RPR. N°: 81641 Pag. 1 of 1	**Test Report RT** **RADIOGRAPHIC EXAMINATION REPORT**	Controlli Radiografici Cattaneo

Job: CRC: 382/12	Order:	Customer: **NUOVA OLEODINAMICA BONVICINI Srl**

Object:

N°2 CANNETTE CA4159 - CA4159A

Code: ASME V ED.2010 ASME V ART.2/22	Specific: ACCEPT. ASME VIII DIV.1 UW51 APP.4	Procedure: C.R.C POI-001 RT./3	Drawing:

EXAMINATION CONDITION

SOURCE TYPE: RX ■ Rγ Ir. 192 ❑

TRADE NAME: SEIFERT 300/3

FOCAL SPOT: 3 mm

THICKNESS: 6 ÷8 mm

ENERGY: 260 Kv. 3 m.A.

FOCAL DIST.: 700mm EXP.TIME: 1'

I.Q.I : ASTM 1A

FILM SIDE ❑ SOURCE SIDE ■

FILM TYPE AGFA D4

SINGLE FILM ■ DOUBLE FILM ❑

SINGLE WALL ❑ DOUBLE WALL ■

FRONT SCREEN Pb. THK. 0,10 mm

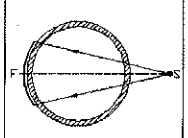
BACK SCREEN Pb. THK. 0,15 mm

Film size: 10 x 16 cm. ■

DEVELOPMENT: AUTOMATIC

RADIOGRAPHIC TECNIQUE

■



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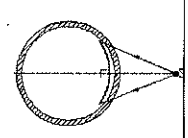

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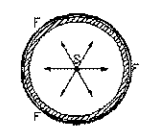

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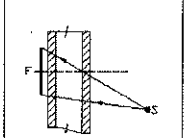

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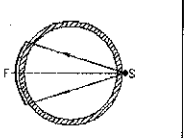

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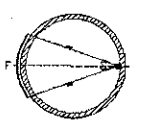


MATERIAL: E235/E355

SURFACE CONDITION :

AS WELDED ■ MACHINED ❑

AS FORGED ❑

TECHNICAL DATA FILMS

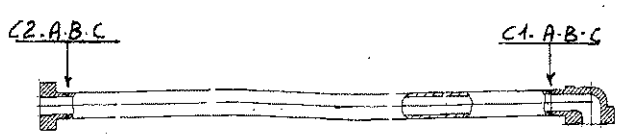
Pos.	Radiography	Weld Nr.	Discontinuity	Decision	Note
A	CA4159	C1	Aa	ACC.	
B	"	"	Aa	ACC.	
C	"	"	Aa	ACC.	
A	"	C2	I	ACC.	
B	"	"	I-Aa	ACC.	
C	"	"	S	ACC.	
A	CA4159/A	C1		ACC.	
B	"	"	Aa	ACC.	
C	"	"	Aa	ACC.	
A	"	C2	Aa	ACC.	
B	"	"	Aa-I	ACC.	
C	"	"	Aa-I	ACC.	

Essential Wire: N°6 Ø 0.25 mm Density: 1.8 ÷ 4

Acc. = ACCEPTABLE **Rip. = TO REPAIR** **Z = TO REPEAT**

B: Slag inclusion	M: Shrinkage cavities	E: Cracks
S: Tungsten inclusion	F: Undercutting	G: Root groove
A: Gas bubbles	D: Incomplete penetration	H: Edges misalignment
C: Lack of fusion	Aa: Pore-Porosity	Ab: Worm holes
Be: Defect root	N: Sagged weld	I: Irregular weld seam
	K: End crater	L: Excess of penetration

SKETCH OF PIECE



RESULT: ■ **CONFORM TO SPECIFICATIONS** ❑ **NOT CONFORM TO SPECIFICATIONS**

Operator: Level: II TACCHINI M.	Date:	Inspector:	Date:
Evaluator: Level: III TACCHINI G.	Date: 27/06/12	Inspector:	Date:

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