



NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)

No. 5, Jalan Anggerik Mokara 31/45, Seksyen 31, Kota Kemuning, 40460 Shah Alam, Selangor Darul Ehsan, Malaysia.

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Our Ref. : NT/103630/18-12

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Report No: FNDT/RT/180503-12/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 231 R1	10	3	141.3	7	2 - 0	Per	Reject	

End of Report

Legend:

TI: Tungsten Inclusion	NRI: No Relevant Indication	Uo: 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: 03 May 2018

Date:





NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)

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Our Ref. : NT/103630/18-12

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Report No: I NDT/RT/180503-11/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 119 R1	10	3	141.3	7	1 - 2 2 - 0	Por NRI	Reject 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: 03 May 2018



Client Representative:

Name:
Date:



Our Ref.: NT/103630/18-12

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 Report No: I NDT/RT/180503-10/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single Viewing
		Source Type/Size :	Iridium192 (3.2mm)
		Location Markers :	Film Side

Radiographic Examination Result

Weld Reference (Welder No)	WT	RT	Pipe Diameter	Material Thickness	Film Position	Film Interpretation	Result	Remarks
	(mm)	(mm)	(mm)	(mm)				
JT 122 R1	10	3	141.3	7	0 - 1	LF	Reject	
					2 - 0	NRI	Accept	

End of Report

Legend:

TI: Tungsten Inclusion	NRI: No Relevant Indication	Uc: Undercut	Por: Porosity	WT: Weld Thickness
SI: Sleg 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: 03 May 2018

Client Representative:



Name:
Date:



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Report No: I NDT/RT/180503-09/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 22 R1	10	3	141.3	7	0 - 1 LF		Reject	
					1 - 2 EP		Accept	
					2 - 0 LF		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: 03 May 2018

Client Representative:

Name:
Date:





NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)

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RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 52	10	3	141.3	7	0 - 1	NRI	Accept	
					1 - 2	Por	Reject	
					2 - 0	LF / Por	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: 03 May 2018



Client Representative:

Name:
Date:



NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)

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RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 29	10	3	141.3	7	0 - 1	LF	Reject	
					1 - 2	LF	Reject	
					2 - 0	LF	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

Client Representative:

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

Date: 03 May 2018

Name:

Date:





NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)

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Our Ref.: NT/103630/18-12

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Report No: I NDT/RT/180503-06/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 28	10	3	141.3	7	0 - 1	NRI	Accept	
					1 - 2	NRI	Accept	
					2 - 0	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: 03 May 2018



Client Representative:

Name:
Date:



Our Ref.: NT/103630/18-12

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Report No: NDT/RT/180503-05/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	141.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 19 R1	10	3	141.3	7	0 - 1	NRI	Accept	
					1 - 2	NRI	Accept	
					2 - 0	NRI	Accept	
JT 30 R1	10	3	141.3	7	0 - 1	NRI	Accept	
					1 - 2	NRI	Accept	
					2 - 0	NRI	Accept	
JT 64 R1	10	3	141.3	7	0 - 1	NRI	Accept	
					1 - 2	NRI	Accept	
					2 - 0	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

Client Representative:

Interpreted & Amat Hamidi - NDT Lev. II

Evaluated By:

Date:

03 May 2018



Name:

Date:



Our Ref.: NT/103630/18-12

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Report No: I NDT/RT/180503-04/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1B
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.33mm(5 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	114.3mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(7+3)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWSI
		Film Viewing Technique :	Single 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
JT 213 R1	10	3	114.3	7	0 - 1	Inc	Reject	
					1 - 2	Inc	Reject	
					2 - 0	Inc	Reject	

End of Report

Legend:

TI: Tungsten Inclusion	NRI: No Relevant Indication	Uo: 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: 03 May 2018



Client Representative:
 Name:
 Date:



Our Ref. : NT/103630/18-12

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 Report No: I NDT/RT/180503-03/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client : Recron (M) Sdn Bhd	Procedure No: NT/RT/ASME Rev. 7.0
Project : HTM Piping	IQI type : ASTM 1B
Material: Carbon Steel	Film Manufacturer/Type : FUJI 100(class II)
Welding Process : GTAW	Density : 2.0 - 3.5
Examination Code : ASME V	Sensitivity: 0.33mm(5 wires visible)
Acceptance Code: ASME B31.3	Source to Object Distance : 114.3mm
Examination Date: 02 May 2018	Source Side of Object to Film Distance: (7+3)mm
	No of Radiograph(exposure) : Single Exposure
	No. of Film Each Cassette : 1 Film
	Radiographic Technique : DWSI
	Film Viewing Technique : Single 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
JT 212 R1	10	3	114.3	7	0 - 1	Por / Uc	Accept	
JT 215 R2	10	3	114.3	7	1 - 2	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: 03 May 2018



Client Representative:

Name:

Date:



Our Ref. : NT/103630/18-12

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RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1A
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.20mm(2 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	400mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(73)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWDI
		Film Viewing Technique :	Double 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
JT 191 R1	7	3	73	4	X	Inc	Reject	
					Y	Inc	Reject	
					Z	Inc	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: 03 May 2018



Client Representative:

Name:
Date:



Our Ref.: NT/103630/18-12

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RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Recron (M) Sdn Bhd	Procedure No:	NT/RT/ASME Rev. 7.0
Project :	HTM Piping	IQI type :	ASTM 1A
Material:	Carbon Steel	Film Manufacturer/Type :	FUJI 100(class II)
Welding Process :	GTAW	Density :	2.0 - 3.5
Examination Code :	ASME V	Sensitivity:	0.20mm(2 wires visible)
Acceptance Code:	ASME B31.3	Source to Object Distance :	400mm
Examination Date:	02 May 2018	Source Side of Object to Film Distance:	(73)mm
		No of Radiograph(exposure) :	Single Exposure
		No. of Film Each Cassette :	1 Film
		Radiographic Technique :	DWDI
		Film Viewing Technique :	Double Viewing
		Source Type/Size :	Iridium192 (3.2mm)
		Location Markers :	Film Side

Radiographic Examination Result

Weld Reference (Welder No)	WT	RT	Pipe Diameter	Material Thickness	Film Position	Film Interpretation	Result	Remarks
	(mm)	(mm)	(mm)	(mm)				
JT 187 R1	7	3	73	4	Y	NRI	Accept	

End of Report

Legend:

TI: Tungsten Inclusion	NRI: No Relevant Indication	Uo: 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: 03 May 2018

Client Representative:



Name:
Date: