SHAW PIPELINE SERVICES

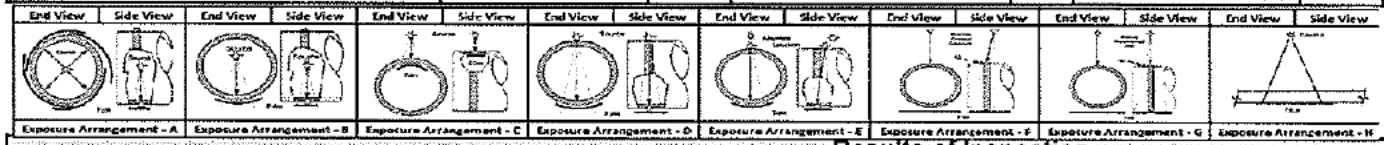
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Report Date:	9/14/2021 Rev 1	**Unit ID:**	37643	**Customer:**	Southern Company Gas	**Page:**	1 of 1
Report #:	1	**No of Men:**	2	**Client AFE:**	~~039162~~ 039126	**Proc. ID & Rev.:**	
Weld Count:	4	**Per-Diem:**	No	**Project ID:**		**Standard/Code:**	API 1104 20th Edition
Hours:	8	**SPS Project #:**	4133GA3	**Client Specs:**	API 1104	**Req. Sensitivity:**	≤ 2%
Miles:	120	**Location:**	Union City, Ga				

Procedure / Technique Details

Tech #	Exposure Arrange	Material	Pipe Dia. or Other	Object Thickness w/Reinf.	Source to Object	Object (") to Film (")	Geometric Unsharpness (Ug)	IQI # & Placement Note**	IQI Group# Size or Set	Essential Wire/ Hole Required?	IQI Side: Source or Film?	Shim Material & Thickness	Heat Shield Used	Film Brand & Type	Source	Focal Spot	Curies Kv/ma:	Screen TM/ Material Front	Screen TM/ Material Back	Exposure Tme (ci/ma Min.)	Viewing Single Composite X	Density Min/Max
1	D	CS	2.5"	.154"	0.5"	3"	0.01	B	1A	.0063"-#4	Film	N/A	N/A	AGFA D3	Ir 192	0.14	61	.010 Pb	.010 Pb	6.1	Single	1.8-3.8
2																						
3																						
4																						

Processing:	Chemistry Temp (°F):	Development Time (min):	Stop Bath Time (min):	Fix Time (min):	Rinse Time (min):
☑ Manual ☐ Automatic	75	3:15	1:00	3:00	1:00



IQI Placement Note**

A- 1 IQI Centered in Area of Interest
B- 1 IQI in first inch and 1 Centered
C- 4 Equally spaced around circumference
D-

Heat Shield Material:

Results of Inspection

#	Weld Number/Part ID	Tech. #:	View	Pipe Size	Nominal Thickness	Results Pass	Results Fail	No. of Exposures	Exposure Type	Welder Stencils	Welding Process	Defect Location, Station Number & Remarks
1	XR-1	1	0-0	2"	.154"	Pass	N/A	4	DWE/SWV	050664	SMAW	Film Id'd in error as AFE 039162
2	XR-2	1	0-0	2"	.154"	Pass	N/A	4	DWE/SWV	050664	SMAW	
3	XR-3	1	0-0	2"	.154"	Pass	N/A	4	DWE/SWV	050664	SMAW	
4	XR-4	1	0-0	2"	.154"	Pass	N/A	4	DWE/SWV	050664	SMAW	
5												
6												
7												
8												
9												Project Coordinator: [redacted]
10												

Indication Abbreviations:

POR- Porosity
CP- Cluster Porosity
SP- Scattered Porosity
IP- Incomplete Penetration
IPD Incomplete Penetration w/Hi/low
IF- Incomplete Fushion
ISI- Isolated Slag Inclusion
ESI- Elongated Slag Inclusion
LI- Linear Indication
RI- Rounded Indication
PP- Piping Porosity
HB- Hollow Bead
EU- External Undercut
IU- Internal Undercut
IC- Internal Concavity
C- Crack
BT- Burn Through
LC- Low Cap

[redacted] Level II Technician (Print)

[redacted] Level II Technician Signature

[redacted] Level I or Trainee (Print)

Level I or Trainee (Print)

Client Name (Print)

Customer signature signifies agreement with time & materials as listed in report and continuing pages. Results of inspection only identify evaluation as compared to the specified acceptance criteria and does not make any guarantee in the ability to perform within the intended service application. This evaluation does not offer any modification or assumption in regards to engineering design.

X

Client Signature

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