



# INSPECTION REPORT

SGS Order NO.: IN-WH-5621-16008			SGS Report NO.: IN-WH-5621-16008		
Contact Person	Judy Hu	Telephone	+86 27 8739 5175	Email	Judy.hu@sgs.com
CLIENT: [REDACTED]				P/o nr: N/A	
Contact Person	[REDACTED]	Telephone	[REDACTED]	Email	N/A
MANUFACTURER: Henan Dafang Heavy Machinery Co.,Ltd				P/o nr: N/A	
Contact Person	Grace Liu	Telephone	+86-1823738 3867	Email	N/A
Inspection Requested by:			<input type="checkbox"/> Client	Manufacturer	

Product inspected	Crane	Quantity	6 sets
Test Location	Changyuan Town, Xinxiang City, Henan Province, China	Test Date	May.25~27,2016

### Test Summation (All details see continuation sheet)

Test Items	Test Results	REFERENCE DOCUMENTS
Ultrasonic test on butt welds	Acceptable	JB/T10559-2006
Magnetic Particle test on fillet welds	Acceptable	JB/T6061-2007

### REFERENCE DOCUMENTS

No.	Title	Reference No.
1.	Non-destructive testing of lifting appliances-Ultrasonic testing of steel welds	JB/T10559-2006
2.	Non-destructive testing - Magnetic Particle testing of welds	JB/T6061-2007
3.	General Drawing	MG15T/3T-S16m
4.	General Drawing	MG20T-S36m
5.	General Drawing	QD 30T-S20.636m

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WHNDT000848



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## Abnormal items issue

N/A

## Equipment/Material inspected

SGS inspector performed inspection for following components:

NO.	Inspected product	QTY.	Inspection item	Inspection proportion	Inspection length	Remark
1	MG15T/3T Double Girder Gantry Crane	3sets	UT for Upper cover plate butt weld	Randomly selected 1 weld	760mm	/
			UT for Under cover plate butt weld	Randomly selected 1 weld	750mm	/
			UT for Main web butt weld	Randomly selected 1 weld	884mm	/
			UT for Sub web butt weld	Randomly selected 1 weld	884mm	/
			MT for fillet weld	Randomly selected 1 weld	16m	/
2	MG20T Double Girder Gantry Crane	1set	UT for Upper cover plate butt weld	Randomly selected 1 weld	980mm	/
			UT for Under cover plate butt weld	Randomly selected 1 weld	962mm	/
			UT for Main web butt weld	Randomly selected 1 weld	1800mm	/
			UT for Sub web butt weld	Randomly selected 1 weld	1800mm	/
			MT for fillet weld	Randomly selected 1 weld	36m	/
3	QD 30T Double Girder Overhead Crane	2sets	UT for Upper cover plate butt weld	Randomly selected 1 weld	600mm	/
			UT for Under cover plate butt weld	Randomly selected 1 weld	585mm	/
			MT for fillet weld	Randomly selected 1 weld	20.636m	/

## Inspection Detail Narrative

### 1、UT

UT has been performed according to the requirement of the client and standard, The details are as following.

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<b>Sample name</b>	Crane	<b>Testing Area</b>	Weld and HAZ
<b>Surface Condition</b>	After grind	<b>Ambient temperature</b>	28°
<b>Instrument Type</b>	PXUT-350+	<b>Probe Type</b>	MSEB4,MWB70,MWB60
<b>Calibration block</b>	CSK-IA, LA-4	<b>Couplant</b>	Paste
<b>Scanning Method</b>	Both side at one face	<b>Testing sensitivity</b>	Φ3DAC-18dB
<b>Testing standard and Level</b>	JB/T10559-2006	<b>Acceptable standard and Level</b>	JB/T10559-2006 level 1

### Testing conclusion:

UT has been performed to welding and HAZs, According to the client's requirement and testing standard JB/T10559-2006, no defect that go beyond the limit of the JB/T10559-2006 level 1 has been found, the result is acceptable.

No.	Sample Name	Inspected Quantity	Thickness (mm)	Defects No.	Equivalent size (dB)	Length (mm)	Result	Remarks
1	MG15T/3T Double Girder Gantry Crane	3sets	8mm /6mm	/	/	/	Acc.	/
2	MG20T Double Girder Gantry Crane	1set	8mm /6mm	/	/	/	Acc.	/
3	QD 30T Double Girder Overhead Crane	2sets	12mm	/	/	/	Acc.	/

## 2、MT

MT has been performed according to the requirement of the client and standard, The details are as following.

<b>Sample Name</b>	Crane	<b>Sample material</b>	/
<b>Testing Method</b>	Continuous method	<b>Testing time</b>	After welded 24h
<b>Tested Area</b>	Weld seam and HAZS	<b>Surface temperature</b>	28°C
<b>Surface Condition</b>	As weld	<b>Magnetizing Method</b>	Yoke
<b>Instrument Type/No.</b>	MP-A-2L/WHNDT003	<b>Magnetic Particle Type</b>	HD-BO Black particles
<b>Lifting Power</b>	≥45 N	<b>Application Method</b>	spray

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<b>Magnetizing Current</b>	AC	<b>Magnetizing Duration</b>	1~3 s
<b>Sensitivity Block</b>	A1-30/100	<b>Illumination Condition</b>	Ambient white light
<b>Testing Standard</b>	JB/T6061-2007	<b>Acceptance Criteria and Level</b>	JB/T6061-2007 level 1

**Testing conclusion:**

MT has been performed to welding and HAZs, According to the client's requirement and testing standard J JB/T6061-2007, no defect that go beyond the limit of the JB/T6061-2007 level 1 has been found, the result is acceptable.

