



INSPECTION REPORT

Project: ■■■■■■■■

Date: 23-August-2012

Supplier: ■■■■■■■■

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Client:	■■■■■
Client's ref.:	■■■■■
Inspecteam Project No.:	■■■■■
Inspector's Name:	Mr. ■■■■■
Report date:	23-August-2012
Report No.:	■■■■■

INSPECTION INFORMATION:

PO No.:	■■■■■
Project Name:	■■■■■
Materials Inspected:	PELTON RUNNER CASTING (in rough machined condition) – Unit 3
Date of Previous Visit:	■■■■■
Date(s) of Visit(s):	27-June-2012
Date of Next Scheduled Visit:	■■■■■
P. O. Status:	<input type="checkbox"/> Complete <input checked="" type="checkbox"/> Incomplete

SUPPLIER/SUB-SUPPLIER DATA:

Supplier:	■■■■■
Supplier Job No:	■■■■■
Location:	■■■■■
Primary Contact:	■■■■■
Phone:	■■■■■
E-mail :	■■■■■

INSPECTION SUMMARY AND CONCLUSION:

As per received Inspection Notification, attendance was made at ■■■■■ to carry out inspection on PELTON RUNNER CASTING (in rough machined condition) – Unit 3, as below detailed:

- MT and UT examination
- Mechanical testing.

Result: satisfactory

RECOMMENDED ACTION:	None
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INSPECTION RESULT:	<input checked="" type="checkbox"/> Accept	<input type="checkbox"/> Nonconformance(s)	<input type="checkbox"/> Other/Explain:
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1.0 ATTENDEES

NAME	COMPANY REPRESENTED	TITLE
Mr. ■■■■■■■■■■	■■■■■■■■■■	Quality Manager
Mr. ■■■■■■■■■■	■■■■■■■■■■	Quality Department
Mr. ■■■■■■■■■■	Inspecteam on behalf of ■■■■■■■■■■	Inspector

2.0 MATERIAL INSPECTED

PRODUCT / MATERIAL / ITEM NAME	ORDERED QUANTITY	PRESENTED THIS VISIT	ACCEPTED THIS VISIT	ACCEPTED TO DATE
PELTON RUNNER CASTING – Unit 3	1	1	-	-

3.0 DOCUMENTS USED

DOCUMENT No.	ISSUE DATE	TITLE	APPROVAL STATUS
■■■■■■■■■■	-	Purchase Order	N/A
■■■■■■■■■■	27-11-2011 - Rev. D	Quality Working Plan	Approved
■■■■■■■■■■	Rev. C	Drawing	N/A
■■■■■■■■■■	Rev. D	Quality sheet	N/A

4.0 SCOPE OF INSPECTION

ITP ACTIVITY	ITEMS	RESULT
MT examination (Random Spot check 35%)	10	Satisfactory
UT examination (Spot check 35%)*	10	Satisfactory
Mechanical test	10	Satisfactory

5.0 CALIBRATION OF THE INSTRUMENTATION USED

All equipment used were in valid calibration status at the time of the inspection.



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6.0 INSPECTION DETAILS

6.1 Introduction:

Following activities were carried out:

- MT examination
- UT examination
- Mechanical test.

Result: satisfactory

6.2 Magnetic Particle Examination (random spot check 35%)

The examination was carried out as per ITP line and applicable standards and specifications.

The examination was carried out with the Magnetic flow technique (with alternating current electromagnetic yoke), by the continuous method. The inspection material was applied during magnetisation (start of material application shortly before the magnetisation, end of material application before the stopping of the magnetisation, to allow the excess of the inspection material to run off during magnetisation).

Wet fluorescent coloured magnetic powder (C.G.M. – PAD 31-73/50) was used to improve the contrast as per specification requirement.

The examination was carried out after cleaning and degreasing; the tested areas were found free of dirt, loose coatings, rust, tinder, weld spatters, grease, oil or other unknown matters, which could influence the testing sensitivity. Viewing conditions were suitable for the examination being executed.

Each point in the tested area was tested in two different directions of magnetisation (with the lines of the magnetic field approximately at the right angle to one another). An ASME pie-shaped field indicator was used to check of the field strength and direction of magnetisation.

The personnel was found duly qualified level II SNT-TC-1A / level 2 EN 473.

Used equipments (C.G.M. Magiscop 10000) were duly identified and found in a valid calibration status at the time of inspection.

No indications were found beyond acceptable limits as per applicable specification requirements.

Result: satisfactory.

6.3 UT examination (random spot check 35%)

The examination was carried out in accordance with applicable standards and specifications.

An ultrasonic pulsed type instrument and suitable search beam units were used.

Calibration was performed with the DAC technique on a suitable calibration block provided.



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The surface was found free of extraneous material such as loose scale, paint, dirt, and so forth. A suitable couplant (contact past) was applied to carry out the test.

The personnel was found duly qualified level II SNT-TC-1A / level 2 EN 473. Used equipments were duly identified and found in a valid calibration status at the time of inspection.

No indication beyond acceptable limits was found. Offered test certificate was stamped, signed and dated by the writer for witness.

No objection was raised.
Result satisfactory.

6.4 Mechanical Testing

All equipments used during inspections were duly identified and found in a valid calibration status. Test specimens' type and quantity were found in compliance with ITP requirements.

Tensile test:
Test specimens were found ready machined in accordance with the requirements of standard and specification. Prior to carry out the tests, main specimen dimensions (diameter and gage length) were checked and found within allowable tolerances. Identification numbers for traceability and the hard stamp identification carried out during last visit were found indelibly marked on each specimen.

All results of the test (yield strength, tensile strength, elongation %, reduction %) were in compliance with specification requirements and applicable material standard.

Impact test:
Test specimens were found ready machined in accordance with the requirements of standard and specification. Prior to carry out the tests, main specimen dimensions (specimen section and notch depth and centring) were checked and found within allowable tolerances. Identification numbers and the hard stamp identification carried out during last visit were found indelibly marked on each specimen.

Impact test was carried out at 0°C in compliance with the requirements of Material specification.

All results of the test (single readings and average) were in compliance with specification requirements and applicable material standard.

No objection was raised.
Result: satisfactory.

7.0 NON-CONFORMANCES

NCR #	DESCRIPTION	DATE RAISED	DATE CLOSED
	None		



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8.0 ATTACHMENTS TO THIS REPORT

- Signed certificates

9.0 PICTURES

Mechanical test:



MT examination





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UT examination



END OF THIS REPORT
Mr. ■■■■■■■■

EXAMPLE