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/103769/18-02

Report No: NDT/RT/180626-01/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Pisces Engineering Sdn Bhd	Procedure No:	NT/RT/ASME Rev7.0
		IQI type :	ASTM 1B
Project :	Crown 9 Tray High X Ø180" DTDC With Ø200" Dome.	Film Manufacturer/Type :	FUJI 100(class II)
		Density :	2.0 - 3.5
Job No:	PCI - 180211	Sensitivity:	0.33mm(5 wires visible)
Material:	SA 106 GR B / SA 234 WPB	Source to Object Distance :	400mm
		Source Side of Object to Film Distance:	(48.3)mm
Welding Process :	GTAW	No of Radiograph(exposure) :	Single Exposure
Examination Code :	ASME V	No. of Film Each Cassette :	1 Film
Acceptance Code:	ASME Sec VIII Div 1 - 2017 Ed.	Radiographic Technique :	DWDI
		Film Viewing Technique :	Double Wall Viewing
Examination Date:	28 May 2018	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
P-1 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-2 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-3 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	

Continue Next Page

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 :	Akbar Ramin - ASNT Level II	Client Representative:	
Interpreted & Evaluated By:	M.Nazib - NDT Level II	Name:	
Date:	29 May 2018	Date:	

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

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/103769/18-02
Job No: PCI - 180211

Report No: NDT/RT/180626-01/18

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
P-4 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-5 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-6 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-7 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-8 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-9 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	
P-10 JT-1 (W-41)	10.14	3	48.3	7.14	X	NRI	Accept	
					Y	NRI	Accept	

End of Report

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

NUSATEK

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/103769/18-02

Report No: NDT/RT/180626-02/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Pisces Engineering Sdn Bhd
Project :	Crown 9 Tray High X Ø180" DTDC With Ø200" Dome.
Job No:	PCI - 180211
Material:	SA 234 WPB
Welding Process :	GTAW
Examination Code :	ASME V
Acceptance Code:	ASME Sec VIII Div 1 - 2017 Ed.
Examination Date:	28 May 2018

Procedure No:	NT/RT/ASME Rev7.0
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:	(60.3)mm
No of Radiograph(exposure) :	Single Exposure
No. of Film Each Cassette :	1 Film
Radiographic Technique :	DWDI
Film Viewing Technique :	Double 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
P-1 JT-2 (W-41)	11.74	3	60.3	8.74	X	NRI	Accept	
					Y	NRI	Accept	
P-2 JT-2 (W-41)	11.74	3	60.3	8.74	X	NRI	Accept	
					Y	NRI	Accept	
P-3 JT-2 (W-41)	11.74	3	60.3	8.74	X	NRI	Accept	
					Y	NRI	Accept	

Continue Next Page

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 : Akbar Ramin - ASNT Level II

Interpreted & Evaluated By: M.Nazih - NDT Level II

Date: 29 May 2018

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

Client Representative:

Name:

Date:

NUSATEK

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/103769/18-02
Job No: PCI - 180211

Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
P-4 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	
P-5 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	
P-6 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	
P-7 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	
P-8 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	
P-9 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	
P-10 JT-2 (W-41)	11.74	3	60.3	8.74	X Y	NRI NRI	Accept Accept	

End of Report

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