



**NON DESTRUCTIVE EXAMINATION REPORT**

Report No. 30810-61150-002-00-3220

Customer : Cockerill  
 Customer Ref. : C/61/31285  
 Manufact. Order: 30810  
 Job order : 61150  
 Sequence : 3220  
 Drawing : ED 006-1-1  
 Item : 002

Item description: Spherical Ring 002  
 Part examined: Complete  
 Inspection by: Cockerill  
 Framatome  
 RN/QC

**Description of Examination**

**MT** A.C. | D.C. \_\_\_\_\_ Prod | Yoke | Coil | Central conductor \_\_\_\_\_ Dry | Wet | Fluorescent  
 Apparatus: \_\_\_\_\_ No.: ID- \_\_\_\_\_ Type of powder:  
 Prod. distance: \_\_\_\_\_ Oil | water suspended  
 Ampere per inch: \_\_\_\_\_ Degmagnetised: yes|no  
 Ampere turns:  
 Specification:

**PT** Colour contrast | Fluorescent  
 Type penetrant: \_\_\_\_\_ batch no.:  
 Type cleaner: \_\_\_\_\_ batch no.:  
 Type developer: \_\_\_\_\_ batch no.:  
 Specification:

**UT** Long. | Shear Time base: 250 - 500 mm. Amplification: Acc. to spec.  
 Apparatus: *Wip 10 W* No.: ID: *305*  
 Transducers: *B25, W845, W860 (2 mV)*  
 Couplant: *Oil*  
 Reference standard No.: *IIW + C.H.L. 002*  
 Specification: PS 21.74 rev.2 + ASME Code section XI incl. Winter 1973 addenda.

Other Tests:

Surface condition: *Machined*

Results: 

NOT ACCEPTABLE
REPORTABLE INDICATIONS
ACCEPTABLE

Remarks:

Attachments: *5*

Var. required *NO* See Var. Report

Dev. required *NO* See Dev. Request

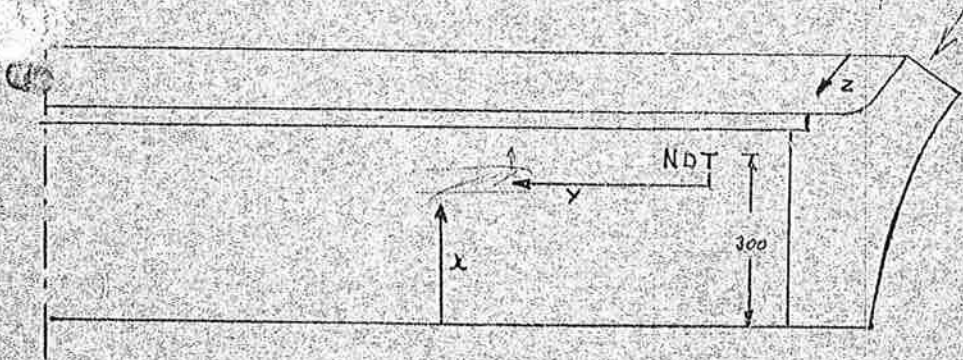
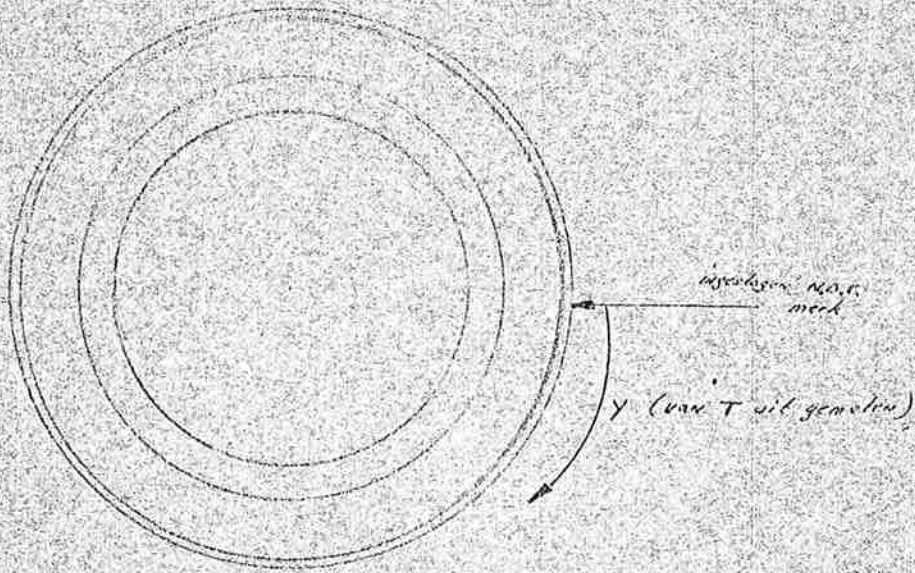
Reviewed by Inspection:

