

# Elverhøy - Erfaringsrapport

Automatisert produksjon basert på lasersveis for bygging av stålbruer

STATENS VEGVESENS RAPPORTER

Nr. 971



## Tittel

Elverhøy - Erfaringsrapport

## Undertittel

Automatisert produksjon basert på lasersveis for bygging av

## Forfatter

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## Avdeling

Teknologi og utvikling Utbygging

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## Prosjektleder

## Godkjent av

Cato Dørum

## Emneord

Stålbru lasersveis erfaringsrapport  
Utbygging automatisert stål

## Sammendrag

Denne rapporten er utarbeidet i forbindelse med et FoU-arbeid for å utvikle en automatisert produksjonsprosess for bygging av stålbruer basert på laser- og laser-hybridsveising. Målet med dette arbeidet er å vise at automatisert produksjon med bruk av lasersveis kan gi gevinster både med tanke på kvalitet, økonomi og miljø. Arbeidet har bestått i bygging av overbygning i stål til Elverhøy bru i Sunndal kommune, og har vært gjennomført som et samarbeid mellom Statens vegvesen Divisjon Utbygging og Prodtex. DNV har bidratt som rådgiver på områder som kvalifisering, kvalitetskontroll og kvalitetssikring av laser- og laserhybrid sveis.

## Title

Elverhøy bridge - Experience report

## Subtitle

Automated production based on laser welding for building of steel bridges

## Author

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## Department

Technology and Development

## Section

## Project number

## Report number

971

## Project manager

## Approved by

Cato Dørum

## Key words

Steel bridge structures laser welding

## Summary

This report has been prepared in connection with research and development work to create an automated production process for constructing steel bridges using laser and laser-hybrid welding. The goal of this work is to demonstrate that automated production using laser welding can yield benefits in terms of quality, economy, and the environment. The project involved building the superstructure of a steel bridge for Elverhøy Bridge in Sunndal municipality, and it was carried out in collaboration between the Norwegian Public Roads Administration (Statens vegvesen Divisjon Utbygging) and Prodtex.

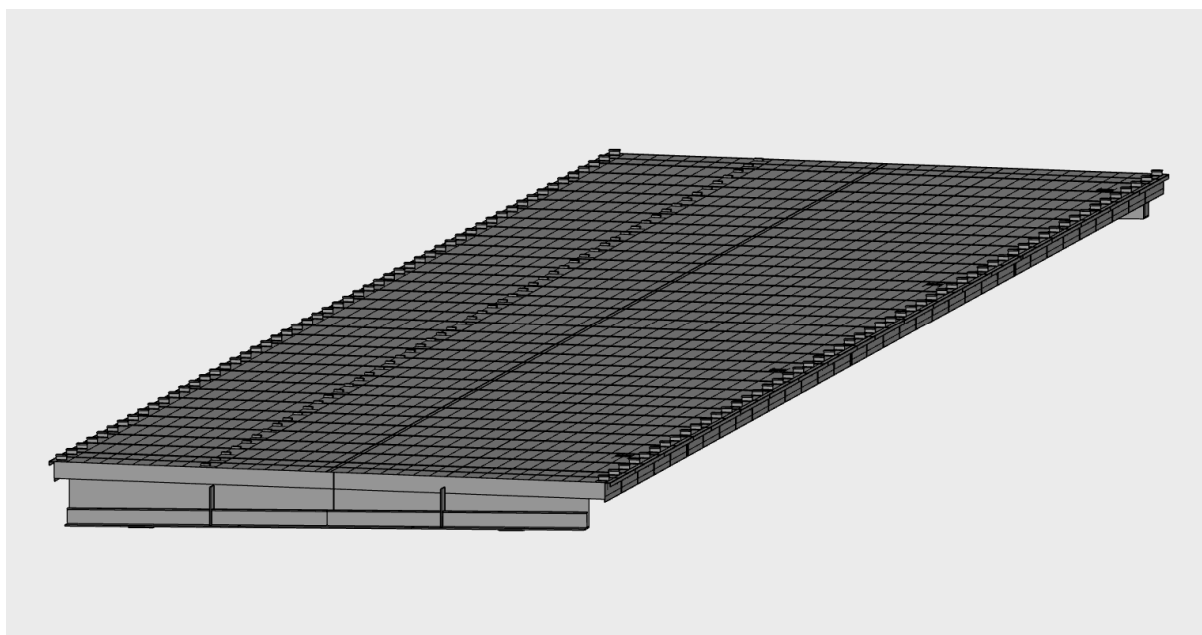


## Forord

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Erfaringsrapporten fra byggingen av Elverhøy bru er skrevet av Emilie Roppen Bjåstad, Prodtex. Det er også gitt et vedlegg til rapporten, skrevet av DNV, ved Stian Gurrik og Tone Hasle.

## ERFARINGSRAPPORT ELVERHØY BRU – PRODTEX



Revisjon	Kommentar	Dato	Ansvarleg
0	Første utgave	05/01/24	ERB
1			
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## 1 SAMMENDRAG

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Elverhøy er fortsettelsen på et utviklingsprosjekt mellom Statens Vegvesen, Prodtex og DNV. Målet er å vise at automatisert produksjon med laser- og laserhybridsveis av store stålkonstruksjoner til bru gir bedre kvalitet, redusert miljøavtrykk og har en lavere kostnad enn tradisjonell produksjon i Europa og Asia. Utviklingsprosjektet startet med bygging av Frønesbrua (Gangbru Åfjord, 2021). Både Frønesbrua og Ya-bru er FoU-prosjekt finansiert av Ferjefri E39.

Som for YA, videreutvikles produksjonsteknikken som nyttes for Elverhøy fra foregående prosjekt. Decksegmentene som er produsert i den robotiserte linjen har økt i størrelse fra ca. 3 x 5 meter og opp til ca. 6,5 x 32 meter. Ståloverbygningen er sammenstilt til åtte større segmenter som består av sandwich og underliggende bjelker i produksjonshallen på Fiskå og er deretter fraktet til riggplass i Sunndalen for sammenstilling før installasjon over Driva elv.

Produksjonslinjen er bygget ut og redesignet med flere automatiserte sveiseceller.

Nye sveiseprosedyrer for laser, laserhybrid og MIG er utarbeidet og kvalifisert.

Den automatiserte sveisingen gir redusert sveisetid og eliminerer mulighet for menneskelige feil uavhengig av om det er robotisert MIG, laserhybrid- eller lasersveis. I tillegg er energiforbruket og graden av deformasjon lavere ved bruk av laser og laserhybridsveis enn ved manuell sveising.

## 2 INNLEDNING

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Rapporten beskriver prosessen med utvikling og produksjon av brukasse i stål til Elverhøy bru på riksveg 70 i Sunndalen. Broen krysser elva og erstatter en eldre bro fra 1941 med bare ett kjørefelt.

Etter avtale med Statens Vegvesen leverer Prodtex ferdig sammenstilt brukasse i stål, prefabrikkert ved Prodtex sin fabrikk på Fiskå. Leveransen inkluderer også overflatebehandling på områder langs sidekant i sandwichdekket til stålkassen, samt membran på topplaten.

Prosjektet er et FOU-prosjekt finansiert av Ferjefri E39, målet er å verifisere at automatisert produksjon i Norge er konkurransedyktig med stål levert fra verft i Asia og Europa.

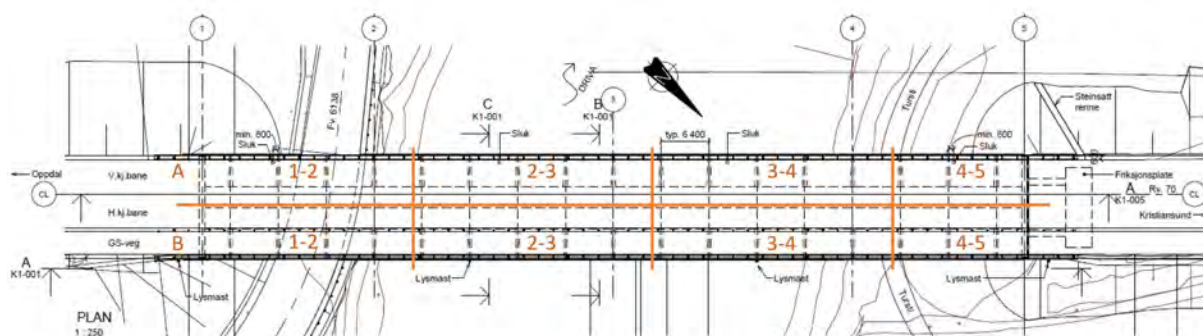
### 3 BESKRIVELSE AV KONSTRUKSJONEN

Ståloverbygningen består av et sandwichdekke og en underliggende stålbejelke. Konstruksjonen er lukket i hver ende av en endetverrbærer.

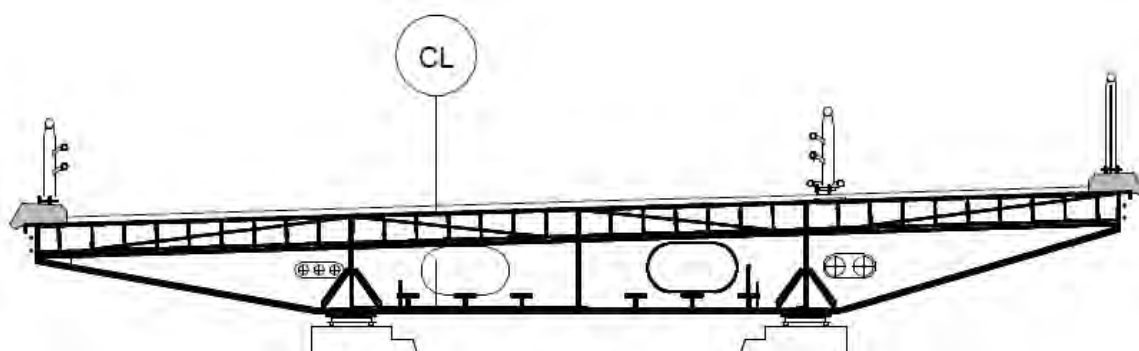
Hoveddimensjoner.:	Lengde	110m
	Bredde	13,6m
	Høyde	1,5m
	Vekt	715t

Stålbejelke og sandwichdekke er delssammenstilt på Fiskåholmen til åtte element. Elementene er fraktet fra Fiskåholmen til Sunndalen med båttransport. Elementene er losset ved anlegget til Hydro, og fraktet videre til riggplass på bil. Transportrutene er dimensjonerende for elementene og maks lengde og -bredde er henholdsvis 32 og 6,9 meter.

Ståloverbygningen er produsert i åtte element. Decket og den underliggende bejelken er delt inn i en A- og B-side på langs. A-siden (nedstrøms) har kjørebane og B-siden (oppstrøms) har kjørebane og gangfelt. På tvers er decket og den underliggende bejelken delt i momentnullpunktet etter akse 2, 3 og 4. Se illustrasjon for inndeling av elementene i Figur 1.



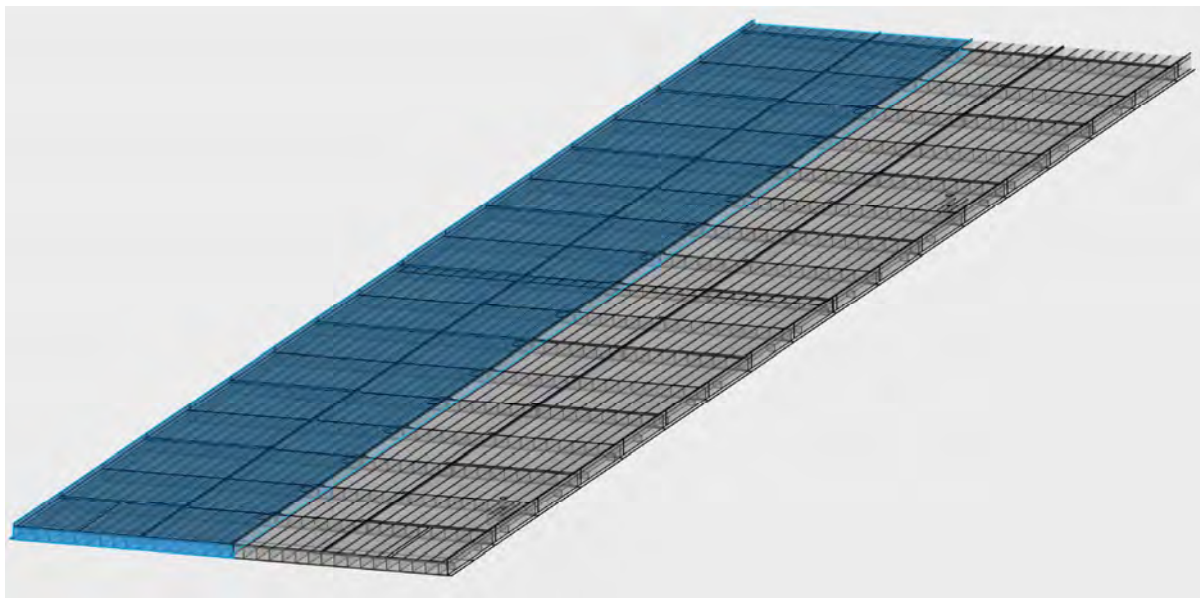
Figur 1.: Elementinndeling Ståloverbygning



Figur 2.: Tverrsnitt Ståloverbygning (v/Akse)

### 3.1 SANDWICHDEKKET

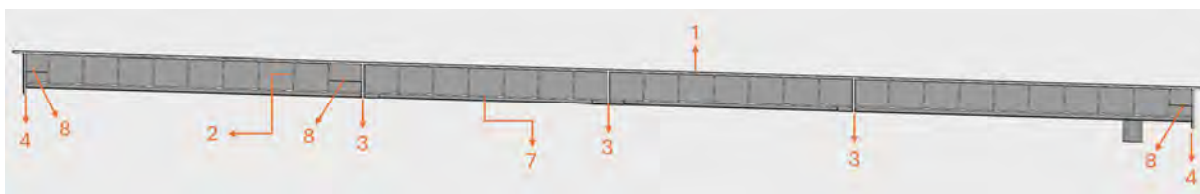
Sandwichdekket er ca. 110 meter langt, 13,6 meter bredt og 0,4 meter høyt. Sandwichdekket er som nevnt i tidligere delt inn i åtte element. Dekket er delt ca. i senterlinjen på langs. Som nevnt tidligere er A-siden nedstrøms og B-siden oppstrøms. Både A- og B-siden er deretter delt i fire lengder. De åtte elementene er prefabrikkert i den automatiserte robotlinjen. Videre vil de elementene omtales som «Decksegment».



Figur 3.: Sandwichdekket i en begrenset lengde.

Sandwichdekkets består av.:

- |                          |      |
|--------------------------|------|
| 1. Topplate              | 16mm |
| 2. Langsgående profil    | 8mm  |
| 3. Langsgående steg      | 20mm |
| 4. Sideplate             | 16mm |
| 5. Tverrbjelke           | 30mm |
| 6. Tverrstiver           | 16mm |
| 7. Bunnplate             | 8mm  |
| 8. Rekkverksforsterkning | 8mm  |

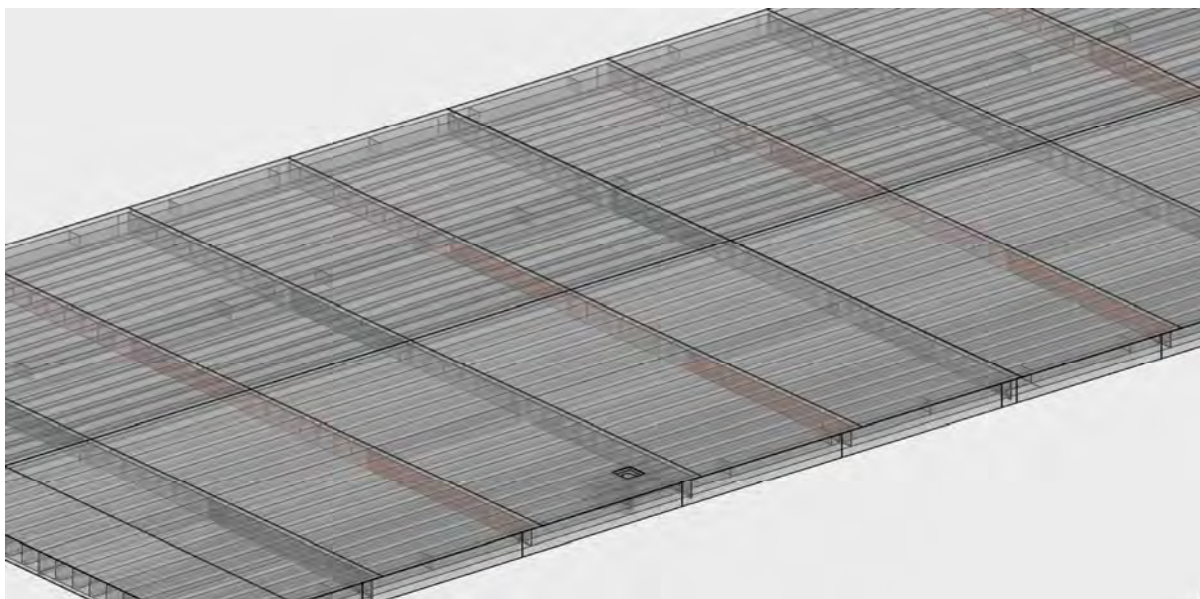


Figur 4.: Tverrsnitt i sandwichdekket



Sandwichdekket har i tverretning 30stk langsgående profiler med en senteravstand på 400mm, tre langsgående steg (direkte over underliggende kasse, se kapittel 3.2), og to sidekanter. Broen har rekkverk langs kanten og mellom kjørefelt og gangfelt. Rekkverket har innfestingspunkt hver andre meter i lengderetning, i områder der innfestingspunktet ikke er direkte over en tverrstiver eller tverrbjelke er det montert en forsterkningsbrakett.

Tverrstiverene og tverrbjelkene er jevnt fordelt langs hele broen. De står annenhver gang med en senteravstand mellom tverrstiver og tverrbjelke på 3,2 meter. Senteravtand mellom hver tverrbjelke er 6,4meter og senteravtand mellom hver tverrstiver er 6,4meter.

