

Laboratory for multiparametric testing and calibration
 ISO 9001:2000 Certificate No 200177 / 31.08.2002 - LRQA
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Multitest

Deutsche Gesellschaft für Zerstörungsfreie Prüfung E.V. - DGZfP
 Member of the American Society for Nondestructive Testing - ASNT

REPORT

№ 7032/13.08.2003

About: Ultrasonic non-destructive testing

Ordering organization: **PROGECO Bulgaria**

Object: *Galata gas field development wellhead platform*

Subobject: Elevation on rows A1-B2 & B2-C1

Information:

Job Progeco: B2PD001GCL
 Draw: 1367D503
 Step: 3.15
 Material: S355J2G4



The welds given in the application are bilaterally controlled.
 Length of controlled welds: **1508.2 dm**
 Length of second control: **13.5 dm**
 Total controlled length: **1521.7 dm**

Used NDT equipment:

Test equipment: Krautkramer USN52 №18268 - 621651
 Type of probes: Dual DA301-5MHz
 MWB 70-4, MWB 45-4
 Calibration block: Step calibration block (10-20)mm and (30-40)mm
 Calibration block V2
 Basic calibration block with flat bottom hole
 Basic calibration block with hole diameter

Specific of the performed testing:

The working area is controlled by dual probe for presence of imperfections.

Preparatory works before ultrasonic testing: grinding up to metal bright finish of the zones around seams: **1521.7 dm²**

Testing and assessment are completed in accordance with:
 API RP2X, ASME V, ASME VIII

Conclusion:

*Unacceptable imperfections detected during the control was repaired and controlled again.
 During the second control unacceptable imperfections are not detected.*

Applications: 2

Draws: 1

All sheets: 4

Remarks:

1. Just sealed sheets are valid
2. Do not reproduce.

NDT inspector:

[Signature]
 /N.Dimitrov/

Manager:

[Signature]
 /Hr.Chukachev/

Recipient:

Date:

[Signature]
 15.05.03

Registered in Varna No 1095/1994
 VOT No 1010059944
 BULSTAT No 813141496

BULRANK Varna
 Branch code: 62176907
 BGN No1033099106

SMIF:DFTBGSPVAR
 USD No1133099563
 EUR No1233099826



	Item	Weld №	Thickness /mm/	Controlled length /dm/	
LEG A1	J010	1002	45	24,8	
	J010-J002	1004	45/30	37,7	
	J002/1.3-J012	1010	30/45	37,7	
	J012-J004/1.1	1013	45/15	36,7	
	J004/1.3-J014	1018	15/45	36,7	
	J014-J006/1.5	1025	45/15	36,7	
	J006/1.1-J016	1033	15/45	36,7	
	J016	1036	45	25	
	J004/1.1-J004/1.2	1014	15	36,7	
	J004/1.2-J004/1.3	1017	15	36,7	
	J006/1.5	1024-1; 1024-2	15	33,2	
	J006/1.1-J006/1.2	1032	15	36,7	
	J006/1.2-J006/1.3	1029	15	36,7	
	J006/1.3-J006/1.4	1028	15	36,7	
	J006/1.4-J006/1.5	1026	15	36,7	
	LEG B2	J018	1082	45	24
		J018-J007/1.1	1131	45/30	37,7
J007/1.3-J019		1134	30/45	37,7	
J019-J008/1.3		1135	45/15	36,7	
J008/1.1-J020		1138	15/45	36,7	
J020-J009/1.5		1139	45/15	36,7	
J009/1.1-J021		1144	15/45	36,7	
J021		1075	45	25	
J008/1.1-J008/1.2		1137	15	36,7	
J008/1.2-J008/1.3		1136	15	36,7	
J009/1.1-J009/1.2		1143	15	36,7	
J009/1.2-J009/1.3		1142	15	36,7	
J009/1.3-J009/1.4		1141	15	36,7	
J009-1.4-J009/1.5		1140	15	36,7	





LEG C1	J011	1039	45	24
	J011-J001/1.1	1040	45/30	37,7
	J001/1.3-J013	1047	30/45	37,7
	J013-J003/1.3	1051	45/15	36,7
	J003/1.1-J015	1057	15/45	36,7
	J015-J005/1.5	1061	45/15	36,7
	J005/1.1-J017	1074	15/45	36,7
	J017	1073	45	25
	J003/1.1-J003/1.2	1055	15	36,7
	J003/1.2-J003/1.3	1054	15	36,7
	J005/1.1-J005/1.2	1069	15	36,7
	J005/1.2-J005/1.3	1067	15	36,7
	J005/1.3-J005/1.4	1066	15	36,7
	J005/1.4-J005/1.5	1062	15	36,7
	Total controlled length:			1508,2

Blank area for additional notes or signatures.





Scheme of Situation of Detected and Repaired Discontinuities

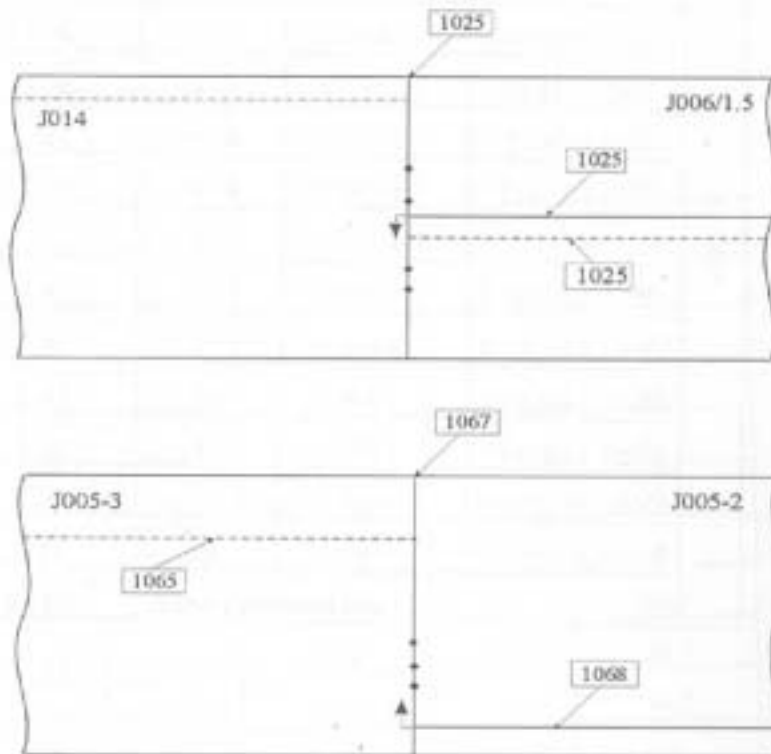


Table of Welds With Unacceptable Imperfections

Item	Weld №	Part for repairing	Kind of imperfections and depth location
J014-J006/1.5	1025	(81 + 83); (87 + 89); (-10,5 + -12); (-52 + -54)	single; D = (13,3 + 14) mm
J005/1.2-J005/1.3	1067	(81 + 83); (90 + 92); (134 + 136)	single; D = (11 + 12) mm
Second controlled length /dm/:			13,5

