*	*Uc : Undercut*	*Por : Porosity*	*WT : Weld Thickness*
SI : Slag Inclusion	*LP : Lack of Penetration*	*Con : Concavity*	*BT : Burn Through*	*RT : Reinforcement Thickness*
LF : Lack of Fusion	*EP : Excess Penetration*	*AR : Artifact*	*Sur : Surface*	

Personnel Particulars

Radiographer : Emirsham - NDT Lev. II

Interpreted & Evaluated By: Amat Hamidi - NDT Lev.II

Date: 07 March 2018

NUSANTARA TECHNOLOGIES SDN. BHD. NDT Division (187753-D)

Client Representative:

Name:

Date:

NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)
No. 5, Jalan Anggerik Mokara 31/45, Seksyen 31, Kota Kemuning, 40460 Shah Alam, Selangor Darul Ehsan, Malaysia.
Tel: 03-5122 9766/7/8 Fax: 03-5122 8766/7 E-mail: info@nusatek.com

Our Ref. : NT/103127/18-03

Report No: NDT/RT/180135-02/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Seremban Engineering Berhad
Project :	17/01567PNKT Disperser Tank
Material:	SA 240 GR 316L
Welding Process :	GTAW / SMAW
Examination Code :	ASME V
Acceptance Code:	ASME Sect. VIII Div.1 : 2017 Ed.
Examination Date:	06 March 2018

Procedure No:	NT/RT/ASME REV 7.0
IQI type :	ASTM 1B
Film Manufacturer/Type :	FUJI 100(class II)
Density :	2.0-3.5
Sensitivity:	0.33mm(5 wires visible)
Source to Object Distance :	400mm
Source Side of Object to Film Distance:	(12+3)mm
No of Radiograph(exposure) :	Single Exposure
No. of Film Each Cassette :	1 Film
Radiographic Technique :	SWSI
Film Viewing Technique :	Single Wall Viewing
Source Type/Size :	Iridium192 (3.2mm)
Location Markers :	Source Side

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
V-5430 U125								
SLS 6 (WN-75/73)	15	3	–	12	0 - 1	NRI	Accept	
					1 - 2	NRI	Accept	
					2 - 3	NRI	Accept	
					3 - 4	NRI	Accept	
					4 - 5	NRI	Accept	
					5 - 6	NRI	Accept	
					6 - 7	Por	Accept	
					7 - 8	NRI	Accept	
					8 - 9	Por	Accept	
					9 - 10	NRI	Accept	
					10 - 11	NRI	Accept	

End of Report

Legend:

TI : Tungsten Inclusion	*NRI : No Relevant Indication*	*Uc : Undercut*	*Por : Porosity*	*WT : Weld Thickness*
SI : Slag Inclusion	*LP : Lack of Penetration*	*Con : Concavity*	*BT : Burn Through*	*RT : Reinforcement Thickness*
LF : Lack of Fusion	*EP : Excess Penetration*	*AR : Artifact*	*Sur : Surface*	

Personnel Particulars

Radiographer : Emirsham - NDT Lev. II

Interpreted & Evaluated By: Amat Hamidi - NDT Lev.II

Date: 07 March 2018

NUSANTARA TECHNOLOGIES SDN. BHD. * (187753-D) * NDT Division

Client Representative:

Name:

Date:

NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)
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Our Ref. : NT/103127/18-03

Report No: NDT/RT/180135-03/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Seremban Engineering Berhad	Procedure No:	NT/RT/ASME REV 7.0
Project :	17/01567PNKT Disperser Tank	IQI type :	ASTM 1B
		Film Manufacturer/Type :	FUJI 100(class II)
		Density :	2.0-3.5
		Sensitivity:	0.33mm(5 wires visible)
Material:	SA 516 Gr 70	Source to Object Distance :	400mm
		Source Side of Object to Film Distance:	(12.7+3)mm
Welding Process :	GTAW / SMAW	No of Radiograph(exposure) :	Single Exposure
Examination Code :	ASME V	No. of Film Each Cassette :	1 Film
Acceptance Code:	ASME Sect. VIII Div.1 : 2017 Ed.	Radiographic Technique :	SWSI
		Film Viewing Technique :	Single Wall Viewing
Examination Date:	06 March 2018	Source Type/Size :	Iridium192 (3.2mm)
		Location Markers :	Source Side

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
V-5430 U125								
JLS 2 (WN-75/73)	15.7	3	–	12.7	0 - 1	Por	Reject	
					1 - 2	Por	Accept	
					2 - 3	NRI	Accept	
					3 - 4	NRI	Accept	
					4 - 5	Por	Accept	
					5 - 6	NRI	Accept	
					6 - 7	Por	Accept	
					7 - 8	Por	Accept	
					8 - 9	Por	Accept	
					9 - 10	Sur	Accept	

End of Report

Legend:

TI : Tungsten Inclusion	*NRI : No Relevant Indication*	*Uc : Undercut*	*Por : Porosity*	*WT : Weld Thickness*
SI : Slag Inclusion	*LP : Lack of Penetration*	*Con : Concavity*	*BT : Burn Through*	*RT : Reinforcement Thickness*
LF : Lack of Fusion	*EP : Excess Penetration*	*AR : Artifact*	*Sur : Surface*	

Personnel Particulars

Radiographer :	Emirsham - NDT Lev. II	Client Representative:	
Interpreted & Evaluated By:	Amat Hamidi - NDT Lev.II	Name:	
Date:	07 March 2018	Date:	

NUSANTARA TECHNOLOGIES SDN. BHD. NDT Division (187753-D)