Date:





spherical ring 002









UT CALIBRATION RECORD

Sheet No. 1

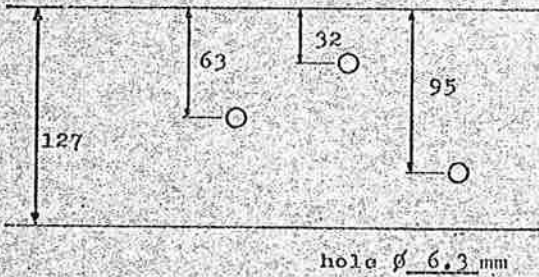
Straight beam examination weld edges

APPARATUS Krautkrämer type USIP10W  Serial No. ID-305  
 USM2  Serial No. ID-  
 SEARCH UNIT Krautkrämer type B2S  Serial No. 302  
 Crystal size 24 mm  $\phi$    
 Frequency 2 MHz

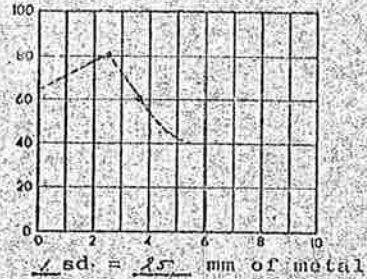
INSTRUMENT SETTINGS Test range 250 mm  
 Gain 62 dB  
 Frequency 2 MHz (for USIP10W)  
 Pulse energy 1

COUPLANT Starch   
 Other oil

CALIBRATION BLOCK No. CKL 002



RESULTS



CALIBRATION RECHECK

Time	<u>7:10</u>	<u>11:45</u>		
Initials	<u>[Redacted]</u>	<u>[Redacted]</u>		

REMARKS

[Redacted] Level IIA

Reviewed by \_\_\_\_\_ Level \_\_\_\_\_  
 Date \_\_\_\_\_





UT CALIBRATION RECORD

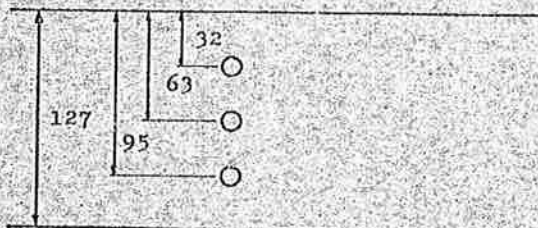
Sheet No. 2

Angle beam examination weld edges

APPARATUS Krautkrümer type USIP10W  Serial No. ID-105  
 USM2  Serial No. ID-  
 SEARCH UNIT Krautkrümer type WB45  WB60  Serial No. 100  
 Crystal size 20x22 mm   
 Frequency 2 MHz   
 INSTRUMENT SETTINGS Test range 250 mm  
 Gain 50 dB  
 Frequency 2 MHz (for USIP10W)  
 Pulse energy 1

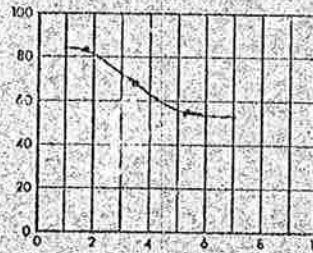
COUPLANT Starch   
 Other oil

CALIBRATION BLOCK No. CKL 002



hole  $\phi$  6.3mm

RESULTS



$\Delta$ sd = 25 mm of metal

CALIBRATION RECHECK

Time	<u>7.45</u>	<u>13.30</u>			
Initials					

REMARKS

Examiners [Redacted] Level IIA

Reviewed by \_\_\_\_\_ Level \_\_\_\_\_

Date \_\_\_\_\_





UT CALIBRATION RECORD

Sheet No. 3

Angle beam examination weld edges

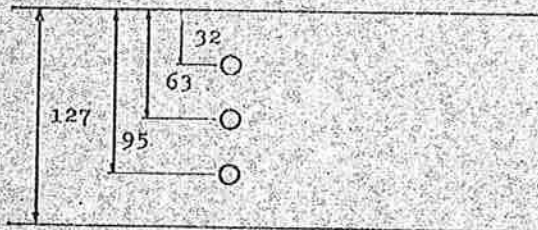
APPARATUS Krautkrämer type USIP10W  Serial No. 10-305  
 USM2  Serial No. 10-

SEARCH UNIT Krautkrämer type WB45  WB60  Serial No. 10-  
 Crystal size 20x22 mm   
 Frequency 2 MHz

INSTRUMENT SETTINGS Test range 500 mm  
 Gain 50 dB  
 Frequency 2 MHz (for USIP10W)  
 Pulse energy 1

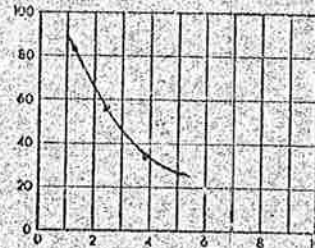
COUPLANT Starch   
 Other oil

CALIBRATION BLOCK No. CKL 002



hole  $\phi$  6.3 mm

RESULTS



$\lambda_{sd} = 50$  mm of metal

CALIBRATION RECHECK

Time	<u>0.00</u>	<u>1.00</u>			
Initials					

REMARKS

Exam CS Level IIA

Reviewed by \_\_\_\_\_ Level \_\_\_\_\_

Date \_\_\_\_\_