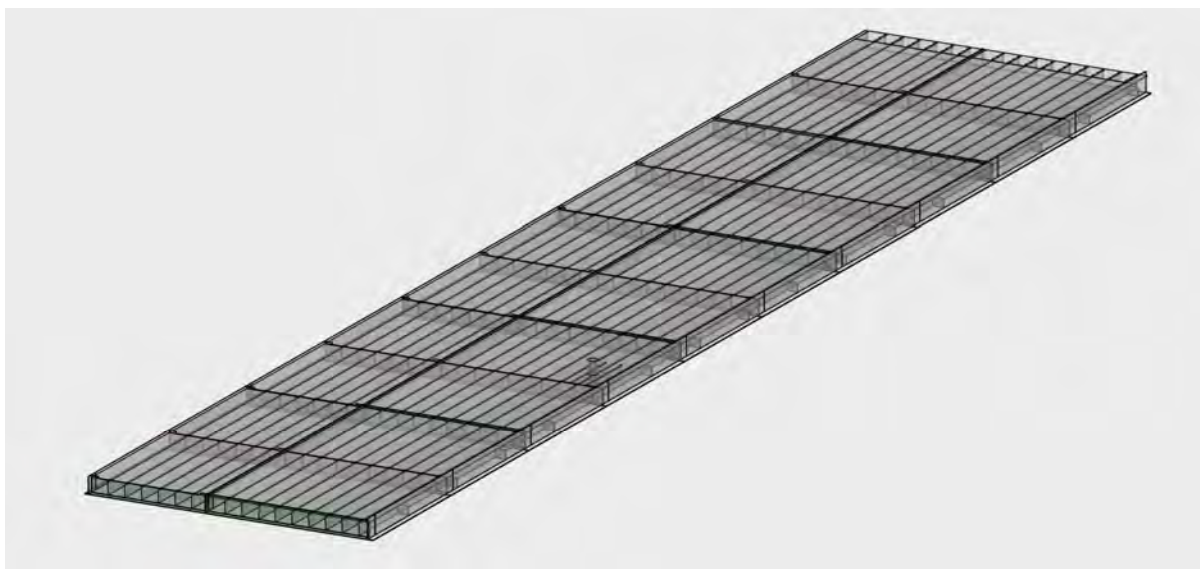


Figur 5.: Sandwichdekket med synlige tverrstivere (orange) og tverrbjelker (grønne)

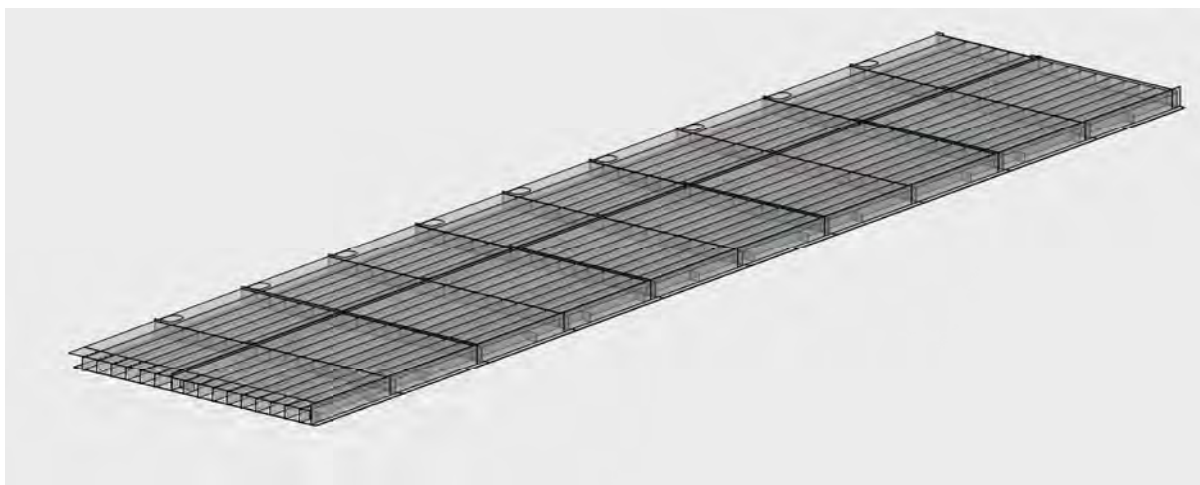
Navngivingen til Decksegmentene refererer til plasseringen segmentene har i ståloverbygningen.  
*Eks.: Decksegment A Akse 1-2 er plassert på A-siden og går mellom akse 1 og akse 2.*

- Decksegment A Akse 1-2
- Decksegment A Akse 2-3
- Decksegment A Akse 3-4
- Decksegment A Akse 4-5
- Decksegment B Akse 1-2
- Decksegment B Akse 2-3
- Decksegment B Akse 3-4
- Decksegment B Akse 4-5

Decksegmentene produseres i hele lengder på ca. 32-, 29- og 16 meter.

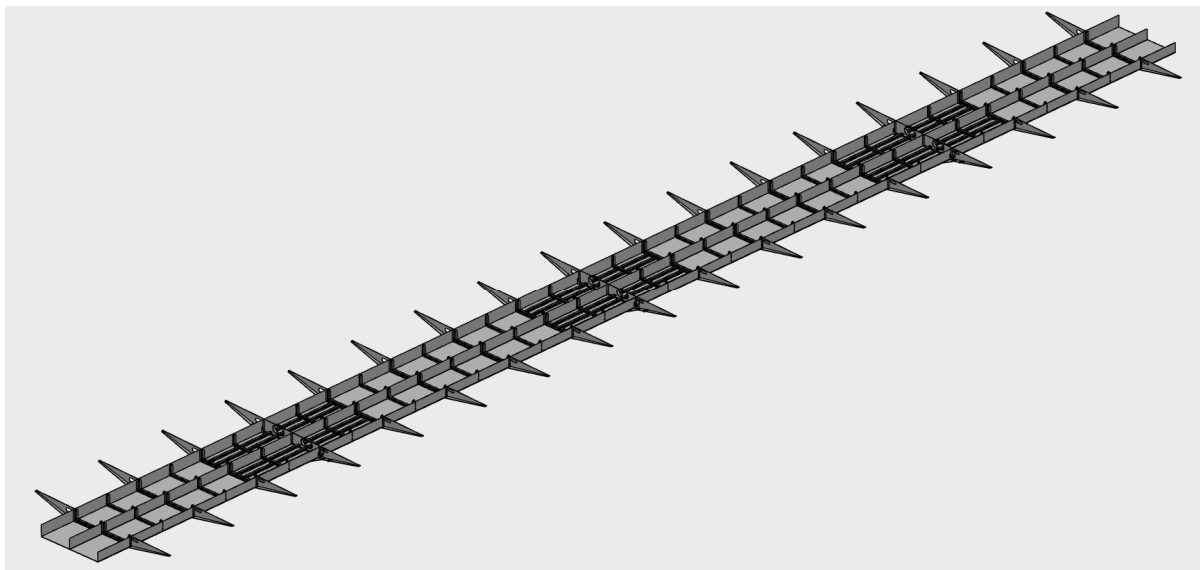


Figur 6.: Decksegment 2-3A



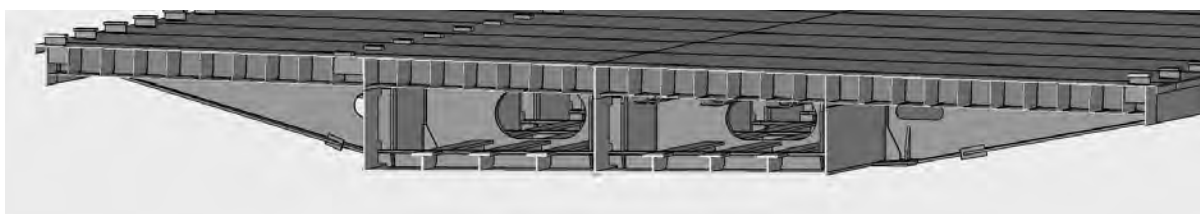
Figur 7.: Decksegment 2-3B

## 3.2 STÅLBJELKER



Figur 8.: Underliggende stålbjelke

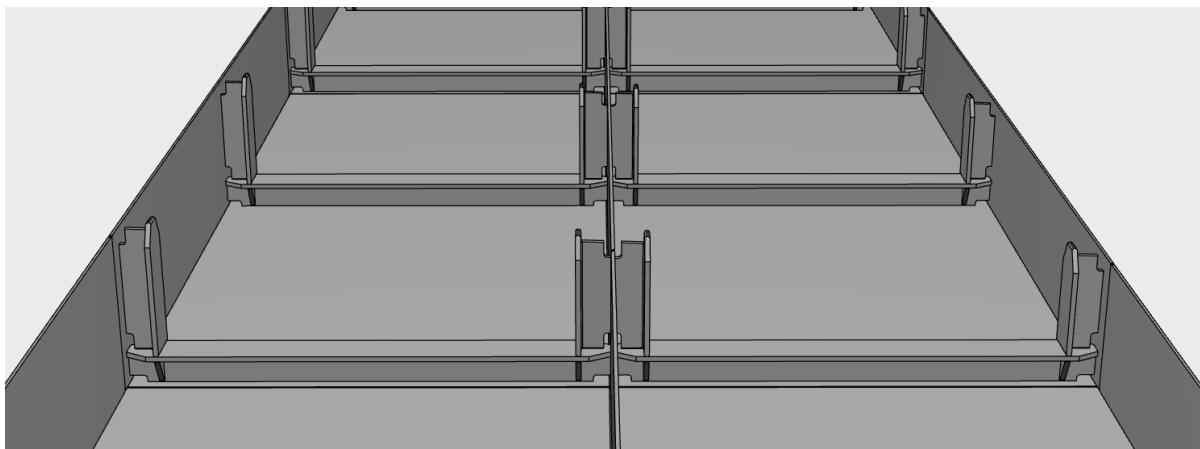
Den underliggende stålbjelken er en u-formet kasse. Den er ca 5,6 meter bred og har tre langsgående steg. De tre stegene skjøtes med de langsgående stegene i sandwichdekket og strekker seg fra bunnen i stålbjelken og opp i topplaten til sandwichdekket.



Figur 9.: Snitt av Stålkasse med synlig innvendig struktur

Stålbjelken har «vingeformede» tverrbjelker som er skjøtet med tverrbjelkene i sandwichdekket. Disse strekker seg fra de langsgående stegene på utsiden av stålbjelken og mot sideplatene i sandwichdekket.

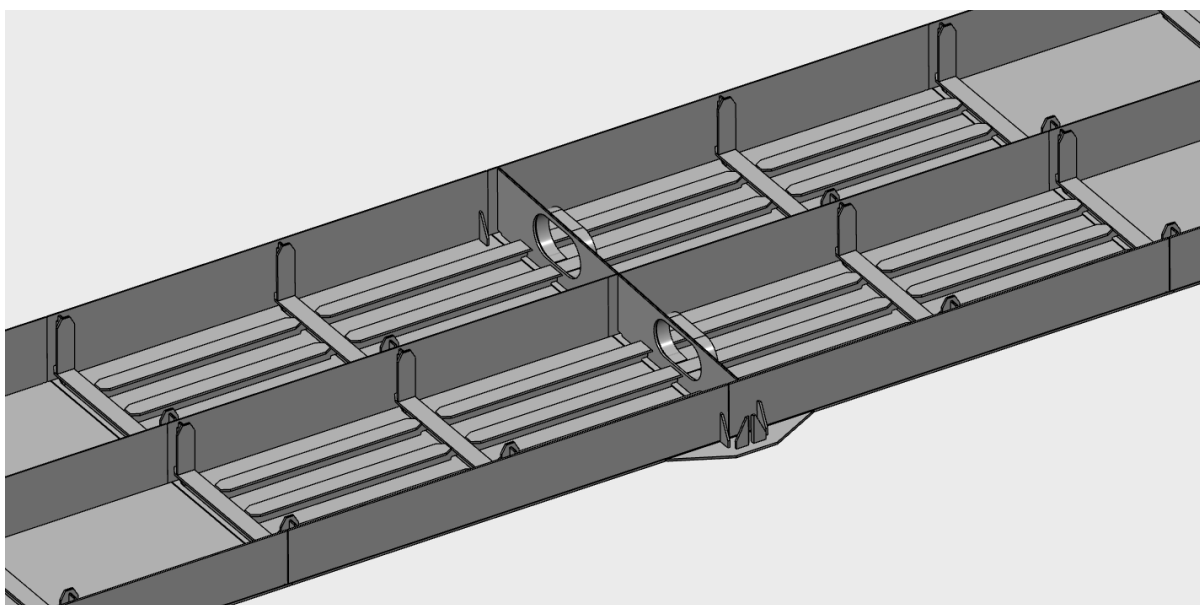
På innsiden av stålbjelken er der tverrrammer hver 3,2 meter. I likhet med de langsgående stegene skjøtes rammene sammen med tverrbjolkene og tverrstiverene i sandwichdekket.



Figur 10.: Tverrrammer på innsiden av stålbjelken

Ved aksene er tverrrammen erstattet med spant og bunnflensen er i området forsterket med langsgående t-bjelker. T-bjolkene strekker seg fra spantet i aksene og 6,4 meter ut i begge retninger.

I tillegg er bunnflensen utvidet ved aksene. Og i senter av det langsgående steget, under bunnflensen, er det montert kileplater for innfesting av lager.

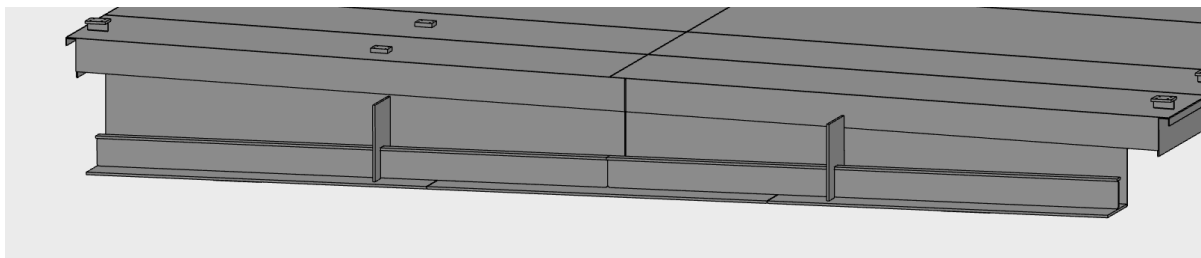


Figur 11.: Innsiden av stålbjelken, viser hvordan området rundt aksene typisk ser ut

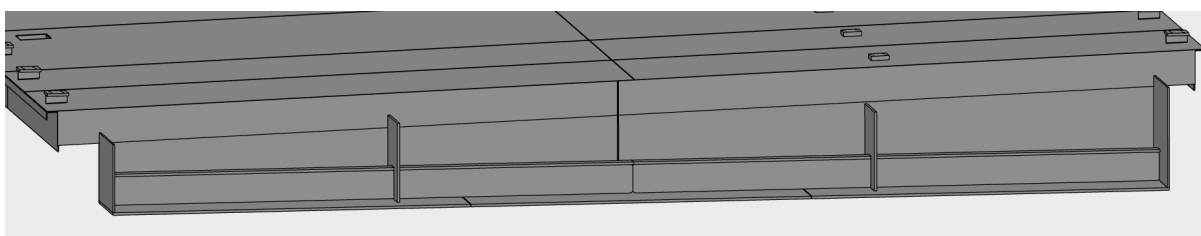
### 3.3 ENDETVERRBÆRER

Endetverrbærere består av en endeplate med forlengelser av de ytterste langsgående stegene og bunnflensen til den underliggende stålbein. Bunnflensen er bredere i dette området og er derfor like bred som endeplaten. Bredden er 12,4 meter i akse 1 og 12,6 meter i akse 5. I tillegg til forlengelsen av det langsgående steget er der montert sideplater på endetverrbæreren i akse 1.

Armeringshylser og dybler dekker endeplaten.



Figur 12.: Endeplate Akse 5 (Uten hylser og dybler)



Figur 13.: Endeplate Akse 1 (Uten hylser og dybler)



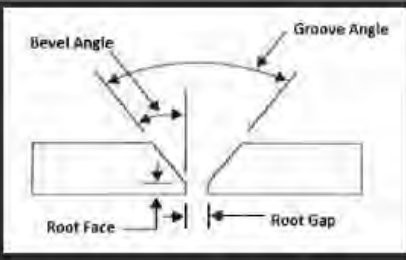
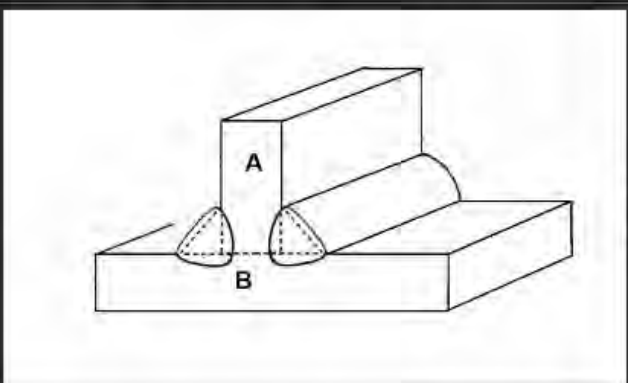
## 4 PRODUKSJONSFORBEREDELSE

### 4.1 KVALIFISERING AV SVEIS

Kvalifisering av sveis er tidkrevende og medfører kvalifiseringskostnader i form av medgått arbeidstid, produksjonsressurser til testing og utarbeiding av prosedyre, samt tredjepartskontroll. Erfaringsmessig kreves det mer tid og ressurser til testing av laser- og laserhybridsveiser enn MIG. MIG er en utbredt sveisemetodikk i Norge. Laser- og laserhybridsveis er fortsatt relativt nytt og lite brukt, spesielt utenfor laboratorier.

I forrige prosjekt ble langsgående profil mot toppplate og langsgående profil mot bunnplate sveiset med henholdsvis laserhybrid- og lasersveis. Disse forbindelsene utføres på samme måte i denne konstruksjonen. Eneste ulikheten er at tykkelsen på toppplaten er økt fra 14mm til 16mm.

Det er kvalifisert to nye sveiser til dette prosjektet. Begge er laserhybridsveiser. Den ene sveisen er en butt-forbindelse av toppplaten, 16mm mot 16mm. Den andre er en t-forbindelse mellom det langsgående steget og toppplaten i sandwichdekket. 20mm mot 16mm.

WPS	Type	Thickness Range (mm)	Sketch	Description
033-LH-BW-16	Butt-Joint	12.8 - 16		Rootface: 6 Rootgap: 1,6 Groove angle: 20° Welding Position: PA Single side weld
035-LH-T162	Fillet	20, 16		Welding Position: PB Double Side Weld

Figur 14.: Sveiser som kvalifiseres i prosjektet

Dersom butt-skjøten ble sveiset med MIG-robot hadde produksjonen vært avhengig av en manuell påført bunnstreng. Ved bruk av laserhybrid elimineres behovet for bunnstrengen og produksjonen effektiviseres. Produksjonen har 2x36 slike forbindelser, samlet har skjøtene en lengde på 489,6meter. Både MIG-sveisen og laserhybridsveisen er avhengig av å kjøre to strenger på en slik forbindelse, og besparelsen er derfor logistikken, innsatsmateriale, arbeidet og tiden med å legge bunnstrengen. Besparelsen i ren sveisetid ved å fjerne behovet for bunnstrengen er over 250timer.

