



NUSANTARA TECHNOLOGIES SDN. BHD. (187753-D)

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Our Ref.: NT/103456/18-03

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Report No: NDT/RT/180344-01/18

RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client :	Tenaga Tiub Sdn Bhd	Procedure No:	NT/RT/ASME Rev 6.0
Project :	2nd Stage Intercooler	IQI type :	ASTM 1A
Job No:	TT 17198 (TT-802U)	Film Manufacturer/Type :	FUJI 100(classII)
Material:	SA 240-304L	Density :	2.2-3.8
Welding Process :	GTAW	Sensitivity:	0.20mm(2 wires visible)
Examination Code :	ASME V	Source to Object Distance :	210mm
Acceptance Code:	ASME Sect. VIII DIV.1 : 2015 Ed.+Tema 9TH Ed.	Source Side of Object to Film Distance:	(0.8+3)mm
Examination Date:	06 April 2018	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
Expansion Bellow LS 1 (WN346)	3.8	3	210	0.8	0 - 1	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 & Evaluated By: Amat Hamidi - NDT Lev. II

Date: 07 April 2018

Name:
Date:





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RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client : Tenaga Tiub Sdn Bhd Project : Surface Condenser Job No: TT 17146 Material: SA 516 GR 70 Welding Process : GTAW / SMAW Examination Code : ASME V Acceptance Code: ASME Sect. VIII DIV.1 : 2015 Ed.+Tema 9TH Ed. Examination Date: 06 April 2018	Procedure No: NT/RT/ASME Rev 6.0 IQI type : ASTM 1B Film Manufacturer/Type : FUJI 100(classII) Density : 2.2-3.8 Sensitivity: 0.33mm(5 wires visible) Source to Object Distance : 400mm Source Side of Object to Film Distance: (15.9+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
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Radiographic Examination Result

Weld Reference (Welder No)	WT (mm)	RT (mm)	Pipe Diameter (mm)	Material Thickness (mm)	Film Position	Film Interpretation	Result	Remarks
E-54-01A								
LS 2 R1 (WN220)	18.9	3	-	15.9	0 - 1	SI	Reject	
					1 - 2	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: 07 April 2018



Client Representative:
 Name:
 Date:



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RADIOGRAPHIC EXAMINATION REPORT

Client and Testing Particulars

Client : Tenaga Tiub Sdn Bhd	Procedure No: NT/RT/ASME Rev 6.0
Project : Surface Condenser	IQI type : ASTM 1B
Job No: TT 17146	Film Manufacturer/Type : FUJI 100(classII)
Material: SA 516 GR 70	Density : 2.2-3.8
Welding Process : GTAW / SMAW	Sensitivity: 0.33mm(5 wires visible)
Examination Code : ASME V	Source to Object Distance : 400mm
Acceptance Code: ASME Sect. VIII DIV.1 : 2015 Ed.+Tema 9TH Ed.	Source Side of Object to Film Distance: (15.9+3)mm
Examination Date: 06 April 2018	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	RT	Pipe Diameter	Material Thickness	Film Position	Film Interpretation	Result	Remarks
	(mm)	(mm)	(mm)	(mm)				
E-54-01A								
LS 1 R1 (WN220)	18.9	3	--	15.9	6 - 7 8 - 9	Por Inc	Reject 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: 07 April 2018

Client Representative:



Name:
Date: