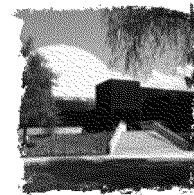




APPLIED TECHNOLOGY SERVICES

Non Destructive Examination

3400 Crow Canyon Road, San Ramon, CA 94583



Data Sheet for RT Characterization of DSAW vs. SSAW Pipeline long seam welds

Examiner/Level (Print): _____

(Sign) _____

Company: PGE / ATS

Interpreter/Level (Print) _____

(Sign) _____

Company: PGE / ATS

Reviewer/Level (Print) _____

(Sign) _____

Company: PGE / ATS

Date: _____

Line No.: _____

Location: _____

GPS data: _____

Pipe Size: _____

Documented pipe thickness: _____

Minimum thickness found: _____

OD Corrosion: Yes* No*

NDT Equipment, Procedures and Results

RT Procedure #: _____

Length of weld examined: _____

RT method: X Ray* Gamma* Se⁷⁵
Ir¹⁹²

Acceptable to API 5L: Yes* No*

UT Procedure #: _____

UT Equip. Serial numbers: _____

Surface NDT Procedure #: _____

Surface NDT method: _____

Surface NDT results: _____

Acceptable or Rejectable: Accept* Reject*

Note * delete or line through where applicable

Weld Characterization

DSAW

SSAW

OTHER

Similar width OD & ID crowns.

OD crown but no uniform ID crown.

Only OD crown, with possible ID repairs.

Light density at weld center across superimposed crowns.

Evidence of possible use of temporary chill ring.

Evidence of repairs.

Visible edges of OD & ID weld crowns.

More uniform density across weld crown indicating less reinforcement on ID.

Grinding marks.

In the "Flat Topped" area, the ID weld crown will have a uniform density across the 4-inch area and a weld bead characteristic of a machine submerged arc weld (uniform with bead width similar to OD crown).

Root geometry.

Moderate weld indications observed.