Tabellen under viser forskjeller mellom MIG-sveis og Laser-/Laserhybridsveis av de to forbindelsene.:

Forbindelse	Sveisemetodikk
Buttforbindelse mellom topplate (16mm) og topplate (16mm)	<p><b>Robot MIG – Sveisehastighet 1m/2min og manuell bunntråd 1m/30min.:</b></p> <p><i>Nødvendig med sveisefuge (V-fuge) og åpning for å oppnå full gjennombrenning. En bunnstreng må legges manuelt og inspiseres/godkjennes før fugen kan fylles med MIG-robot. Estimert at forbindelse krever tre sveisestrenger for å fylle ensidig fuger, der en av strengene er bunnstreng, de to siste er for å fylle fugen.</i></p>
	<p><b>Laserhybrid – Sveisehastighet 1m/min.:</b></p> <p><i>Fuger nødvendig (Y-fuger) for full gjennombrenning med baksveis. Forbindelsen krever to «run», altså to strenger med sveis. Den første tetter nederste del av Y-fugen og gir baksveis. Den andre fyller resten av fugen.</i></p>
T-Forbindelse mellom Langsgående steg (20mm) og topplate (16mm)	<p><b>Robot MIG – Sveisehastighet 1m/2min.:</b></p> <p><i>Nødvendig med sveisefuge (K-fuger) for innbrenning. Sveisen kjøres fra begge sider av det langsgående steget, med minimum to strenger på hver side.</i></p>
	<p><b>Laserhybrid – Sveisehastighet 1m/1min.:</b></p> <p><i>Sveisefuger er ikke nødvendig for å oppnå innbrenning. Sveisen kjøres fra begge sider med ett «run» hver. (En streng på hver side).</i></p>

#### 4.1.1 Generelt

Sveisekvalifiseringen utføres på plasma-kuttete plater som er sandblåst til ruhet SA 2.5. Materialkvalitet er SSAB Weathering 420 ML (S420J5W M), materialet er godt egnet til laser- og laserhybridsveising. Platebestillingen til sveisekvalifiseringen har samme spesifisering som plater bestilt til produksjon.

##### 4.1.1.1 Rensing av sveisesoner

Sveisesoner er renses med trykkluft før sveising. Prosedyre dersom rust oppdages i sveisesoner er å slippe bort rustet før sveis kjøres.

##### 4.1.1.2 Sveiseparametere

Sveiseparameter som justeres i testing av sveis til kvalifisering. For sveiseparameter brukt i prosjektet se vedlegg for WPS

Sveiseparameter.:

- Sveisegass
- Sveisehastighet
- Lasereffekt
- MIG spenning/effekt
- Fokus

- Sveisevinkel
- Buelengde
- Avstand laserlys til MIG-tråd (Gjelder kun laserhybridsveis)
- Ledende laser eller tråd (Gjelder kun laserhybridsveis)

#### 4.1.1.3 Typiske sveisefeil

Ved sveisefeil er det typisk disse feilene som oppstår.:

- Manglende baksveis
- Undercut
- Porer (Minimalt)
- Sveisesprut

#### 4.1.2 Laser og laserhybridsveis benyttet i prosjektet

Laser- og laserhybridsveiser fra tidligere FOU-prosjekt er benyttet også i dette prosjektet.

##### 4.1.2.1 Laserhybridsveis

Laserhybridsveis benyttet i prosjektet.

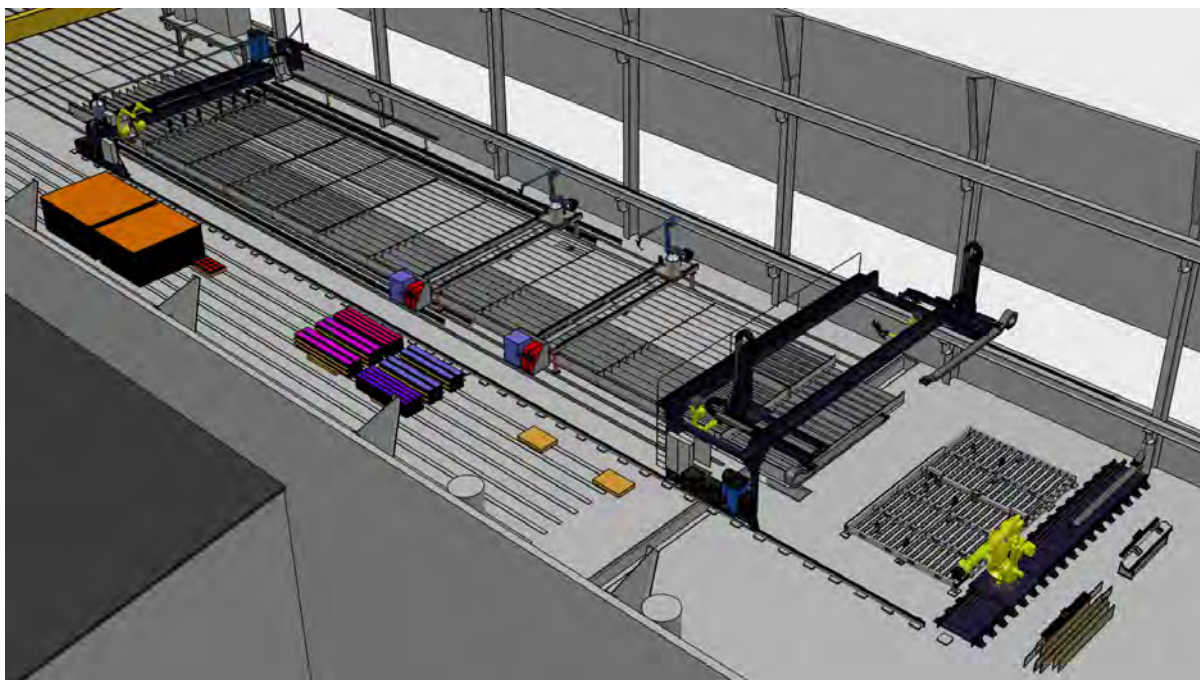
Type	Platetykkelse	Beskrivelse
T-forbindelse <i>Tidligere kvalifisert</i>	Langsgående profil (8mm) mot topplate (16mm)	Horisontal, ingen fuge. Full gjennombrenning med baksveis.
Buttforbindelsee (16mm) <i>NY</i>	Topplate (16mm) mot topplate (16mm)	Horisontal, Y-fuge Full gjennombrenning med baksveis.
T-Forbindelse <i>NY</i>	Langsgående steg (20mm) mot topplate (16mm)	Horisontal, K-fuge Delvis innbrenning fra to sider.

##### 4.1.2.2 Lasersveis

Lasersveis benyttet i prosjektet.

Type	Platetykkelse	Beskrivelse
Lapweld <i>Tidligere kvalifisert</i>	Bunnplate (8mm) mot Flens på langsgående profil (8mm)	Horisontal, ingen fuge. Innbrenning 2mm.

## 4.2 OMBYGGING AV PRODUKSJONSLINJE



Figur 15.: Produksjonslinjen etter utbedringer

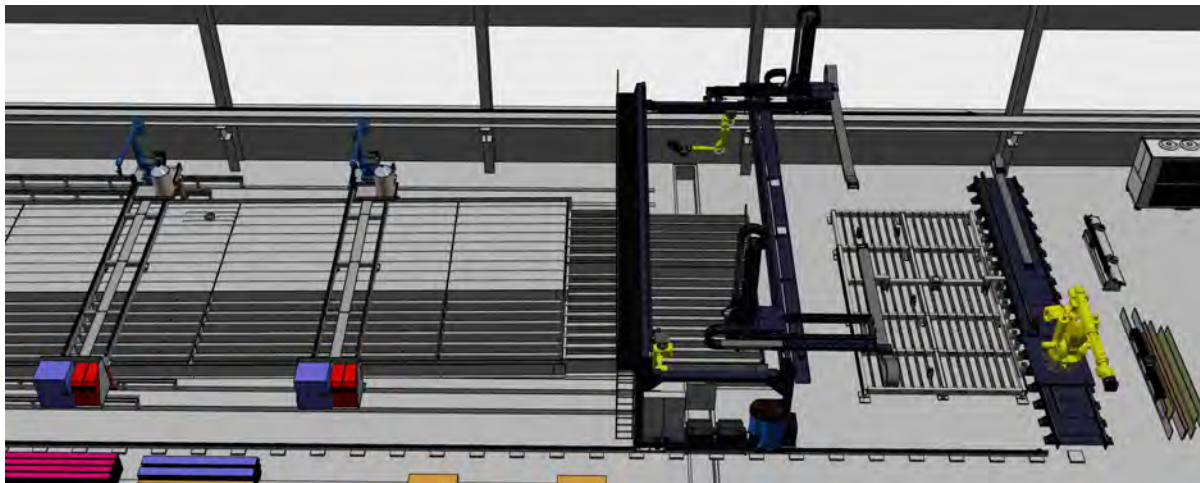
Før produksjonsstart ble produksjonslinjen utvidet og utbedret. Den består nå av tre celler og er over 40m lang. I utgangspunktet bestod produksjonslinjen av Gantry 1 og monteringsroboten. To flyttbare MIG-celler plassert utenfor produksjonslinjen dannet en egen produksjonscelle i forrige prosjekt.

#### 4.2.1 Utbedringer/Endringer

Gantry 1 fikk nye skinner og styring langs gulvet. Gantryen har nå en vandring langs gulvet på ca. 15m som styres via PLS. På grunn av PLS-styringen er det ikke mulig å kjøre Gantryen langs skinnene og sveise samtidig. Selv om vandringen ikke er robotstyrt er der kommunikasjon fra robot til PLS-en og en av robotene kan gi signal om at gantryen skal flyttes.

Sveisebordet i Gantry 1 som ble benyttet i YA-prosjektet er utvidet. Gripeverktøy og kassetter til monteringsrobotens plukke-stasjon er utbedret og tilpasset Elverhøy-prosjektet.

De to MIG-cellene som i YA-prosjektet var en frittstående celle er flyttet inn i produksjonslinjen i fortsettelsen av Gantry 1. Skinnene har blitt hevet slik sandwichdekket får fri passasje under dem.



Figur 16.: Fra venstre - MIG-Celler, Gantry 1 og Monteringscelle

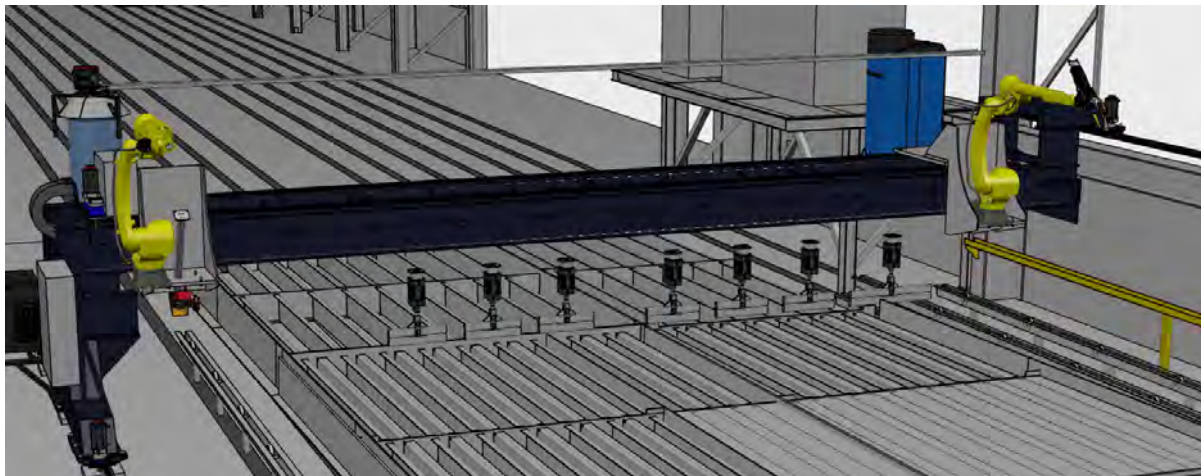


#### 4.2.2 Gantry 2

I tillegg til ombygging av Gantry 1, har en ny gantry blitt bygget, Gantry 2. Den er utstyrt med to sveiseroboter. En ny laserkilde er satt inn og koblet på robotene i Gantry 2, gantryen har en robot som benytter lasersveis, og en som benytter MIG.

Gantry 2 har vandring langs gulvet i samme retning som Gantry 1. Vandringen er ikke styrt av ekstern PLS, men er robotstyrt. Den kan derfor sveise og flytte seg langs skinnene i gulvet samtidig dersom det er ønskelig.

I tillegg til robotene er «Press-down tool» montert på Gantry 2. Dette utstyret presser ned bunnplaten til sandwichdekket før sveising. Utstyret styres via PLS.



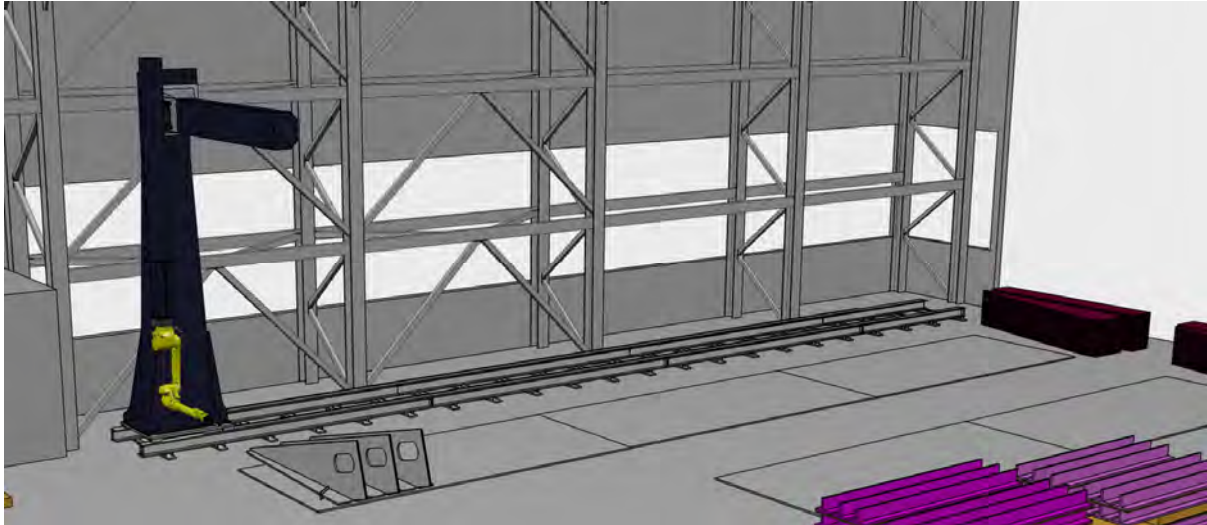
Figur 17.: Gantry 2

#### 4.2.3 Kjettingdrag

For å kunne flytte sandwichdekket nedover i produksjonslinjen underveis i produksjonen er et kjettingdrag installert. Kjettingdraget er koblet på en elektromotor og styres manuelt.

#### 4.2.4 IGM-Gantry

En ny produksjoncelle er satt opp i tillegg til produksjonslinjen, IGM-Gantryen. Cellen sveiser i all hovedsak på element som skal benyttes i den underliggende stålbjelken. Den har en vandring på over 20 meter langs gulvet og består av en Fanuc-sveiserobot som sveiser MIG.



Figur 18.: IGM-Gantry

## 5 PRODUKSJON

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### 5.1 SOFTWARE

Cloud-løsningen til Softwareprogrammet 3DEXPERIENCE fra Dassault Systems benyttes til 3D-modellering, simulering og robotprogrammering. 3DEXPERIENCE forenkler samarbeidet og kommunikasjonen mellom design og produksjon. Broen er modellert opp med rollen «Civil Designer», ut fra modellen genereres innkjøps- og produksjonsunderlag. Når designet er fullført overfører modellen til automasjonsavdelingen og de starter programmering av produksjonsceller, til dette nyttes rollene «Equipment & Layout Engineer» og «Fabrication Robot Programmer». Rollen «Structural Engineer» er brukt i mindre analyser i prosjektet. I tillegg til de nevnte rollene har de ansatte med viewerlisens tilgang til 3D-modell og digitalt produksjonsunderlag.

Lisenser benyttet i prosjektet

Nr.	Beskrivelse	Lisens (Rolle)
1	3D-modellering	Civil Designer
2	Simulering og FEM-analyser	Structrual Engineer
3	Oppsett av robotcelle	Equiptment & Layout Engineer
4	Robotprogrammering	Fabrication Robot Programmer
5	Begrenset tilgang til 3D-modeller	Viewer

## 5.2 PRODUKSJONSUTSTYR (HARDWARE)

Nr	Beskrivelse	Typebetegnelse
1	Sveisegantry	Prodtex design
2	Sveisejigg	Prodtex design
3	Sveiserobot 1 (Gantry 1)	Fanuc M-20iA 35M
4	Sveiserobot 2 (Gantry 1)	Fanuc M-20iA 35M
5	Laserkilde (Gantry 1)	Trumpf Trudisc10002
6	Sveisekilde MIG (Gantry 1 & Gantry 2)	Fronius tps/I 400
7	LaserHybrid Type A	Fronius tps/I 500
8	LaserHybrid Type C	Fronius tps/I 500
9	Lasertracker	Servorobot
10	Monteringsrobot	Fanuc M900iB-400L
11	Skinne for monteringsrobot	Prodtex design
12	Force/Torque sensor	ATI
13	PLC	Beckhoff IPC C6930
14	Sveisebord (Gantry)	Prodtex Design
15	Posisjoneringsverktøy langsgående stivere	Prodtex Design
16	Press-down tool	Prodtex Design
17	Sveiserobot 1 (MIG-celle)	Motoman MH50-20
18	Sveiserobot 2 (MIG-celle)	Motoman MH50-20
19	Sveisekilde (MIG-celle)	Fronius tps 5000
20	Skinnesystem MIG-celle	Prodtex Design
21	Sammenføynings-jigg	Prodtex Design
22	Flyttbar robot	Fanuc Arc Mate 120iD
23	Gantry 2	Prodtex Design
24	Sveisekilde MIG (Gantry 2)	TPSI 400-i
25	Sveiserobot 1 (Gantry 2)	ArcMate-120iD12L
26	Sveiserobot 2 (Gantry 2)	ArcMate-120iD12L
27	Laserhode (Gantry 2)	Process Optics D50 Coherent

28	Laserkilde (Gantry 2)	TruDisk 10003 (4 C/S)
29	IGM-Sveisegantry	IGM-design, Prodtex modifisert
30	Sveiserobot (IGM-Sveisegantry)	ArcMate-120iD12L
31	Sveisekilde (IGM-Sveisegantry)	TPSI 400-i



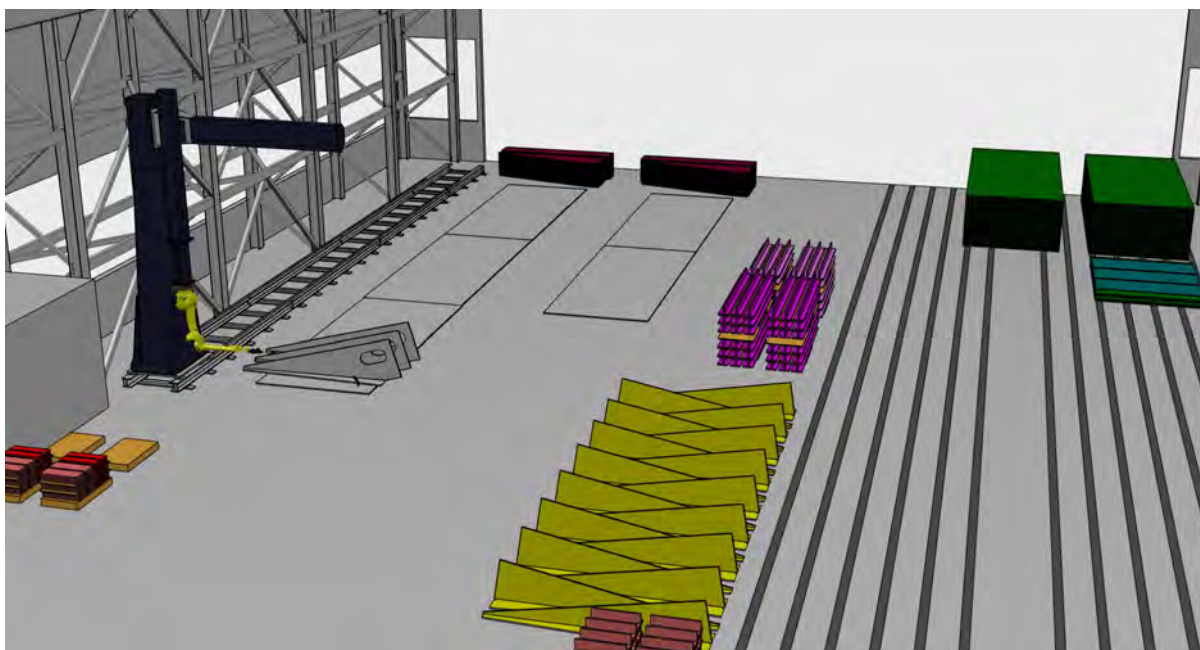
### 5.3 LAGER OG LOGISTIKK

Alle innkjøpte stålplater og ståldeler til produksjonen er lagret tørt og innendørs. De er merket med ID-nummer. Ved mottak sorteres og kontrolleres platene.

