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/103219/18-03

Report No: NDT/RT/180157-03/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Seremban Engineering Berhad
Project :	A17013(IZZ) S/N : U138 Intergrated Flow Stabiliser & Desanding Vessel
Material:	S31803
Welding Process :	GTAW / SMAW
Examination Code :	ASME V
Acceptance Code:	ASME Sect. VIII Div.1 : 2017 Ed.
Examination Date:	10 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:	(25+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 :	Film Side

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
S-0420								
CW 2 R1 (WN-195)	28	3	–	25	4 - 5	Uc	Reject	

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: 11 March 2018

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

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/103219/18-03

Report No: NDT/RT/180157-01/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Seremban Engineering Berhad
Project :	A17013(IZZ) S/N : U138 Intergrated Flow Stabiliser & Desanding Vessel
Material:	S31803
Welding Process :	GTAW / SMAW
Examination Code :	ASME V
Acceptance Code:	ASME Sect. VIII Div.1 : 2017 Ed.
Examination Date:	09 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:	(25+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 :	Film Side

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
S-0420								
CW 1 R1 (WN-95/50)	28	3	–	25	7 - 8	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: 10 March 2018

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

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/103219/18-03

Report No: NDT/RT/180157-02/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Seremban Engineering Berhad
Project :	A17013(IZZ) S/N : U138 Intergrated Flow Stabiliser & Desanding Vessel
Material:	S31803
Welding Process :	GTAW / SMAW
Examination Code :	ASME V
Acceptance Code:	ASME Sect. VIII Div.1 : 2017 Ed.
Examination Date:	10 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:	(25+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 :	Film Side

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
S-0420								
CW 2 R1 (WN-195)	28	3	–	25	0 - 1	NRI	Accept	
					1 - 2	Por / Sur	Accept	
					2 - 3	Por	Accept	
					3 - 4	Por	Accept	
					5 - 6	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: 11 March 2018

NUSANTARA TECHNOLOGIES SDN BHD (187753-D) NDT Division

Client Representative:

Name:

Date: