



TEST REPORT

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MAGNETIC PARTICLE TESTING (MT)

Our Ref. : NI-8500169169/THI
Customer Ref. : -

Date : 09/07/2021
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Customer : **OPAI (SINGAPORE) PTE LTD**
1 BUKIT BATOK CRESCENT
#08-14 WCEGA PLAZA
(S) 658064
Attention : **Mr. Francis Ang**

Job Details

Project Title : BJT PROJECT
Date of Test : 07 July 2021
Location of Test : 38, Joo Koon Road

Test Requirements

Standard / Code : BS EN ISO 17638 - 2016
Acceptance : BS EN ISO 23278 - 2015 (Table 1)

Test Procedure : NDT/TP/MT/30 (Rev.3)

Details of Item(s) Tested

Description : Steel Bracket Weld Joints
Material : Carbon Steel
Thickness : 6mm
Type of Weld / Welding Process : Fillet / MMAW

Surface Temp : Ambient
Surface Condition : As Welded

Equipment

Description : Electromagnetic Yoke
Serial Number : MY0261
Make / Model : Gammatec Engrg Pty Ltd / MY-2
Current Type : AC

Test Media

Contrast Medium : SHERWIN / CP-2
Batch No. : 1504-400-35-1220
Particles : SHERWIN / BO-1
Batch No. : 1503-400-31-1220

Method of Testing

Test Method : Wet (Visible)
Magnetizing Method : Continuous
Viewing Condition : White Light Intensity of min 100 fc (1000Lx)

Post-Examination

Cleaning : NA
Demagnetization : NA

Testing Officer : Palanivelu Thiyagarajan

Qualification : ASNT Level II

Test Results : Refer next page for test results and drawings / photos of items tested.

Note : This test report consists of results for magnetic particle testing only and does not cover the visual examination acceptance of the welds and its sizes.

Abdul Rahim b Hassan
PCN Level 2
(Supervisor)

Maung Tint Lwin
Manager
(NDT / Inspection)
Mechanical Technology Division

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LA-1993-0051-C LA-1998-0144-D
LA-1993-0067-G LA-2000-0181-F
LA-1994-0068-A LA-2012-0519-E
LA-1987-0001-B LA-1987-0001-B-1

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Test Results:

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No.	Weld Identification	Tested Length (mm)	Evaluation			Results	Remarks
			Distance from Datum (mm)	Discontinuity Length (mm)	Discontinuity Type		
#	Steel Bracket Weld Joints						
1.	Bracket No.: 5-3 (Jt 1)	-	-	-	A	S	Refer to photos
2.	Bracket No.: 5-1 (Jt 2)	-	-	-	A	S	Refer to photos
3.	Bracket No.: 4-3 (Jt 3)	-	-	-	A	S	Refer to photos
4.	Bracket No.: 4-2 (Jt 4)	-	-	-	A	S	Refer to photos
5.	Bracket No.: 3-4 (Jt 5)	-	-	-	A	S	Refer to photos
6.	Bracket No.: 1-3 (Jt 6)	-	-	-	A	S	Refer to photos
7.	Bracket No.: 1-2 (Jt 7)	-	-	-	A	S	Refer to photos
8.	Bracket No.: 1-1 (Jt 8)	-	-	-	A	S	Refer to photos
9.	Bracket No.: 2-6 (Jt 9)	-	-	-	A	S	Refer to photos
10.	Bracket No.: 5-2 (Jt 10)	-	-	-	A	S	Refer to photos
*	Note: The above item tested was carried on accessible area only.						

Legend :

S Satisfactory

U Unsatisfactory

Type of Discontinuities :

A No Significant Discontinuity

D Lack of Fusion

G Slag Line

J Undercut

B Porosity

E Incomplete Penetration

H Longitudinal Crack

K Transverse Crack

C Wormhole

F Slag Inclusions

I Crater Crack

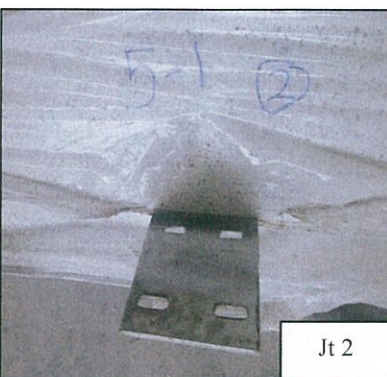
L Cluster Porosity



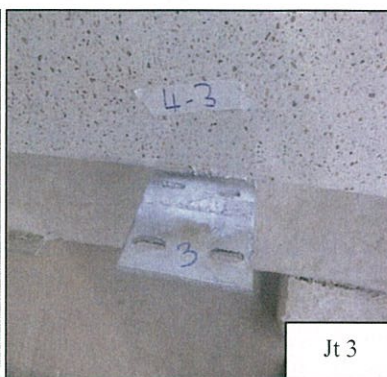
PHOTOS ATTACHED



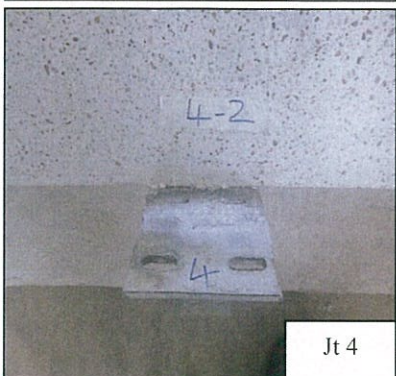
Jt 1



Jt 2



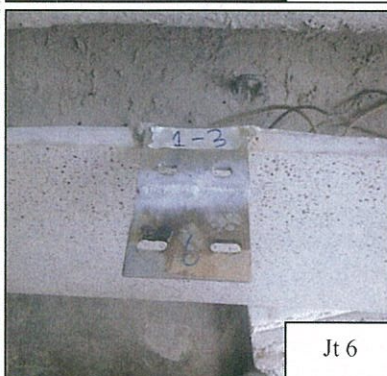
Jt 3



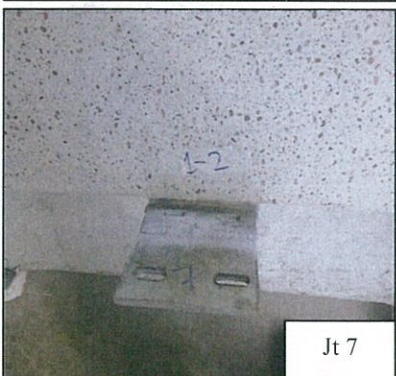
Jt 4



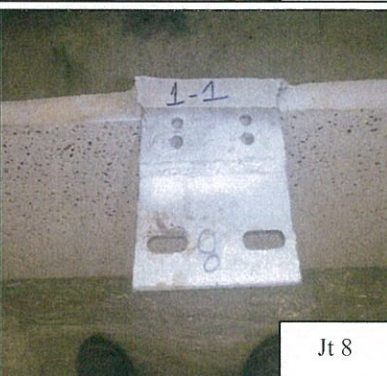
Jt 5



Jt 6



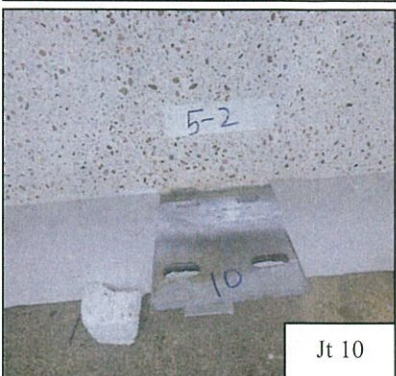
Jt 7



Jt 8



Jt 9



Jt 10