Platene er lagret i stabler. Alle stabler er sortert etter platetype og når i produksjonen platene skal benyttes. Plater som tas i bruk helt til slutt i produksjonen, ligger i bunn av stablene, og de som benyttes tidlig ligger på toppen. Ulike platetyper er ikke blandet i samme stabel. Det er egne stabler for topplater, bunnplater, langsgående steg til sandwich, tverrgående steg og bjelker til sandwich, bunnflens, langsgående- og tverrgående steg til underliggende bjelke, flens og steg til tverrammer i underliggende bjelker og flens og steg til tverrbjelke i underliggende bjelke.

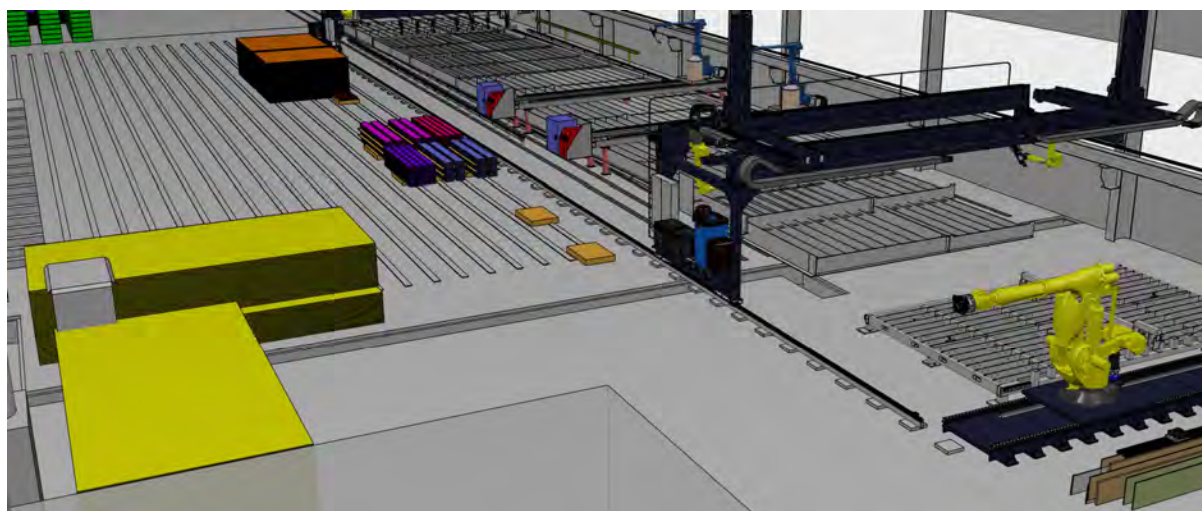
De ulike platestablene er plassert i nærheten av de cellene hvor platetypen som er stablet skal monteres. De fleste platene er løftet inn i cellene med kran, og det er derfor tidsbesparende at de ligger i nærheten av hvor de løftes inn. Delene som monteres med monteringsrobot ligger i nærheten av roboten og er plassert i kassetter som skiftes ut ved behov.

Deler til den underliggende stålbjelken plasseres der i nærheten av IGM-Gantryen. Ferdig prefabrikkerte deler lagres i samme område slik de lett tilgjengelige i nærheten av cellen hvor de skal bearbeides videre.



Figur 19.: Illustrasjon for platelagring i området rundt IGM-Gantryen

Deler til sandwichdekket lagres i nærheten av produksjonslinjen, platetyper som monteres tidlig i linjen er plassert ved Gantry 1. Bunnplater og braketter til rekkverk montres senere i prosessen og står i stabler plassert ved Gantry 2.



Figur 20.:Illustrasjon for platelagring i området rundt produksjonslinjen

## 5.4 PRODUKSJON DECKSEGMENT

Totalt åtte Decksegment er produsert. Fire til A siden og fire til B siden. Elementene varierer i lengde, og A-siden er noe bredere enn B-siden og har to langsgående steg, der B-siden har ett langsgående steg. A-siden har sluk, og B-siden har gangfelt.

Decksegmentene bygges og sveises i produksjonslinjen, og arbeidet er delt inn i ulike aktiviteter som foregår i ulike celler. Segmentene er produsert «opp ned», topplaten plasseres i bunn og bunnplaten er det siste som monteres.

Decksegmentet flyttes gradvis nedover produksjonslinjen med hjelp av kjetting-draget, og hvert flytt er på 3,2 meter. Det fylles på med nye deler etter hvert som segmenter blir flyttet nedover i linjen. Decksegmentene produseres fortløpende, der er ett flytt, 3,2meter, mellom den siste topplaten i ett Decksegment og den første topplaten i neste Decksegment. Dette gjelder fra Decksegment nr.1 til Decksegment nr.8.

### 5.4.1 Gantry 1 og monteringsrobot

#### 5.4.1.1 Skjøt av topplate

Den foregående topplaten flyttes ett hakk lenger ned i produksjonslinjen v/hjelp av kjetting-draget. Neste topplate heises inn på sveisebord med kran og posisjoneres. Deretter skjøtes topplaten med laserhybridsveis.

#### 5.4.1.2 Montasje av langsgående profiler, langsgående steg og tverrbjelke/tverrstiver

Når topplaten er ferdig sveiset monteres tverrbjelke/tverrstiver med hjelp av kran, deretter monterer sveiseroboten de langsgående profilene. Til slutt monteres de langsgående stegene, også disse løftes inn med kran.

#### 5.4.1.3 Sveis av langsgående profiler og langsgående steg

Når monteringen er fullført flyttes seksjonen ett hakk ned i linjen. Deretter sveises de langsgående stegene og profilene med laserhybridsveis.

#### 5.4.2 MIG-Celler

Neste stasjon er MIG-Cellene. De består av to celler og to MIG-roboter, en som sveiser vertikale sveiser, og en som sveiser horisontale. I dette området utføres også montasje av sluk og forsterkningsbraketter til rekkverk.

##### 5.4.2.1 Vertikale sveiser

Først sveises de vertikale sveisene. Dette er forbindelsen mellom langsgående steg og -profiler som sveises mot tverrbjelke og tverrstiver.

NDT utføres på sveisene som ble lagt i Gantry 1. Disse er reparert fortløpende ved behov.

##### 5.4.2.2 Horisontale sveiser og reparasjoner

Decksegmentet flyttes ett hakk videre og områder hvor laserhybridsveisen ikke hadde tilkomst på de langsgående stegene og -profilene er sveiset i denne cellen. I tillegg repareres sveiser det er utført NDT på i dette området.

#### 5.4.3 NDT-stasjon

Holdetiden fra sveis til kontroll er minimum 24t. NDT-sonen er derfor fordelt over fire flytt. Optimal hastighet på flytt er to for dag. I NDT sonen utføres NDT og reparasjoner.

#### 5.4.4 Gantry 2

Etter fullført NDT-kontroll monteres bunnplatene.

##### 5.4.4.1 Lapweld

Når bunnplaten er montert sveises den mot flensen på de langsgående profilene med lapweld. «Press-down tool» trykker bunnplaten ned mot flensen og sørger for at der er full kontakt under punkting. Når bunnplaten er ferdig punktet kjøres 3 «run» med lapweld på hver av flensene.

##### 5.4.4.2 MIG-sveis

Når bunnplaten er ferdigsveiset i de langsgående profilene lukkes Decksegmentet med å legge MIG-sveis rundt hele bunnplaten og inn mot langsgående steg og tverrstiver/tverrbjelke.

Visuell kontroll utføres etter sveis, men resterende NDT av sveiser lagt i Gantry 2 utføres etter utløft.

#### 5.4.5 Utløft

Når alt sveisearbeidet i Gantry 2 er utført, flyttes Decksegmentene helt i enden av produksjonslinjen og løftes ut.

Decksegmentet roteres slik toppplaten peker oppover og plasseres på stålbjelken som «tilhører» elementet.

## 5.5 PRODUKSJON STÅLBJELKE

Det produseres stålbjelker tilhørende hvert av de åtte Decksegmentene. Segmentene produseres i IGM-gantryen, men flere områder er manuelt sveiset dette er fordi IGM-Gantryen bare har en sveiserobot, og den klarer ikke holde takten som er ønsket uten bidrag fra manuelle sveisere.

### 5.5.1 Prefabrikasjon T-Bjelker

Stålbjelken har tre ulike typer T-bjelker. Bjelkene sammenstilles manuelt og sveises med MIG-robot i IGM-cellen. Alle bjelkene sveises opp samtidig og legges på lagring. All NDT og reparasjoner utføres fortløpende.

Disse T-bjelkene har alle sveisefuger. For å fylle fugene måtte det sveises tre strenger, disse er lagt med MIG-robot og det er første gang i Prodtex sin broproduksjon at alle strengene i en sluk K-fuge er lagt med robot.

#### 5.5.1.1 Vertikal T-bjelke til tverramme

Totalt produseres 120stk vertikale T-bjelker til tverrammene i stålbjelken

#### 5.5.1.2 Horisontal T-bjelke til tverramme

Totalt produseres 60 horisontale T-bjelker til tverrammene i stålbjelken.

#### 5.5.1.3 Langsgående T-bjelker

Totalt produseres 72stk langsgående T-bjelker til området rundt aksene i stålbjelken.

### 5.5.2 Prefabrikasjon av tverrbjelker til stålbjelkene

Tverrbjelkene som skal gå fra stålbjelken og ut mot sidekanten på konstruksjonen ansees i produksjonen som en del av stålbjelken. Tverrbjelkene sammenstilles manuelt og sveises med MIG-robot i IGM-Gantryen. Totalt er der 36 slike bjelker, bjelkene produseres opp og settes på lagring.

### 5.5.3 Prefabrikasjon langsgående steg

Stålbjelken har tre langsgående steg. De vertikale T-bjelkene monteres på de langsgående stegene og sveises i IGM-Gantryen. Stegene settes på lagring når de er ferdig.

### 5.5.4 Prefabrikasjon bunnflens

Bunnflensene produseres fortløpende, element for element. Horisontale T-bjelker til tverramme og ved akser monteres og sveises, og bunnflensene skjøtes i IGM-Gantryen. Buntråden er lagt manuelt.

### 5.5.5 Sammenføring av stålbjelkeelement

Når bunnflensen er ferdig prefabrikkert monteres de langsgående stegene i bjelken. Stålbjelkeelementet sveises både med MIG-robot i IGM-gantryen og manuelt. NDT og reparasjoner utføres fortløpende. Når bjelkeelementet er ferdig flyttes det og klargjøres til sammenføring med det tilhørende Decksegmentet.

## 5.6 SAMMENFØYING STÅLBJELKE OG DECKSEGMENT

Når Decksegmentene er løftet ut av produksjonslinjen og rotert står den tilhørende stålbjelken klar. Decksegmentet plasseres på stålbjelken og de prefabrikkerte tverrbjelkene monteres. Konstruksjonen sveises, og sveisearbeidet er manuelt utført.

Når sveisearbeidet er fullført, flyttes elementet ut av produksjonshallen.

## 5.7 TVERRBJELKER

Tverrbjelkene er bygget manuelt. Der var ikke ledig kapasitet i robotcellene til å produsere dem automatisert.

## 5.8 OVERFLATEBEHANDLING

Overflatearbeidet er utført utendørs. Ved dårlig vær dekkes elementene til med telt bygd opp av stilas og presenning. Elementene påføres både membran og maling i utvalgte soner.

### 5.8.1 Membran

Hele toppdekket med unntak av en smal sone langs ytterkantene hvor det senere skal legges kantdrager påføres membran.

Før påføring av primer og membran, renses toppdekket, på Fiskå er det benyttet laser for å renses dekket. Det er renses på tradisjonelt vis på riggplass.

Topplatene på sandwichdekket primes med «Safeprime», deretter påføres membranen «Safegrip». Med unntak av skjøtesonene er all membran påført på Fiskå. Skjøtesoner er behandlet på riggplass etter sammenføring og NDT-kontroll av toppdekket.

Safeprime og Safegrip er produkter levert av Fjerby v/Gunnar Østby. Produktene er påført av WestCoat AS etter instruks fra Fjerby.

### 5.8.2 Maling

Området langs kantdrager og kileplater til lager males. Malingssystemet benyttet er.:

- NORSOK M-501 System nr 1.
- RAL-kode 7016

Mesteparten av malingsarbeidet utføres på Fiskå, med unntak av skjøtesoner og kileplater til lager, de behandles på riggplass etter sammenføring.

## 5.9 SAMMENSTILLING RIGGPASS

Det er brukt 9 uker på ferdigstilling til installasjon, det er utført noe etterarbeid etter installasjon som trykktesting, maling av kantplater og lager, samt reparasjon av sveis og fjerning av merking på stålet.

### 5.9.1 Posisjonering av element

Det er på grunn av vekt og presisjon benyttet SPMT for å posisjonere ståloverbyggingen på riggplass. Posisjoneringen til SPMT'en har en presisjon på et par millimeter. I tillegg går det raskt og alle åtte elementene var ferdig målt inn og posisjonert på et par dager. Elementene er plassert på bukker under sammenstillingen.

### 5.9.2 Preparering og montasje til sveisearbeid

Der er mange skjøter mellom de åtte elementene. Tverrsnittet mellom de åtte elementene er skjøtt i langsgående steg både i sandwich og underliggende bjelke. Det er også langsgående profiler, sideplater, topp- og bunnplate i sandwich. I langsgående retning er topplaten i sandwichdekket skjøttet. Det samme gjelder u-rammer, tverrbjelker og -stivere på B-siden, disse er skjøtt mot det langsgående steget i senter i konstruksjonen. Endetverrbærere er montert og sveiset og tilkomstluker



inne i konstruksjonen er lukket. Braketter til rekkverk er montert og preparert, det samme er dybler til kantdrager, opphengs-braketter til VA og kileplater for innfesting av lager.

Alle disse områdene er preparert, det er sikret at plater ikke sakser og at fuger har riktig åpning. Dersom fugene er skadet, repareres de, om åpningen er for stor iverksettes reparasjoner. Sveiseområdene er rensset ved behov. Dette er gjort ved hjelp av sliping og trykkluft.

### 5.9.3 Sveis

Et anslag viser at det er sveiset mellom 5000-7000 meter med sveis på riggplass. Reparasjoner og punkting er ikke medregnet i estimatet. For hver lengde som er sveiset er det lagt mellom 1-5 tråder.

Ca. 300 meter av de estimerte sveisemeterne er utført med robot. Og ca 300-350 meter er sveiset med sveisekrabbe (En sveisepistol på skinner som festes mot stålet med magnet, justeres inn og kjøres av en sveiser).

### 5.9.4 NDT

Aqma utfører tredjepartskontroll av NDT både på riggplass og på fabrikk. NDT er utført i henhold til kontroll og prøvingsplan, samt sveisetabell.

### 5.9.5 Membran og maling

All maling og membran er påført elementene i fabrikk med unntak av skjøtesoner. Skjøtesoner er påført maling og membran etter sveisearbeid og NDT var utført i disse områdene på riggplass.

### 5.9.6 Trykktesting

Trykktesting er utført i henhold til kontroll og prøvingsplan. Det er utført trykktesting av alle lukkede rom i Sandwichkonstruksjonen, og i de underliggende bjelkene. Arbeidet er utført både før og etter installasjon.

## 5.10 UTFORDRINGER

### 5.10.1 Ombygging av produksjonslinje

På grunn av forsinkelser knyttet til ombygging av produksjonslinje ble full produksjon utsatt fra slutten av januar til etter påske.

Forsinkelser i ombygging skyldes leveringstid på komponenter, uforutsette komplikasjoner

Produksjonen ble startet opp i slutten av januar, men med redusert kapasitet.

### 5.10.2 NDT

Det er tatt hensyn til NDT-omfanget og holdetider i produksjonsplanleggingen. Det er forsøkt å tilrettelegge produksjonen slik at NDT-arbeidet ikke fører til stans i produksjonslinjen. Produksjonen har lyktes bedre i å unngå stans og opphold i dette prosjektet enn i YA-prosjektet. Men NDT-omfanget er fortsatt høyt. I perioder er det krevende å få tak i nok bemanning, noe som fører til uønsket overtid. Kostnaden for arbeidet er også meget høyt, og NDT-arbeidet utført i fabrikk har en kostnad på rundt 4 millioner kroner. Kostanden for NDT på riggplass er ikke klare enda når rapporten skrives.