No.	Sample Name	Inspected Quantity	Defect No.	Defect type	Defect size(mm)	Result (Acc./Rej.)	Remark
1	MG15T/3T Double Girder Gantry Crane	3sets	/	/	/	Acc.	/
2	MG20T Double Girder Gantry Crane	1set	/	/	/	Acc.	/
3	QD 30T Double Girder Overhead Crane	2sets	/	/	/	Acc.	/

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Attached Photos

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Photo1 MG15T/3T Double Girder Gantry Crane



Photo2 MG15T/3T Double Girder Gantry Crane



Photo3 MG20T Double Girder Gantry Crane



Photo4 QD 30T Double Girder Overhead Crane



Photo5 MT for fillet weld

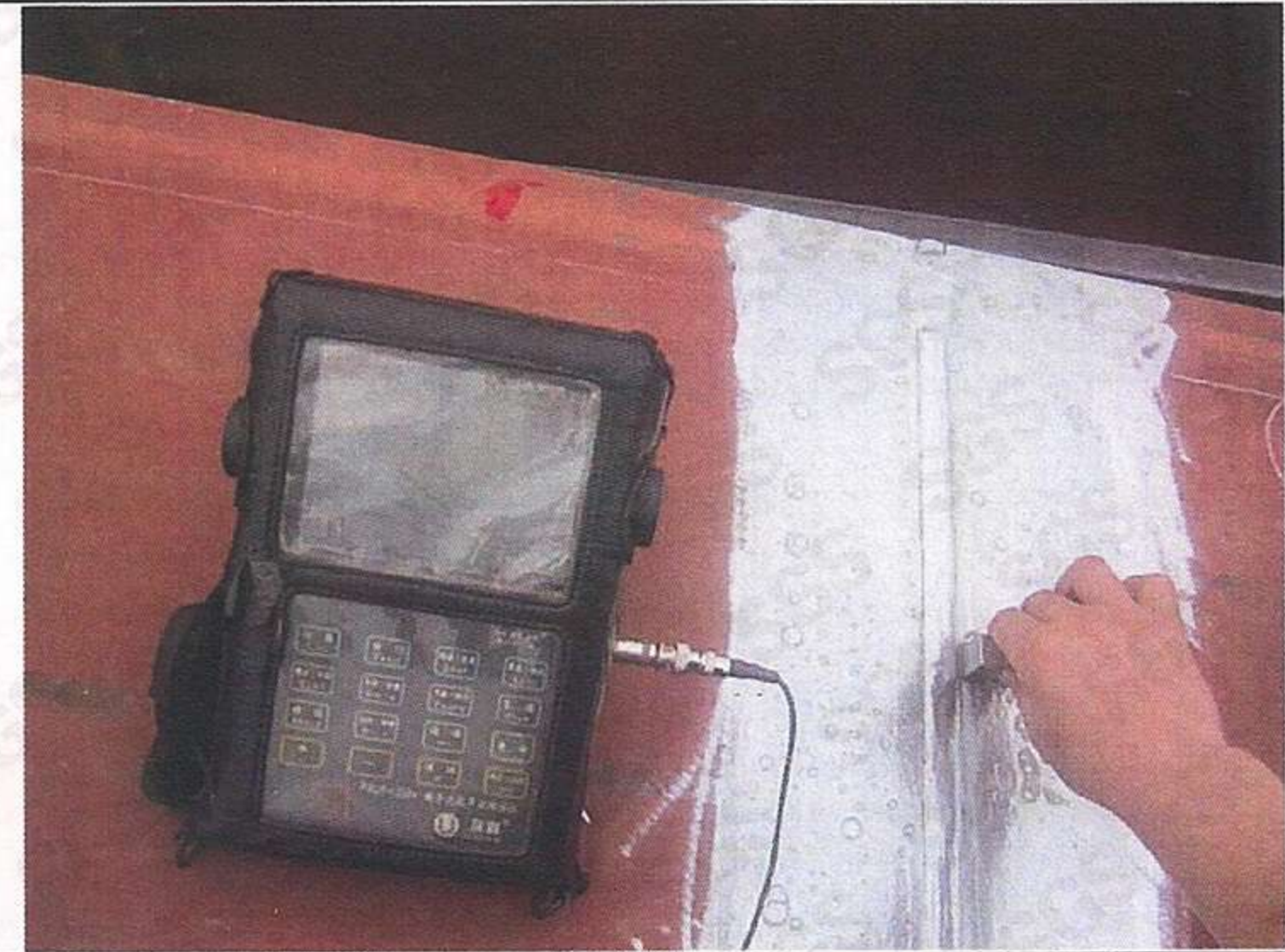


Photo6 UT for butt weld



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**Time Sheet**

Inspector Name: Lemon Liu

Used for Inspection (Including Traveling and Reporting)	Date	Working Hours	Over Time
	May.25,2016	8	/
	May.26,2016	8	/
	May.27,2016	8	/
<b>Total time charged</b>	/	24	/

**Remarks**

1. This report only reflects our findings at time and place indicated above only and does not refer to any other matters.
2. Every NDT method have the limit which may result the non-conformation with client's requirements.
3. All orders are accepted and all reports and certificates issued subject to the General Conditions of Service.

Inspected by:  
Lemon Liu *Lemon Liu*

Reviewed by:  
Wesley Wang *Wesley Wang*

Approved by:  
John Zhao *John Zhao*

Inspector  
NDT Engineer  
Date: May.28,2016

Position  
NDT Head  
Date: May.30,2016

Position  
Dept Manager  
Date: May.30,2016

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**WHNDT000853**



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