### 5.10.3 Større sveisetrekk enn antatt

Basert på erfaringer fra YA-produksjonen er der lav sveisetrekk i sandwichkonstruksjonen, og noe mer i stålbjelkeproduksjonen. Det er derfor antatt en krymp på ca 25mm i lengderetning og 5mm i



tverretning i sandwichkonstruksjonen, for den underliggende stålbjelken er det antatt krymp på 90mm i lengderetning og 10mm i tverretning. Sluttmålinger gjort på riggplass etter sammenstilling viser at konstruksjonen er over 70mm for kort i lengderetning og 30mm for kort i tverretning.

Vi kan ikke si med 100% sikkerhet hva som er årsaken til avviket, men mistenker at den økte lengden på Decksegmentene og de tre langsgående stegene i sandwichen er medvirkende årsaker til at krympen har økt fra forrige prosjekt. Lengre element reduserer muligheten til å justere lengde underveis i produksjonen. Platetykkelse, sveisetypen og -mengde er også parametere som påvirker den totale krympen.

#### **5.10.4 Materiallevering**

Materialleveringen ble over to måneder forsinket i prosjektet. Det var estimert ferdig leveranse medio oktober 2022 ved bestilling, men siste levering av material ankom ikke produksjonen før tidlig januar 2023.

#### **5.10.5 Mannskap**

Det har vært problematisk å holde bemanning av sveisere og montører på ønsket nivå. Prodtex Industri leier inn mannskap via bemanningsbyrå, og gjennom hele produksjonen og spesielt på sammenføyingen på riggplass har det vært problematisk og å få tak i nok kvalifiserte arbeidere.

#### **5.10.6 Robotkapasitet og manuelt arbeid**

Produksjonslinjen er utvidet og IGM-gantryen er tatt i bruk, det gjør at robotkapasiteten er økt med to MIG-roboter og en laserrobot siden YA-prosjektet. Det er fortsatt for mye manuelt arbeid som blir utført. Denne broen er dobbelt så lang som YA og noe bredere, så det er vesentlig mye mer sveisearbeid på den.

Under sammenstillingen av Decksegment og stålbjelker er alle sveiser manuelt utført. Det er også for mye manuelt arbeid på stålbjelkene isolert, alle bunnstrenger i buttskjøter er lagt manuelt, og braketter og mindre deler er også sveiset manuelt.

Det er fullt mulig å fjerne mye av det manuelle arbeidet. Der er potensial i utforming og tilpasning av designet som skal produseres, innkjøp av mer automatisert sveiseutstyr og videreutvikling og fortsatt forskning på de produksjonsmetodene som allerede er i bruk.

## **6 TRANSPORT OG INSTALLASJON**

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Transport og installasjon er ikke utført av Prodtex, men Prodtex har vært delaktig i prosessene.

### **6.1 TRANSPORT**

Elementene er transportert med båt fra Fiskå til Sunndal. Prosjektet fikk losse båtfrakten ved Hydro sitt anlegg i Sunndal. Elementene er fraktet videre til riggplass med lastebil. SPMT er brukt for å posisjonere elementene etter ankomst riggplass.

Transporten er utført av Prøven Transport.

## 6.2 INSTALLASJON

Sarens Norge er innleid for å utføre installasjon av stålkassen over elv. Stålkassen er flyttet over elven ved bruk av SPMT, og er deretter jekket opp i riktig høyde og posisjonert over akser. Selve kjøringen over elv, jekking og posisjonering tok mindre enn en uke og installasjonen var meget effektiv.

## 6.3 ETTERTANKE

Transport- og installasjonskostnadene er store kostnader i prosjektet, sett i forhold til prisen av stålkassen. Det å bygge element som kan fraktes på vei vil mest sannsynlig redusere transportkostnadene betraktelig, og det vil nødvendigvis ikke øke produksjonskostnadene nevneverdig. Det kan også åpne for mer fleksibilitet når det kommer til sammenstilling og installasjon av stålkassen.

# 7 HELSE, MILJØ OG SIKKERHEIT (HMS)

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## 7.1 MONTERING MED ROBOT

Monteringsroboten er et effektivt verktøy, men den kan gjøre stor skade på personell og materiell ved feil bruk eller uaktsomhet. Det er nødvendig med personell i fabrikk under produksjon, de som jobber i området hvor monteringsroboten står har nødvendig opplæring og hastighet på robotbevegelser er redusert.

## 7.2 SVEISING MED LASER OG LASERHYBRID

Laserlyset til laser- og laserhybridsveiser kan gi skader på syn. I verste fall kan det føre til at vedkommende som utsettes direkte for lyset blir blind. Prodtex Industri har strenge rutiner for bruk av laserbriller i produksjonshallen. Det er påbudt med laserbriller i hallen, og når det sveises med laser- og laserhybrid varsles det med sirener og lys, alle innganger til hallen lukkes og låses.

Alle som skal arbeide eller oppholde seg i hall må fullføre en sikkerhetsbrifing. Dersom retningslinjene ikke blir fulgt, får vedkommende ikke lov å fortsette arbeidet i fabrikk.

## 7.3 KRANLØFT

I produksjonen av ståloverbygningen benyttes kran til å løfte og vende stålelement. Det er påbudt med hjelm i områder hvor kran benyttes, og sikker jobb analyse er utført for løftene. Før tunge løft varsles alle som arbeider i området hvor løftet utføres. Kun nødvendig personell er til stede under disse kranoperasjonene.

## 7.4 ARBEIDSMILJØ

Prodtex Industri jobber aktivt for et godt arbeidsmiljø. Det er en prioritet å redusere farlige situasjoner, skader og ulykker og fremme trivsel og god helse på arbeidsplassen. Ulykker, skader og mulig farlige situasjoner skal registreres som avvik og behandles for å redusere risikoen for gjentagelser i fremtiden.

## 8 KVALITET

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### 8.1 SERTIFISERING

Prodtex jobber aktivt med kvalitetssikring og er sertifisert i henhold til NS-EN 1090-serien og kan levere CE-merkede stålkonstruksjoner. Prodtex er også sertifisert i henhold til NS-EN ISO 9001 og 14001.

Produksjonsutstyret Prodtex bruker er underlagt forskrift om maskiner og er CE-merket. Risikoanalyser er utført som en del av CE-merkingen av utstyret og tiltak er iverksatt for å redusere risikoen ved bruk.

### 8.2 ENGINEERING

Modellering, simulering, analyser og programmering er utført i Dassault Systems 3D Experience. Programvaren er mye brukt i bil- og flyindustrien. Mulige feilkilder reduseres når både design og produksjon jobber i samme program med samme modell.

### 8.3 MATERIALE

Benyttet materiale er SSAB Weathering 420 ML (S420J5W M), levert av SSAB via Tibnor. Materialet er EN10204-3.1 sertifisert og levert med dokumentasjon på materialegenskaper og resultater fra materialtesting.

### 8.4 SKJÆRING/FUGING

Materialet er valset, skjært og fuget hos SSAB i Finland. Toleranser er bestemt ved innkjøp og alle plater kontrolleres. De som er utenfor toleransekravet, blir forkastet og erstattet med nye. Det er brukt samme leverandør som i YA-prosjektet, og det har også i dette prosjektet vært minimalt med feil på leveransen, og feilene som er funnet har vært enkle å rette opp.

Hele plater som skal brukes til langsgående profiler i sandwichdekket er sendt fra Finland til IMS. Der er de skjært og knekket. Det er ikke funnet mangler eller feil på stivere som er mottatt.

### 8.5 NDT

NDT er beskrevet i kontroll og inspeksjonsplanen. Inspeksjonsomfanget baserer seg på sveiseklassene, WIC, i håndbok N400 og ISO. NDT er utført av tredjepart, Aqma AS, og i henhold til ISO sine sveiseklasser.

Hvilken sveiseklasse hver enkelt sveis skal ha er utarbeidet sammen med Statens Vegvesen og Norconsult.

## 9 FREMDRIFT

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Planlagt produksjonsstart var satt til første uken i januar 2023. Produksjonsstarten ble forskjøvet en måned frem i tid, og gikk med redusert kapasitet frem til slutten av april.

### 9.1 PRODUKSJONSFORBEREDENDE FASE

#### 9.1.1 Ombygging/oppgradering av produksjonsceller og produksjonsutstyr

I den produksjonsforberedende fasen ble, som nevnt tidligere, produksjonslinjen og verktøy oppgradert og bygget om, og nye celler installert i produksjonshallen. Dette tok mer tid en forventet og førte til at produksjonen ble noe forsinket.

#### 9.1.2 Produksjonsplanlegging

Produksjonsplanleggingen er har fokusert mer på produksjon av stålbjolkene enn i YA-prosjektet. Produksjonen er brutt ned steg for steg og produksjonslinjen med Gantry 1, MIG-cellen og Gantry 2 er bygd om med tanke på hvordan det er ønsket å produsere Decksegmentene. Prefabrikasjon av T-bjelker og tverrbjelker til stålkassen er planlagt slik at delene er klar til selve byggingen av stålkassen starter. Det er begrenset med areal innendørs, og flytt av Decksegment og stålbjelker er koordinert med hverandre.

Åttendedelselementene må sammenføres og flyttes ut av hallen i takt med når Decksegmentene er ferdig i produksjonslinjen, og stålbjelken som tilhører Decksegmentet som står i produksjonslinjen må være posisjonert og klart samtidig som Decksegmentet er klart for utløft.

Produksjonen er planlagt i detalj på forhånd, og underveis i produksjonsperioden er den oppdatert etter hvert som forsinkelser og utfordringer har oppstått.

#### 9.1.3 Sveisetester

Sveisetester og sveisekvalifisering for de to nye sveisene i prosjektet ble utført i den produksjonsforberedende fasen. Og erfaringen er at jo flere sveisekvalifikasjoner som er utført og godkjent, jo lettere er det å produsere nye tester av god kvalitet som sendes til godkjenning.

#### 9.1.4 Materiallevering

Materialleveringen var noe forsinket fra leverandør, noe som bidro til forsinket oppstart.

## 9.2 STÅLBJELKER

#### 9.2.1 Prefab tverrbjelke

På tverrbjolkene ble den første streng i fugen manuelt utført i starten, senere ble også den gjort med MIG-robot, produksjonen gikk radig og uten nevneverdige problemer.

#### 9.2.2 Prefab T-bjelker

På grunn av testing av T-forbindelse med fuge utført av MIG-robot var fremdriften lavere enn ønsket i starten, men etter hvert gikk produksjonen i ønsket tempo. Tverrbjelker og T-bjelker ble produsert delvis i samme tidsrom. Der Tverrbjelken hadde en tidligere oppstart av produksjonen.

### 9.2.3 Prefab langsgående steg og bunnflenser

Produksjon av de langsgående stegene var uproblematisk i seg selv, de fleste av dem ble produsert samtidig som bunnflensene, og bunnflensene var noe mer krevende å produsere på grunn av buttskjøten mellom dem. Den krever full gjennombrenning og det var en flaskehals for resten av produksjonen at den måtte legges manuelt.

### 9.2.4 Sammenføring til stålbjelke

Sammenføring av stålbjelker var også preget av manuelt arbeid. Bunnstrengen i skjøtene mellom de langsgående stegene er manuelt utført, og mindre sveiser i sammenstillingen til tverrammene er også manuelle. Med bare en sveiserobot tilgjengelig til så mange meter og lag med sveis var det nødvendig med manuelt arbeid i tillegg.

## 9.3 DECKSEGMENT

På grunn av ombygging ble produksjonen av Decksegmentene forsinket. Gantry 2 var ikke klar for full produksjon før i april. Produksjonen gikk tilnærmet normalt i Gantry 1 og i MIG-cellene, og det ble bygget opp et «lager» med Decksegment som måtte tilbake i produksjonslinjen når Gantry 2 var klar.

Når Gantry 2 endelig var i full drift økte produksjonstakten til det nivået som var ønskelig fra start. Men på grunn av forsinket oppstart var det krevende å hente inn igjen tapt tid.

## 9.4 SAMMENFØYING MELLOM DECKSEGMENT OG STÅLBJELKER

Sammenføyingen mellom Decksegment og stålbjelker er preget av manuelt arbeid. Fremdriften var ikke så høy som ønskelig, men det som ikke ble fullført inne i produksjonshallen på normert tid, ble utført utendørs før overflatebehandling.

## 9.5 OVERFLATEBEHANDLING OG MEMBRAN

Overflatebehandlingen er utført av WestCoat AS. Arbeidet er ikke preget av forsinkelser, og er utført på tiltenkt tid.

## 9.6 MONTASJE RIGGPASS

Selve posisjoneringen av elementene var hurtig utført, dette ble som nevnt tidligere utført med SPMT. Det ble brukt en del tid på å tilpasse skjøtene mellom elementene, og første perioden på riggplass var preget av dårlig vær.

Det var estimert at arbeidet på riggplass skulle ta 8 uker å fullføre. Dette tok lenger tid enn planlagt på grunn av problemer med bemanning og at arbeidet med å tilpasse skjøter var mer tidkrevende enn ventet. Fra stålkassen var plassert på riggplass, til den var klar for installasjon ble det brukt 9 uker. Som nevnt tidligere er det utført litt etterarbeid etter installasjon.

Noe som forbedret arbeidet på riggplass var stål-backing på den langsgående skjøten i topplaten, dette gjorde området mye enklere å sveise enn det som var erfaringen fra YA-sammenstillingen.

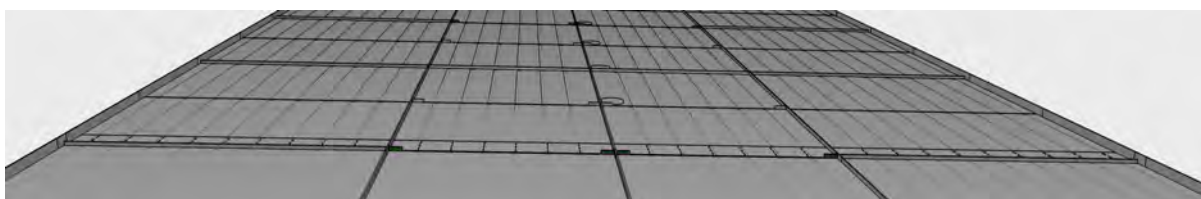
## 10 FORBEDRINGSPOTENSIAL OG ETTERTANKER

Det er lagt inn et eget kapittel med tittel «Forbedringspotensial og ettertanker» i rapporten. Dette er fordi gjennom produksjonen av stålkassen til Elverhøy bro er der flere punkt hvor Prodtex ser muligheter for forbedring og utvikling.

### 10.1 DESIGN TILPASSET AUTOMATISERT PRODUKSJON

#### 10.1.1 Langsgående steg og tverrbjelker/tverrstivere

Noe som kunne bedret designet på Decksegmentene uten å endre lengden på dem er å unngå tverrbjelker/tverrstivere og langsgående steg som går «gjennom» bunnplaten. Disse burde stoppe opp i bunnplaten, slik vi får sveiset de med lapweld gjennom bunnplaten.



#### 10.1.2 Platetykkelser

Tykkere plater er mer tidkrevende å sveise, uansett metodikk. Den underliggende stålbjelken består av 20- og 30mm plater. Sandwichdekket har 20mm tykkelse på det langsgående steget og 30mm tykkelse på tverrbjelkene. Det å få redusert platetykkelser er tidsbesparende. For eksempel vil det være tidsbesparende å halvere tykkelsen på tverrammenene i stålbjelken, men sveise dobbelt så mange av dem. Forutsatt at det ikke er behov for fuger. Det å redusere platetykkelser hvor det er mulig reduserer den totale stålmengden, men kan også redusere produksjonstiden.

#### 10.1.3 Områder med dårlig tilkomst

Områder i konstruksjonen med dårlig tilkomst øker mengden med manuell sveising og montering. Med dårlig tilkomst menes områder hvor man ikke når til med sveiserobot, eller som er vanskelig for en sveiser å manøvrere seg rundt i. Disse områdene er lettere kanskje lettere å «finne» etter arbeidet er utført, men lærdommen kan være overførbart til en ny konstruksjon.

I ettertid er det diskutert internt i Prodtex at dersom den underliggende stålbjelken hadde vært to stålbjelker med avstand mellom, så hadde skjøtingen av elementene på riggplass blitt forenklet og det hadde vært mulig å utføre flere av sveisemeterne i fabrikk, og skjøten mellom A og B-siden kunne blitt utført med en sveisekrabbe.

## 10.2 ELEMENTSTØRRELSE

I dette prosjektet ble det å produsere element av en størrelse som ikke kan fraktes på vei, i håp om at montasjetiden på riggplass gikk ned. I ettertid er konklusjonen at det å sammenstille mindre element som kan fraktes på vei ikke er mer tidkrevende enn å sammenstille større element. Ved å sammenstille mindre element på riggplass har det vist seg å være lettere å oppnå ønskede toleranser, og det er muligens mer effektivt å sammenstille.

I tillegg er det mye rimeligere å frakte elementene på vei, enn med båt.



### 10.3 BEDRE UTNYTTELSE AV KJENT TEKNOLOGI

Spesielt på riggplass kunne flere sveiser vært utført med sveisekrabbe og flyttbare roboter. Å bruke disse krever tilkomst, og at utstyret er tilgjengelig. Prodtex har kun hatt en sveisekrabbe og en flyttbar robot tilgjengelig i prosjektet, og bare i et begrenset tidsrom.

Det å anskaffe mer av dette utstyret er lavhengende frukt for å redusere kostnader og produksjonstid. Det er nyttig både på riggplass og i fabrikken. Produksjonen blir mindre avhengig av kvaliteten og effektiviteten til hver enkelt sveiser (som igjen kan bidra til å redusere reparasjoner), og behovet for antall sveisere reduseres.

Å få tak i nok kvalifiserte arbeider har vært problematisk gjennom hele 2023, og det å gjøre seg mindre avhengig av eksterne arbeidere vil gjøre prosjektgjennomføringen mer forutsigbar.

### 10.4 VIDEREUTVIKLING AV ROBOTTEKNOLOGI

Å fortsette å forske og videreutvikle den teknologien som er utprøvd i FOU-prosjektene har potensiale til å øke dagens produksjonseffektivitet ytterligere. Det er så vidt skrapet i overflaten og for hvert prosjekt avdekkes nye områder hvor teknologien kan videreutvikles.

Sveising med MIG-robot er ikke ett ukjent territorium, men der er flere optimaliseringer og forbedringer som ikke er utnyttet enda, blant annet det å legge stabile bunnstrenger uten backing og vertikal sveis i fugede områder som effektiviserer arbeidet, både i fabrikk og på riggplass.

Bruk av lapweld er i prosjektet avgrenset til de langsgående profilene i sandwichdekket, men burde ikke begrenses til dette. Lapweld burde kunne benyttes for å sveise topplaten mot langsgående steg og tverrstivere/bjelker. Og der er flere forbindelser som ikke er utprøvd med ren laser. Vi har også en teori om at i områder hvor det er nødvendig med tykke dimensjoner kan man knytte sammen smalere dimensjoner i flere lag med lapweld, for eksempel å sveise sammen tre 10mm plater med lapweld istendefor en 30mm plate. De tre lagene med 10mm plater som nå skal utgjøre en 30mm plate har ikke buttskjøtene mot motstående plater på samme plass, slik at dersom en av lagene har en dårlig forbindelse, vil ikke det andre laget sprekke opp i buttskjøten. Denne måten å bruke lapweld på for å «bygge» platetykkelser, men slippe store fuger er allerede planlagt testet i et annet prosjekt. Men der er potensiale for å kunne benytte teknologien også innenfor brobygging.

I tillegg er ikke laserhybridsveisen benyttet på plater over 16mm (butt-forbindelse) og 20mm (T-forbindelse). I prosjektet er det bare de langsgående profilene og stegene som sveises med laserhybrid.

## 11 MILJØ

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Å ta vare på miljøet får høyere og høyere prioritet, noe som må få konsekvenser for hvilke prosjekter som skal realiseres og hvordan disse skal gjennomføres.

Denne rapporten går ikke inn i vurdering på hvilke prosjekter som skal realiseres, dette er et altfor omfattende tema å vurdere her.

Utdrag fra artikkel på Statens Vegvesen sine nettsider den 03.12.2020:

### ***Vegvesenet skjerper klima- og miljøkrav***

***Statens vegvesen stiller nå krav til at alle prosjekter over 200 millioner kroner skal sertifiseres gjennom CEEQUAL.***

*Vegvesenet har vedtatt at alle prosjekter med en investeringsramme på over 200 millioner skal sertifiseres i tråd med Ceequal. Flere av etatens vegprosjekter er allerede sertifisert etter denne ordningen.*

*CEEQUAL (The Civil Engineering Quality Assessment & Awards Scheme) er et internasjonalt miljøsertifiseringssystem for anleggsprosjekter der målsetningen er å gjøre disse mer miljøvennlige og bærekraftige. Dette er en tilsvarende ordning som BREEAM, som er utbredt i byggsektoren. Ceequal er en bransjestandard som skal stille enhetlige og forutsigbare miljøkrav til anleggsbransjen.*

*Sertifiseringsordningen omfatter et bredt spekter av miljøhensyn, fra klima og energiforbruk, via arts mangfold og kulturminner til forholdet til naboer og andre interesseparter. Ordningen krever at anleggsprosjektet vurderes opp mot et sett av miljøkriterier, og hvert kriterium krever framlegging av dokumentasjon på oppfyllelse. Vurderinger og dokumentasjonen skal gjennomgås og godkjennes av en godkjent tredjepart. Kriteriene kan brukes på de ulike fasene i et anleggsprosjekt, fra planfase via prosjektering til utbygging separat, eller på prosjektet som helhet.*

Denne rapporten vil belyse fordeler og ulemper med en norsk automatisert produksjon sammenlignet med stål innkjøpt fra Europa eller Asia. Dette forutsetter at et prosjekt er vedtatt bygget og at miljøkonsekvenser av det er belyst tidligere.

Hvordan kan vi realisere et vedtatt prosjekt med minst mulige konsekvenser for miljø. Dette inkluderer stålbygging, transport og monteringsoperasjoner.

For å gi et bilde på miljøbelastning ved forskjellige byggemetoder kopierer vi inn en analyse som er gjort for bygging av Nerlandsøybrua. Den viser at en moderne byggemetode med bruk av materialer med gunstige CO<sub>2</sub> avtrykk er overlegen de metoder en sammenligner med.

Vår produksjon har halvparten av tilsvarende betongbru og en tredjedel av kinesisk bygd stålbru.

## 11.1 OPPSUMMERING MILJØ

Prodtex Industri AS skal være det mest miljøvennlige alternativet for produksjon av store stålkonstruksjoner. Virkemiddel for å nå dette målet er:

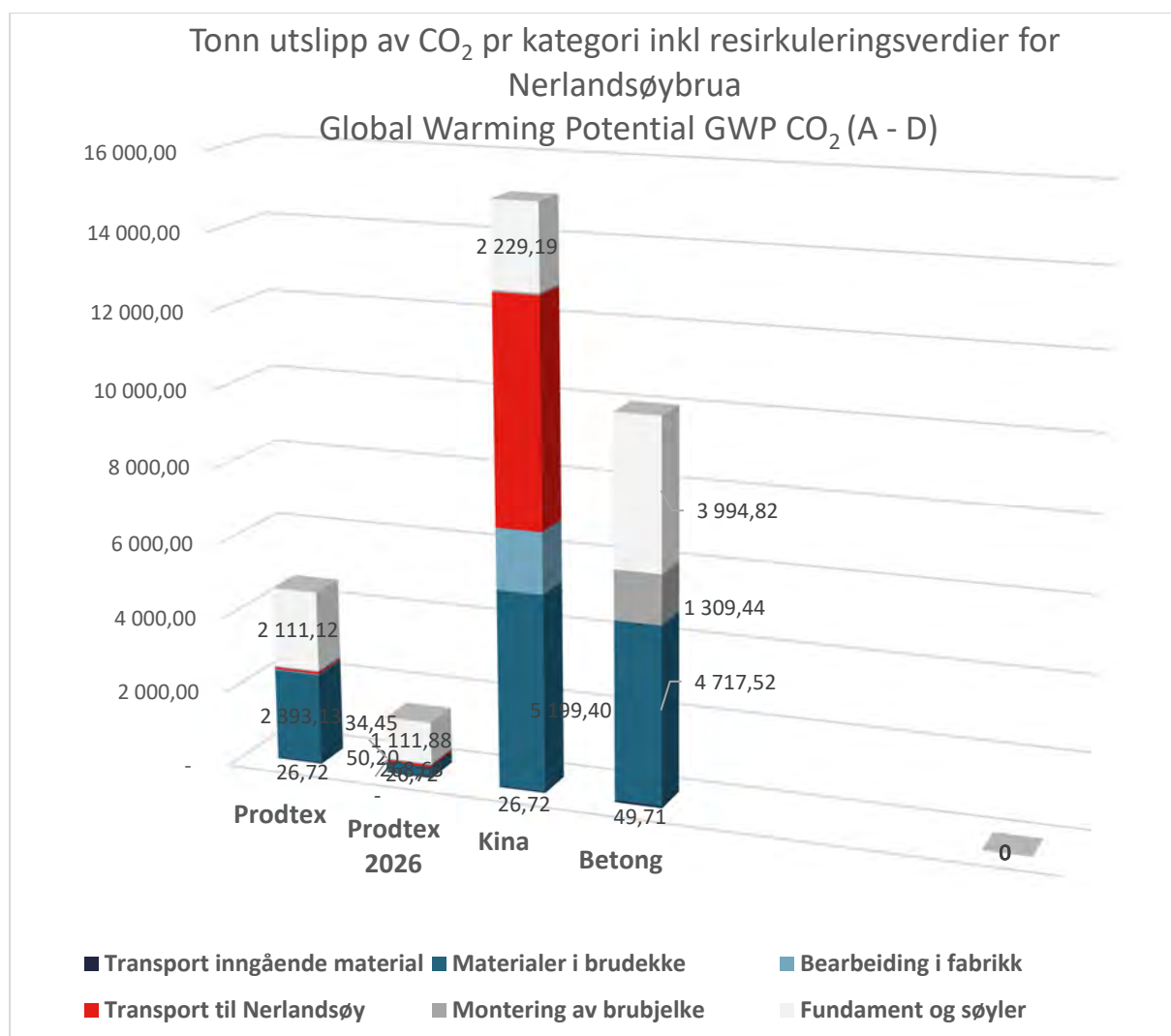
- Moderne teknologi som forbruker mindre energi
- Bruk av ren og fornybar energi
- Valg av de mest miljøvennlige innsatsmaterialer
- Kort avstand til markedet

Sammenlignet med konstruksjoner produsert i Asia og alternativ i betong er CO<sub>2</sub> avtrykket betydelig mindre. Alle de fire elementene over bidrar til denne konkurransekraften. Detaljer i sammenligning mot betong og Asiaproduksjon viser i Figur 21.

Som en ser av tabellen nedenfor, står CO<sub>2</sub> avtrykk av stål for mesteparten av avtrykket. Det er derfor viktig for Prodtex å ha nærhet til stålprodusenter som SSAB. Oppskriften på et miljøvennlig produkt er:

- Bruke de beste underleverandørene
- Nærhet i forsyningskjeden
- Moderne produksjonsutstyr og effektive produksjonsprosesser som i kombinasjon med godt design kan redusere bruk av materialer
- Tilgang til fossilfri energi
- Nærhet til markedet

Prodtex er god på alle punktene.



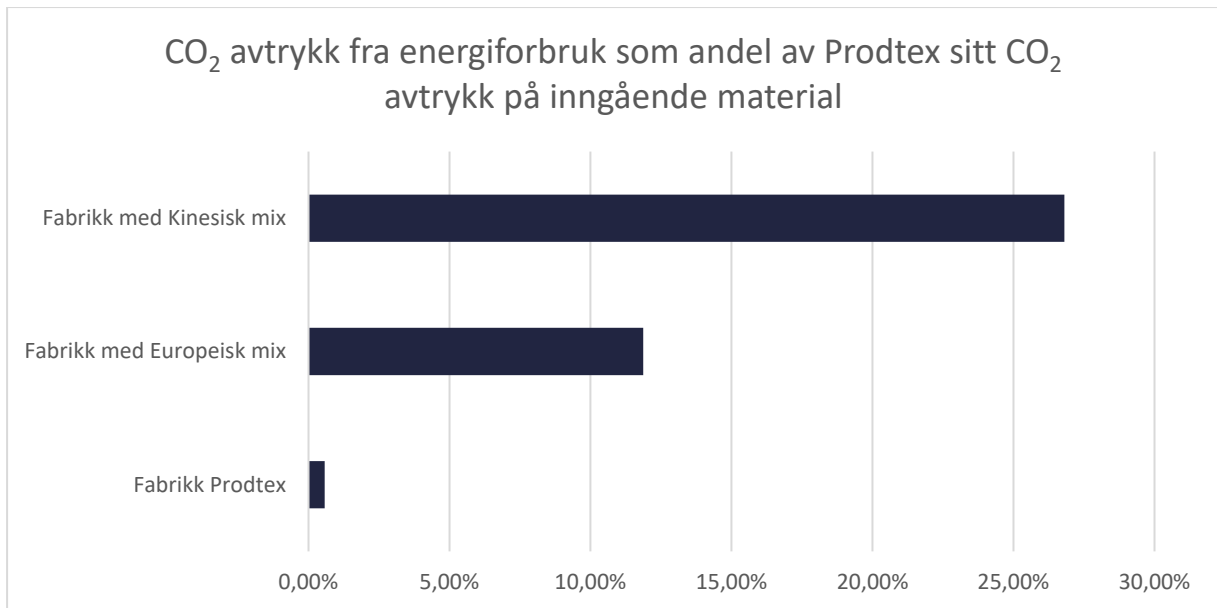
Co2 avtrykk for bru Nerlandsøy	Prodtek resirk	Prodtek	Prodtek 2026	Kina resirk	Kina	Betong Resirk	Betong
Transport inngående material	26,72	26,72	26,72	26,72	26,72	49,71	49,71
Materialer i brudekke	2 393,13	6 499,26	268,63	5 199,40	9 305,54	4 717,52	3 699,45
Bearbeiding i fabrikk	27,00	27,00	-	1 620,00	1 620,00	-	-
Transport til Nerlandsøy	50,20	50,20	50,20	5 953,65	5 953,65	-	-
Montering av brubjelke	34,45	34,45	34,45	48,61	48,61	1 309,44	1 309,44
Fundament og søyler	2 111,12	1 768,43	1 111,88	2 229,19	1 886,50	3 994,82	3 484,12
<b>Sum</b>	<b>4 642,61</b>	<b>8 406,05</b>	<b>1 491,87</b>	<b>15 077,57</b>	<b>18 841,01</b>	<b>10 071,49</b>	<b>8 542,72</b>

Figur 21 Utdrag fra miljørapport - ny bru til Nerlandsøy

Rapporten viser at vår produksjon har under 50% av belastningen til betongalternativ og 25% av belastningen til Asiaproduksjon når en tar med verdier for resirkulering.

NB! For at stål og betong skal kunne sammenlignes må resirkuleringsverdier vær hensyntatt. Dette fordi armeringsstål som i betongbru har nesten lik vekt med stålplater ikke får CO<sub>2</sub> belastning før ved resirkulering.

Mye av effekten i denne sammenligningen kommer fra material og transport. For å illustrere fabrikken sin betydning har vi satt opp tabellene i Figur 22 og Figur 23.



Figur 22 CO<sub>2</sub> avtrykk

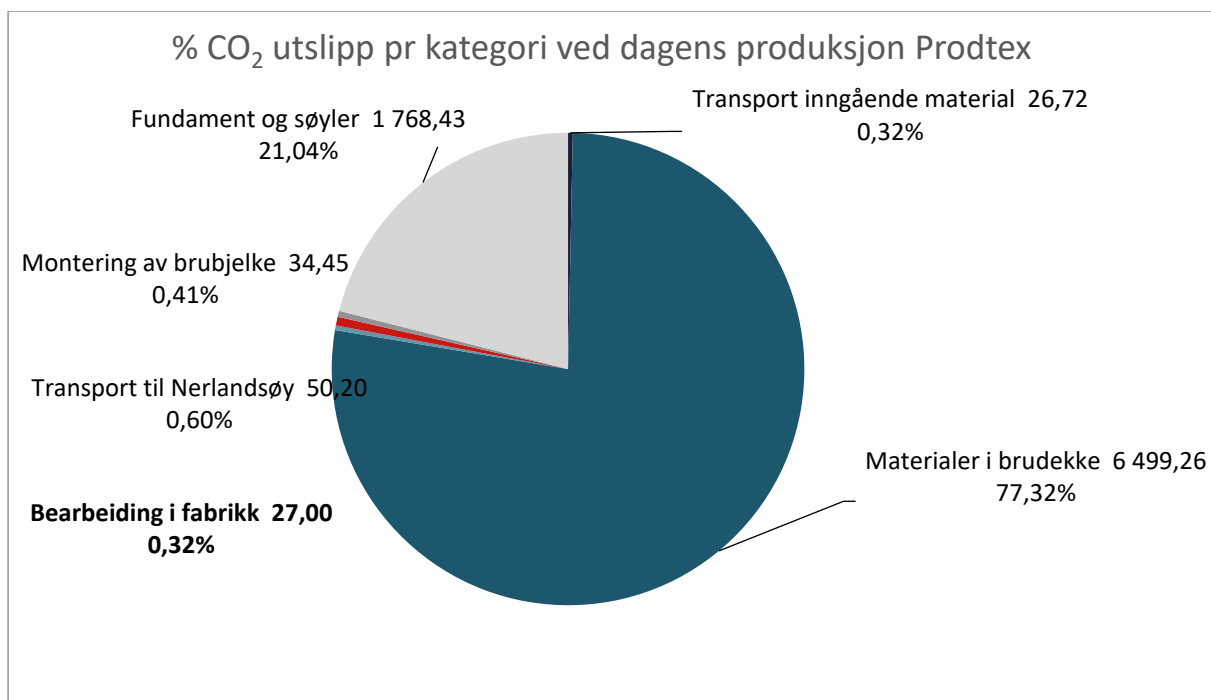
<i>Fabrikken sitt CO2 avtrykk i forhold til medgått material</i>			
	Prodtex	Manuell Europa	Manuell Kina
Årsforbruk KWh	900 000,00	1 800 000,00	1 800 000,00
Faktor	0,03		
Faktor Europa-mix		0,31	
Kina-mix			0,70
Utslipp pr år fabrikk sertifikat	27 000,00	-	-
Utslipp pr år Europa-mix	-	558 000,00	-
Utslipp pr år fabrikk Kina-mix	-	-	1 260 000,00
Årsproduksjon (ton)	2 000,00	2 000,00	2 000,00
Stålets sin CO <sub>2</sub> faktor	2 350,00	2 350,00	2 350,00
Utslipp pr år (kg)	4 700 000,00	4 700 000,00	4 700 000,00
Fabrikk sin andel Prodtex	0,57 %		
Fabrikk sin andel Europa-mix		11,87 %	
Fabrikk sin andel Kina-mix			26,81 %
NB! Fabrikken sin andel er basert på CO <sub>2</sub> avtrykk fra Prodtex sin stålleverandør. Kinesisk stål vil ha høyere verdi.			

Figur 23 CO2 avtrykk produksjon

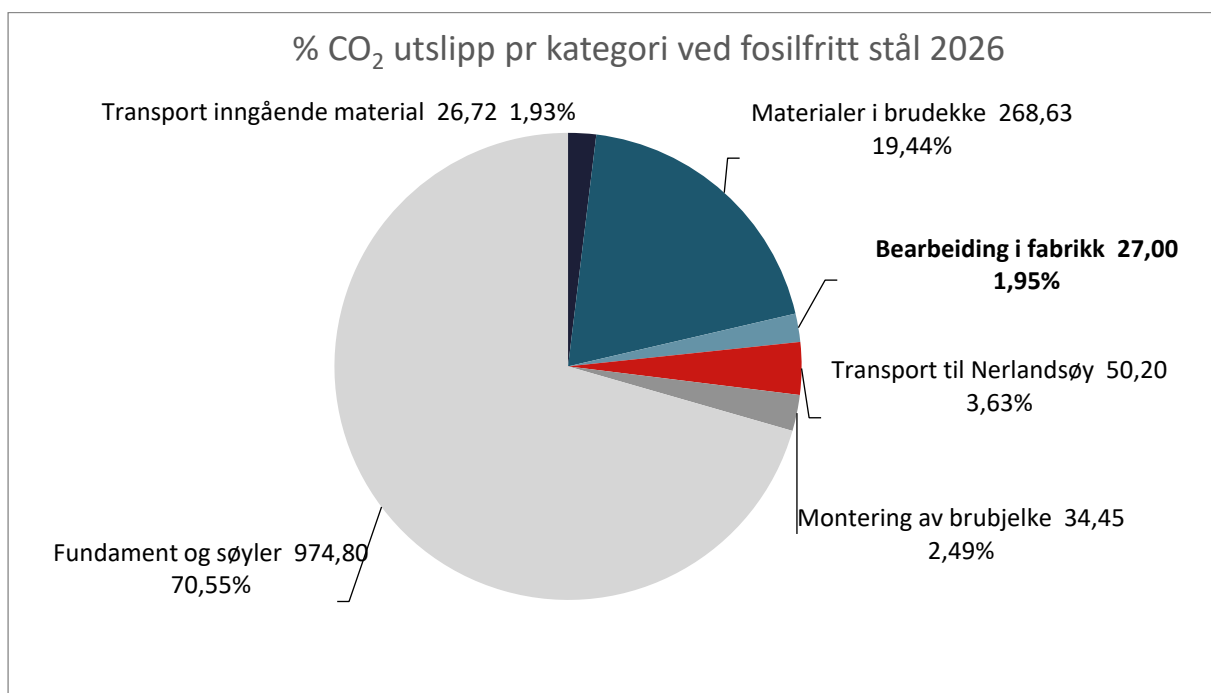
Illustrasjonen forutsetter at manuell fabrikk bruker dobbelt så mye energi på likt produksjonsvolum. Det er en veldig konservativ antagelse. Den manuelle fabrikk må smelte minst 5 ganger så mye material, slipe og varmrette samtidig som den vil trenge et betydelig større areal for å produsere samme mengde på grunn av lengre produksjonstid.

Når materialleverandørene lykkes med å redusere sitt miljøavtrykk og nærme seg en fossilfri produksjon vil fabrikkens sitt avtrykk og de andre små utslippene få større betydning. En kan derfor ikke ta vekk oppmerksomheten fra de element som i dag har en liten andel.





Figur 24 CO<sub>2</sub> utslipp på bru



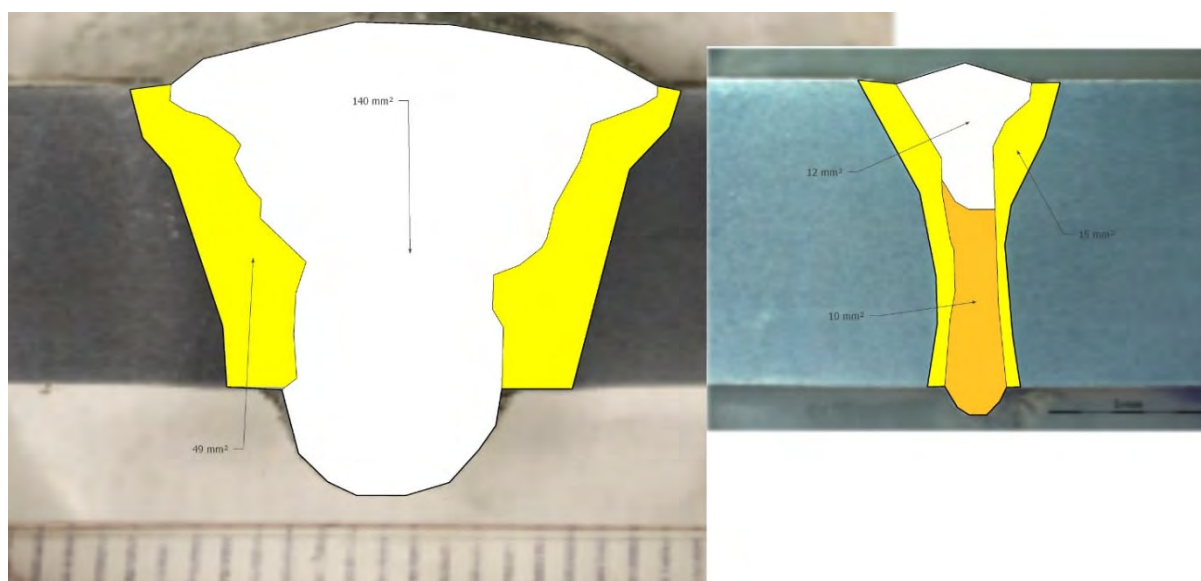
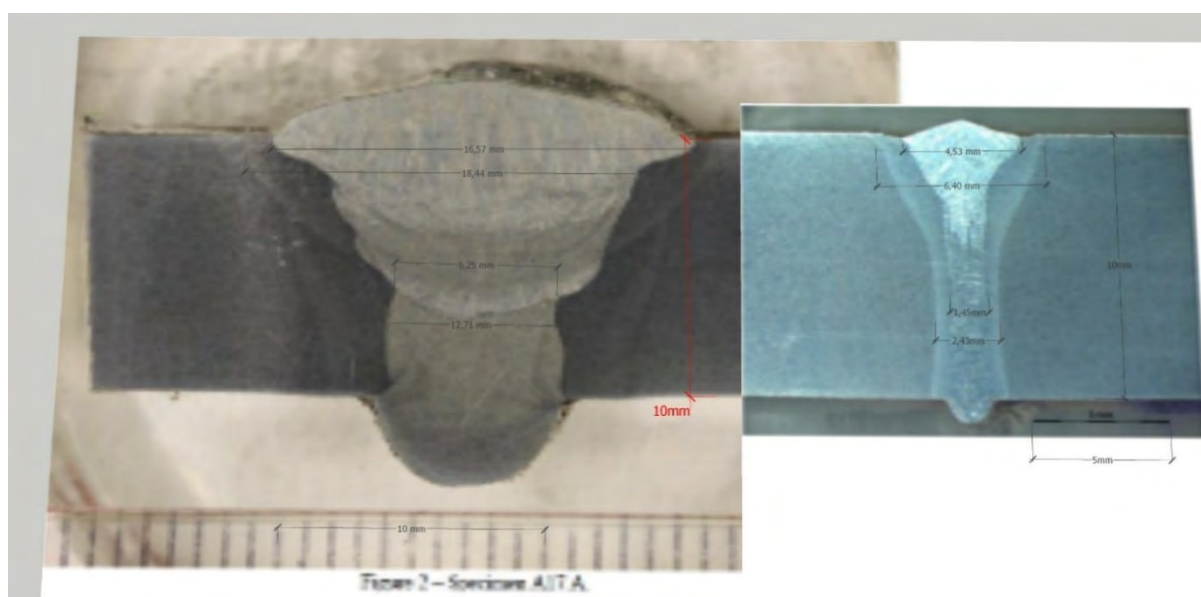
Figur 25 CO<sub>2</sub> utslipp på bru med fossilfritt stål

## 11.2 MODERNE TEKNOLOGI SOM FORBRUKER MINDRE ENERGI.

Bruk av robotisert montering og lasersveis er med på å øke gjennomstrømmingen i fabrikken betydelig. Det medfører at energibruk pr produsert enhet blir redusert fordi en stor del av energibruken ikke varierer med produksjonsmengde. Vi kan nevne element som.:

- Oppvarming av verkstedhaller og kontorer.
- Lys
- Ventilasjon
- Produksjon av trykkluft og gass (lekkasjer og svinn er ofte uavhengig av volum).

Lasersveis er en presis produksjonsprosess som reduserer varmepåvirkningen som trengs for å smelte materialer. Prosessen medfører også en betydelig reduksjon i behovet for sliping av sveiser og varmretting av konstruksjonen etter sveising.



Figur 26 Manuell og lasersveis av 10mm plate sveist butt i butt

En vanlig skjøt av 10mm plate krever 3 sveistråder og gir et oppvarma areal som er nær 10 ganger større enn laserhybrid sveis. I tillegg er bruken av sveistråd 12 ganger større for manuell sveis. Sveistråd har større miljøavtrykk pr kilo enn stålplatene. Til tross for at vår produksjonsmetode gir nesten en dobling i antall meter sveis, er energibruken i prosessen mindre enn 20% av manuell prosess.

Moderne produksjon med lasersveis medfører også at antall sveise apparater rundt om i hallen blir sterkt redusert. Apparatene forbraker ofte energi også når en ikke sveiser, men har påslått apparat.



*Figur 27 Laser Hybrid sveis med full gjennombrenning*

Behov for å slippe sveis er ved laser nesten redusert til null. I prosjektet er slip av sveis kun brukt der en har feil i sveisen. Ved ordinær produksjonsmetode er slipemaskiner en betydelig bruker av energi.



*Figur 28 Dekksflate sveist med laser uten etterbehandling med varme*

Behovet for varmretting av produserte enheter er fraværende ved vår produksjonsmetode. Konstruksjonen har svært høy standard på presisjon uten bruk av varmretting. Slik varmretting krever normalt et høyt energiforbruk, enten til induksjonsvarme eller ved varming med gass.

### 11.3 BRUK AV REN, FORNYBAR ENERGI.

Prodtex AS og Prodtex Industri AS har innkjøpsavtale på strøm med Tussa. Dette er en avtale som sikrer at den energien som blir levert er basert på fornybar vannkraft.

Sertifikat for ren og fornybar strøm fra vannkraft betyr at vi i anbud får bruke 0,03 kilo CO<sub>2</sub> pr kilowatt time som er forbrukt. Uten sertifikat må det brukes faktor på 0,31. Ingen industri regioner i Kina som ligger ved kysten har verdier på under 0,6.



Figur 29 Miljøsertifikat



## 11.4 VALG AV MILJØVENNLIGE INNSATSMATERIALER

Prodtex Industri AS sin viktigste innsatsfaktor er stålplater. CO<sub>2</sub> avtrykket på platene er avhengig av mange faktorer som.:

- Hvor kommer malmen fra og hvor effektiv er prosessen i gruve
- Hvor stor andel er gjenbruk av skrap
- Hvilken prosess blir brukt
- Hvilken type energi blir brukt i prosessen

Prodtex Industri har i pilotprosjektet brukt material fra SSAB. Materialet har en lavere CO<sub>2</sub> avtrykk enn gjennomsnittet for denne type material og SSAB jobber aktivt for å redusere ytterligere. I 2026 vil de kunne levere ut i markedet 1 mill. tonn med material som er fossilfritt. I 2045 skal alt materiale være fossilfritt.

Andersen, N. B., 2021. *Shear testing by compression 21NO-00493OR01*, s.l.: KIWA.

## 11.5 KORT AVSTAND TIL MARKEDET

I figuren som sammenligner CO<sub>2</sub> avtrykk for Nerlandsøy viser at transport fra Kina har et CO<sub>2</sub> avtrykk som er større enn Prodtex Industri sitt totale avtrykk når resirkulering er inkludert.

For å frakte 560 meter med brukonstruksjon er følgende data brukt.

- Fart: 12 knop
- Ytelse: 6000 kW (snitt for last og tom retur)
- Tidsbruk: 1875 timer (ikke hensyntatt ventetider)
- Distanse: 22500 nautiske mil tur retur
- Drivstoff forbruk: 1920 tonn – 200 gram pr kw/h
- CO<sub>2</sub> utslipp: 5928 tonn – 3,1 kg CO<sub>2</sub> pr liter

Det er svært lite sannsynlig at avtrykket fra transport over så lange distanser vil bli vesentlig redusert i de næreste årtier.

Kortreist produksjon er derfor en av de viktigste miljøtiltak. Det betyr også at dersom Prodtex Industri AS vil eksportere til Asia, Australia, Amerika eller Afrika så bør det skje ved etablering av lokal produksjon. Slik produksjonskapasitet kan være kopi av eksisterende fabrikk og styrt og programmert fra Prodtex Industri AS.

## 12 VEDLEGG

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- [1] 20021\_WeldingTable.xlsx
- [2] 20021\_Welding plan.pdf
- [3] 20021\_Inspection and test plan.pdf
- [4] Sveiselogg
- [5] NDT-Rapporter
- [6] WPQR/WPS
- [7] Installasjon Sarens.pdf
- [8] DNV rapport (Navn på rapport må legges til når DNV leverer rapport)
- [9] Norconsult rapport (Navn på rapport må legges til når Norconsult leverer rapport)



## 13 REFERANSER

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Andersen, N. B., 2021. *Shear testing by compression 21NO-00493OR01*, s.l.: KIWA.

# 20021 – Elverhøy Bru

## WELDING PLAN



Revision	Comment	Date	Resp.
0	-	01.03.22	ÖBB
1			
2			
3			
4			



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## REFERENCES

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### STANDARDS

- NS-EN 1090-1:2009 Execution of steel structures and aluminum structures - Part 1 Requirements for conformity assessment off structural components
- NS-EN 1090-2:2018 Execution of steel structures and aluminum structures - Part 2: Technical requirements for steel structures
- NS-EN ISO 3834-2 Quality requirements for fusion welding of metallic materials – Part 2: Comprehensive quality requirements
- NS-EN ISO 5817 Welding-Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) Quality levels for imperfections

### EXTERNAL DOCUMENTS

- Håndbok R762 Prosesskode 2: Standard beskrivelse for bruer og kaier (2018)

### INTERNAL DOCUMENTS

- 20021\_Welding Table
- 20021\_Inspection and test plan
- [KC04 Sveising](#) process descriptions

## 1 INTRODUCTION

---

This document (*20021\_Welding plan*), together with the document *20021\_Welding Table*, describes the planned welding activities for the project 20021 Elverhøy Bru, based on the required information as per NS-EN 1090-2 pkt. 7.2.

In addition, the following documents should be used together with:

- 20021\_Inspection and test plan

## 2 WELDING PROCEDURE SPECIFICATIONS

---

The welding coordinator is taking care of the existence of all the necessary procedures to cover all types of welds used and their availability. The welding procedure is a record that describes the joining by fusion of two pieces of metal materials, at very high temperatures.

For the Elverhøy project, the welding will be done in two ways: with or without the use of filler material.

The following welding processes shall be used:

- with electric arc
- hybrid
- laser

The WPS and WPQR are available in production for foremen and welders and can be found in:

Prodtex AB\Industri Fiskå -Documents\Prosedyrer\Sveiseprosedyrer\Godkjente prosedyrer

## 3 EXECUTION OF WELDING

---

In general, all welding in the project shall be performed according to the company process descriptions and welding procedures – [KC04 Sveising](#)

Essential lines for welding execution:

-Before welding, increased attention will be paid by the welding coordinator, foreman, operator for welding joint preparation, alignment, and connection angle.

-During welding, the correct welding order should be followed and the welding parameters according to the right WPS.

-After welding, all the welds are 100% visually checked.

The welding table to be used for weld details and description for each stage of Elverhøy bru production.

The document *20021\_Welding Table* describes the necessary details for each weld:

- Welding sequence
- WPS for each weld
- Weld Inspection Class (WIC) for each weld

## 4 EFFORTS TO AVOID DEFORMATION

---

In general, the following efforts shall be made to avoid deformation:

- heating the material as low as possible by using welding processes with concentrated heating, high-speed welding, making the size of the welds as small as possible (according to the welding table).
- intermittent welding - if it is provided in the execution drawings
- preheating the parts before welding reduces the temperature difference between the part and the weld which reduces deformation
- proper positioning of the elements, so that by deformation they are brought to the desired position
- choosing an appropriate welding order
- welding seams with a length of less than 400 mm are welded from one end to the other
- when welding in several layers, the successive layers are welded in opposite directions, so that the end of the seams does not overlap
- when welding on both sides, the rows must be placed alternately on the 2 sides, so that the stresses and as such the deformations are balanced as much as possible
- welding a section is done from the middle of the section to the extremities
- for manually welding, WPS and working instructions must be followed for each case separate

## 5 CLAMPING AND TURNING OF COMPONENTS

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The components shall be clamped during welding, to ensure correct placement and reduce weld deformations.

According to planned production flow we know how and when the components shall be turned to accommodate the planned welding sequence.

## 6 INSPECTION AND TEST DURING PRODUCTION

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NB! It is necessary to perform inspection and testing during production. Please refer to the document “20021 Elverhøy bru\_Inspection and test plan” for details.

## 7 EFFORTS TO AVOID DELAMINATION

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Delamination cracks occur due to the lack of elasticity of the material in the direction of thickness. It is produced by breaking segregation zones arranged in parallel, containing elongated non-metallic inclusions, in case of mechanical stresses on Z direction.

To avoid the tendency towards lamellar tearing:

- Proper choice of base material (chemical composition, mechanical properties, etc.).
- The constructive conception of the product so that the unitary effort at which the tearing occurs is as small as possible.
- Technological measures aimed at reducing the own tensions on the Z direction (choosing appropriate shapes of the joints, a certain order of laying the welding seams).



## 8 EFFORTS TO CONTROL HEAT INPUT TO AVOID LOCAL HARDNESS IN SMALL WELD SEAMS

Heat input is the amount of electrical energy supplied by a welding arc to a workpiece. It occurs as a result of structural changes due to volume changes that lead to mechanical stresses.

The following formula will be used as a general guide to calculate welding heat input:

$$Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$$

However, when welding materials that are susceptible to cracking, adequate heat input is crucial given the potential impact it can have on cooling rates. Cooling rates that are too fast can cause embrittlement in the heat-affected zone.

When we want to ensure that we're using the correct heat input, the best way is to perform a test weld and evaluate the results. The value is recorded in WPQR.

## 9 ACCEPTANCE CRITERIA

### 9.1 ROUTINE REQUIREMENTS

EXECUTION CLASS	QUALITY LEVEL
EXC3*	B** (ref. NS-EN ISO 5817:2014)
* Ref. Håndbok R762 Prosesskode 2: Standard beskrivelse for bruer og kaier (2018), pkt. 85 c) ** Ref. NS-EN 1090-2 pkt. 7.6.1	

All the welds are subject to 100% VT

### 9.2 SPECIAL REQUIREMENTS FOR WELDS SUBJECT TO FATIGUE

Ref. 1090-2 par. 7.6.2

(REF. NS-EN ISO 5817 Annex C: Additional requirements for welds in steel subject to fatigue)

The additional requirements for quality level B are to adjust the limits for imperfections to the fatigue class FAT 90 giving B90 as quality level.

Welding control classes describe the scope of the test - Quality level describes how strict the requirements are to pass the test.

For each type of weld, the control class is mentioned in the 20021\_Welding Table.

## 10 TRACEABILITY OF WELDS

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The description of how it is planned to manage traceability:










- Traceability record with unique ID where the welding coordinator notes down data for each weld
- Drawings where each weld is marked with a unique ID
- Marking of components in production

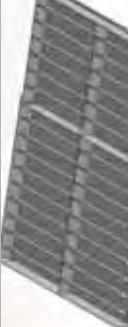
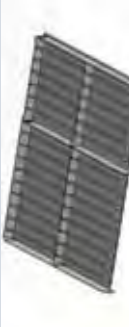
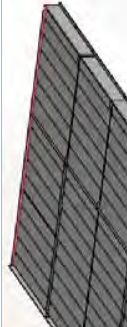
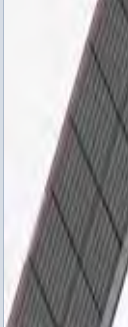



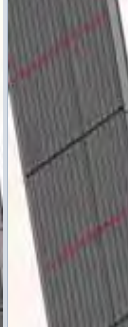

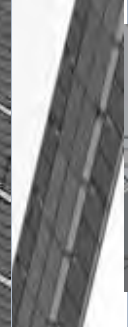
The traceability template records are:

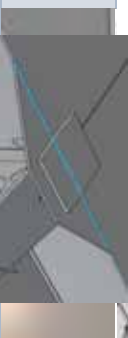




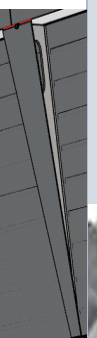

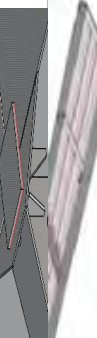






-KC04.04\_M01 Mal - Skjema for sporbarheit av sveis











[-KC04.05 M05 Mal - Skjema for stikkprøvebasert kontroll av sveisearbeid](#)

Ref. Production drawings.






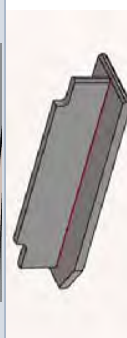



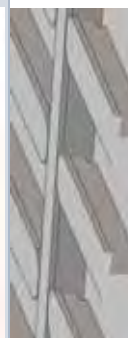
SVÆSNR. [W]	TYPE	ROBOT	SVEIS	P1	P2	TYKKELSE P1 [mm]	TYKKELSE P2 [mm]	RETNING	A-MÅL [mm]	INNBRENNING (TYPE)	INNBRENNING [mm]	FUGE	FUGEBSKRIVELSE	BESKRIVELSE	TILLEGGS- INFORMASJON	WPS	W/C	OMRÅDEJ BRUKASSE	STED FOR UTFØRELSE	BILDE	
1	LH	Ja	Butt	Topplate	Topplate	16	16	Horizontal	-	Full innbrenning	16	Ja	Y, 30grader, N=6mm	Ensidig sveis	033-LH-BW-16	5		Sandwich	Fabrikk		
1A	LH	Ja	Butt	Topplate	Topplate	16	16	Horizontal	-	Full innbrenning	16	Ja	Y, 30grader, N=6mm	Ensidig sveis	033-LH-BW-16	5		Sandwich	Fabrikk		
2	MIG	Nei	Butt	Topplate	Topplate	16	16	Horizontal	-	Full innbrenning	16	Ja	V, 30grader	Ensidig sveis	0221-R-BW	5		Sandwich	Montasje- sted		
3	MIG	Ja	Butt	Topplate	Endeplate	16	20	Horizontal	-	Full innbrenning	16	Ja	Halv V, 30grader	Ensidig sveis	0221-R-BW	5		Sandwich	Fabrikk		
4	LH	Ja	Kliveseis	Topplate	Sideplate	16	16	Horizontal	-	Delvis innbrenning	12	Nei		Tosidig sveis	034-LH-T16	5		Sandwich	Fabrikk		
5	MIG	Ja	Kliveseis	Topplate	Sideplate	16	16	Horizontal	4	-	12	Nei		Tosidig sveis	150mm mot hver tverrblekke	0231-R-TW	5		Sandwich	Fabrikk	
6	LH	Ja	Kliveseis	Topplate	Langsgående Silver	16	8	Horizontal	-	Delvis innbrenning	7	Nei		Ensidig sveis		021-LH-T16	5		Sandwich	Fabrikk	
7	MIG	Ja	Kliveseis	Topplate	Langsgående Silver	16	8	Horizontal	5	-			Tosidig sveis	150mm mot hver tverrblekke. Avventer Armal	0231-R-TW	5		Sandwich	Fabrikk		
8	MIG	Ja	Kliveseis	Topplate	Tverrblekke (Sandwich)	16	30	Horizontal	5	Delvis innbrenning	20	Ja	K, 30grader	Tosidig sveis	0231-R-TW	3		Sandwich	Fabrikk		


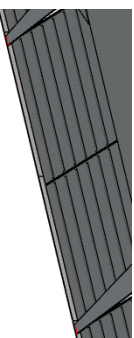








9	MIG	Ja	Klsveld	Topplate	Tverrsteig (Sandwich)	16	16	16	Horizontal	-	Delvis innbrenning	12	Ja	K, 30grader	Tosidlig sveis	0231-R-TW	3	Sandwich	Fabrikk		
10	LH	Ja	Klsveld	Topplate	Langsgående Stegsilver	16	20	20	Horizontal	-	Delvis innbrenning	16	Nei	-	Tosidlig sveis	035-LH-T162	5	Sandwich	Fabrikk		
11	MIG	Ja	Klsveld	Bunnplate	Endeplate	8	20	20	Horizontal	-	Delvis innbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	Gjelder også vakse, lag egen sveis	0231-R-TW	3	Sandwich	Fabrikk	
12	MIG	Ja	Klsveld	Bunnplate	Sideplate	8	16	16	Horizontal	-	Full innbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0231-R-TW	2	Sandwich	Fabrikk		
13	LASER	Ja	Lap	Bunnplate	Langsgående Silver	8	8	8	Horizontal	1,5	Delvis innbrenning	2	Nei	-	Ensidig sveis	011-LJW8	2	Sandwich	Fabrikk		
14	MIG	Ja	Klsveld	Bunnplate	Langsgående Stegsilver	8	20	20	Horizontal	-	Full innbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0231-R-TW	2	Sandwich	Fabrikk		
15	MIG	Ja	Klsveld	Bunnplate	Tverrblekke (Sandwich)	8	30	30	Horizontal	-	Full innbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	Se sveis mot endeplate	0231-R-TW	3	Sandwich	Fabrikk	
16	MIG	Ja	Klsveld	Bunnplate	Tverrsteig (Sandwich)	8	16	16	Horizontal	-	Full innbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0231-R-TW	3	Sandwich	Fabrikk		
17	MIG	Nei	Other	Bunnplate	Langsgående Silver	8	8	8	Horizontal	-	-	-	Nei	-	Ensidig sveis	Slisser, L100x810x18	2	Sandwich	Montasje-sted		
18	MIG	Ja	Butt	Bunnflens	Bunnflens	30	30	30	Horizontal	-	Full innbrenning	30	Ja	X, 30grader	Tosidlig sveis	0221-R-BW	5	Bjelke	Fabrikk		











19	MIG	Ja	Butt	Bunniflens	Bunniflens (Lagerbrakett)	30	30	Horizontal	-	Full innbrenning	31	Ja	Halv V, 40grader	Ensidig sveis	0221-R-BW	3	Bjelke	Fabrikk	
20	MIG	Ja	Kliveseis	Bunniflens	Langsgående Stegsiver	30	20	Horizontal	7	-	-	Nei	-	Tosidig sveis	0231-R-TW	2	Bjelke	Fabrikk	
<p><b>Obs! :</b> Over hvert lager, 3,2 meter i hver retning skal det sveises med full innbrenning. (Tilpass fuge, K 10/10, 40grader)</p>																			
21	MIG	Ja	Kliveseis	Bunniflens	Langsgående Stegsiver C	30	20	Horizontal	5	Delvis innbrenning	25	Ja	K, 10/15mm, 40grader, N=5mm	Tosidig sveis	0231-R-TW	2	Bjelke	Fabrikk	
22	MIG	Ja	Kliveseis	Bunniflens	Tverrsteg Lager	30	30	Horizontal	3	Full innbrenning	30	Ja	K, 15mm, 40grader	Tosidig sveis	0231-R-TW	5	Bjelke	Fabrikk	
23	MIG	Ja	Kliveseis	Bunniflens	Tverranne Horizontalslag	30	30	Horizontal	7	-	-	Nei	-	Tosidig sveis	0231-R-TW	3	Bjelke	Fabrikk	
24	MIG	Nei	Butt	Bunniflens	Tverrbjelke Flens	30	30	Horizontal	-	Full innbrenning	30	Ja	Halv V, 40grader	Ensidig sveis	0261-M- BWT1040	3	Bjelke	Fabrikk	
25	MIG	Ja	Butt	Bunniflens	Endeplate	30	20	Horizontal	-	Delvis innbrenning	25	Ja	K, 10/15mm, 40grader, N=5mm	Tosidig sveis	0221-R-BW	5	Bjelke	Montasje- sted	
26				Bunniflens	Lager-fundament	30	40	Horizontal	5					Ensidig sveis	0272-M TW340		Bjelke	Montasje- sted 7	
<p>Helge og Anna tar en dobbeltsjekk. Sveises helt rundt.</p>																			
27	MIG	Ja	Kliveseis	Bunniflens	Bjelke Langsgående Profil	30	30	Horizontal	7	-	-	Nei	-	Tosidig sveis	0231-R-TW	2	Bjelke	Fabrikk	
28	MIG	Ja	Butt	Tverrbjelke (Sandwich)	Tverrbjelke (Bjelke)	30	30	Side inn	-	Full innbrenning	30	Ja	X, 40grader	Tosidig sveis	0221-R-BW	3	Sammenstilling Bjelke & Sandwich	Fabrikk	
29	MIG	Ja	Butt	Tverrbjelke (Sandwich)	Tverskott (Akse/Lager)	30	30	Side inn	-	Full innbrenning	30	Ja	X, 40grader	Tosidig sveis	0221-R-BW	4	Sammenstilling Bjelke & Sandwich	Fabrikk	
30	MIG	Ja	Kliveseis	Tverrbjelke (Sandwich)	Sideplate	30	16	Vertikal	3	Delvis innbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	3	Sandwich	Fabrikk	
31	MIG	Ja	Kliveseis	Tverrbjelke (Sandwich)	Langsgående Siver	30	8	Vertikal	4	Full innbrenning	8	Ja	Halv V, 30grader	Tosidig sveis	0232-R-TW	3	Sandwich	Fabrikk	
32	MIG	Ja	Kliveseis	Tverrbjelke (Sandwich)	Langsgående Stegsiver	30	20	Vertikal	3	Full innbrenning	30	Ja	K, 40grader	Tosidig sveis	0231-R-TW	4	Sandwich	Fabrikk	










33	MIG	Nei	Butt	Tverrbjelke (Sandwich)	Tverranne Vertikal Steg	30	30	Side inn	-	Full innbrenning	30	Ja	X, 40grader	Tosidig sveis	0231-M-BW1040	3	Sammensilling Bjelke & Sandwich	Fabrikk	
34	MIG	Ja	Klveis	Tverrbjelke (Bjelke)	Langsgående Stegstiver	30	20	Vertikal	3	Delvis innbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	4	Bjelke	Fabrikk	
35	MIG	Nei	Klveis	Tverrbjelke (Bjelke)	Langsgående Stegstiver	30	20	Vertikal	3	Delvis innbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	4	Bjelke	Montasje-sted	
36	MIG	Ja	Klveis	Tverrbjelke (Bjelke)	Tverrbjelke Flens (Bjelke)	30	30	Horisontal	3	Delvis innbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	2	Prefab Bjelke	Fabrikk	
37	MIG	Ja	Klveis	Tverrbjelke (Bjelke)	Sideplate	30	16	Vertikal	7	-	-	Nei	-	Tosidig sveis	0231-R-TW	3	Sammensilling Bjelke & Sandwich	Fabrikk	
38	MIG	Ja	Klveis	Tverrsteg (Sandwich)	Sideplate	16	16	Vertikal	3	Delvis innbrenning	10	Ja	K, 30grader, N=6mm	Tosidig sveis	0231-R-TW	3	Sandwich	Fabrikk	
39	MIG	Ja	Klveis	Tverrsteg (Sandwich)	Langsgående Stegstiver	16	20	Vertikal	3	Full innbrenning	20	Ja	K, 30grader	Tosidig sveis	0231-R-TW	3	Sandwich	Fabrikk	
40	MIG	Nei	Butt	Tverrsteg (Sandwich)	Tverranne Vertikal Steg	16	30	Side inn	-	Full innbrenning	16	Ja	X, 30grader	Tosidig sveis	0231-M-BW1040	3	Sandwich	Fabrikk	
41	MIG	Ja	Butt	Langsgående Stegstiver	Langsgående Stegstiver	20	20	Side inn	-	Full innbrenning	20	Ja	V, 30grader	Ensidig sveis	0221-R-BW	3	Sammensilling Bjelke & Sandwich	Fabrikk	
42	MIG	Ja	Butt	Langsgående Stegstiver	Langsgående Stegstiver	20	20	Vertikal	-	Full innbrenning	20	Ja	V, 30grader	Ensidig sveis	0221-R-BW	5	Sandwich & Bjelke	Fabrikk	



43	MIG	Ja	Klisseis	Langsgående Stegstiver	Tverramme Vertikalt Steg	20	30	Horisontal	7	-	-	Nei	-	Tosidig sveis	0231-R-TW	3	Bjelke	Fabrikk	
44	MIG	Nei	Klisseis	Langsgående Stegstiver	Tverramme horisontalt Steg	20	30	Vertikal	7	-	-	Nei	-	Tosidig sveis	0231-R-TW	3	Bjelke	Fabrikk & Montasje-sted	
45	MIG	Nei	Klisseis	Langsgående Stegstiver	Tverramme Flens	20	30	Horisontal	7	-	-	Nei	-	Tosidig sveis	0271-M TW340	3	Bjelke	Fabrikk & Montasje-sted	
46	MIG	Nei	Klisseis	Langsgående Stegstiver	Endeplate	20	20	Vertikal	4	Full imbrenning	20	Ja	Halv V, 30grader	Ensidig sveis	0271-M TW340	4	Sandwich & Bjelke	Montasje-sted	
47	MIG	Nei	Klisseis	Langsgående Stegstiver	Brakett lager	20	30	Vertikal	-	Full imbrenning	30	Ja	Halv V-fuge, 40 deg	Ensidig sveis	0271-M TW340	5	Bjelke	Fabrikk	
48	MIG	Ja	Klisseis	Tverramme Flens	Tverramme Vertikalt Steg	30	30	Horisontal	4	Delvis imbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	2	Prefab Bjelke	Fabrikk	
49	MIG	Ja	Klisseis	Tverramme Flens	Tverramme Horisontalt Steg	30	30	Horisontal	4	Delvis imbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	3	Prefab Bjelke	Fabrikk	
50	MIG	Nei	Klisseis	Tverramme Flens/Steg	Tverramme Flens	30	30	Horisontal	4	Delvis imbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0271-M TW340	3	Bjelke	Fabrikk	
51	MIG	Ja	Klisseis	Bjelke Langsgående Steg	Bjelke Langsgående Flens	30	30	Horisontal	4	Delvis imbrenning	20	Nei	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	2	Prefab Bjelke	Fabrikk	
52	MIG	Ja	Klisseis	Bjelke Langsgående Profil	Tverramme Steg	30	30	Vertikal	4	Delvis imbrenning	20	Ja	K, 40grader, N=10mm	Tosidig sveis	0231-R-TW	3	Bjelke	Fabrikk	

53	MIG	Nei	Butt	Bjelke Langsgående Tverramme Flens Flens	30	30	Horizontal	-	Delvis imbrenning	25	Ja	Halv V, 40grader, N=5mm	Ensidig sveis	0261-M- BW1040	3	Bjelke	Fabrikk	
54	MIG	Nei	Butt	Sideplate	16	30	Horizontal	-	Delvis imbrenning	25	Ja	Halv V, 40grader, N=5mm	Ensidig sveis	0261-M- BW1040	3	Sammenslåing Bjelke & Sandwich	Fabrikk	
55	MIG	Ja	Butt	Sideplate	16	16	Vertikal	-	Delvis imbrenning	14	Ja	V, 30grader, N=2mm	Ensidig sveis	0221-R-BW	5	Sandwich	Fabrikk	
56	MIG	Nei	Butt	Sideplate	16	20	Vertikal	-	Delvis imbrenning	14	Ja	V, 30grader, N=2mm	Ensidig sveis	0261-M- BW1040	5	Sandwich	Fabrikk	
57	MIG	Ja	Kilsvets	Tverrsteg (Sandwich)	16	8	Vertikal	4	Full imbrenning	8	Ja	Halv V, 30grader	Tosidig sveis	0231-R-TW	3	Sandwich	Fabrikk	
58	MIG	Nei	Kilsvets	Tverrbjelke (Sandwich)	30	8	Vertikal	-	Full imbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0231-R-TW	3	Sandwich	Montasje- sted	
59	MIG	Nei	Butt	Bunnplate	8	30	Horizontal	-	Full imbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0271-M- TW340	3	Sandwich	Montasje- sted	
60	MIG	Nei	Butt	Bunnplate	8	8	Horizontal	-	Full imbrenning	8	Ja	V, 30grader	Ensidig sveis	0151-M-BW	5	Sandwich	Montasje- sted	
61	MIG	Nei	Butt	Bunnplate	8	20	Horizontal	-	Full imbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0151-M-BW	2	Sandwich	Montasje- sted	
62	MIG	Nei	Butt	Bunnplate	8	16	Horizontal	-	Full imbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0151-M-BW	2	Sandwich	Montasje- sted	

63	MIG	Nei	Butt	Langsgående Stegstiver	Langsgående Stegstiver	20	20	20	Vertikal	-	Full innbrenning	20	Ja	V, 30grader	Ensidig sveis	0261-M-BW1040	5	Sandwich & Bjelke	Montasje- sted		
64	MIG	Nei	Butt	Sideplate	Sideplate	16	16	16	Vertikal	-	Delvis innbrenning	14	Ja	V, 30grader, N=2mm	Ensidig sveis	0261-M-BW1040	5	Sandwich	Montasje- sted		
65	MIG	Nei	Klsveld	Langsgående Stegstiver	Tverramme Vertikal Stieg	20	30	30	Vertikal	7	-	-	Nei	-	Tosidig sveis	0271-M-TW340	3	Bjelke	Montasje- sted		
66	MIG	Ja	Klsveld	Tverrstieg (Sandwich & Bjelke)	Langsgående Stegstiver	30	20	30	Vertikal	3	Full innbrenning	30	Ja	K, 40grader	Tosidig sveis	0271-M-TW340	5	Sandwich & Bjelke	Montasje- sted		
67	MIG	Ja	Klsveld	Tverrstieg (Sandwich)	Langsgående Stegstiver	16	20	30	Vertikal	3	Full innbrenning	30	Ja	K, 40grader	Tosidig sveis	0271-M-TW340	5	Sandwich & Bjelke	Montasje- sted		
68	MIG	Nei	Klsveld	Bunnflens	Langsgående Stegstiver C	30	20	25	Horizontal	5	Delvis innbrenning	25	Ja	K, 10/15mm, 40grader, N=5mm	Tosidig sveis	0231-R-TW	2	Bjelke	Montasje- sted		
69	MIG	Nei	Butt	Bunnflens	Bunnflens	30	30	30	Horizontal	-	Full innbrenning	30	Ja	X, 30grader	Tosidig sveis	0261-M-BW1040	5	Bjelke	Montasje- sted		
70	MIG	Nei	Butt	Langsgående Stegstiver	Langsgående Stegstiver	20	20	20	Side Inn	-	Full innbrenning	20	Ja	V, 30grader	Ensidig sveis	0151-M-BW	5	Sammensetting Bjelke & Sandwich	Montasje- sted		
71	MIG	Ja	Klsveld	Bunnflens	Tverrstieg	30	30	20	Horizontal	4	Full innbrenning	20	Ja	K, 40 grader	Tosidig sveis	Husk å fuge iver skott	0231-R-TW	5	Bjelke	Fabrikk	
72	MIG	Nei	Butt	Langsgående Bjelke Flens	Flens Mannull	30	20	20	Horizontal	-	Full innbrenning	20	Ja	Halv V, 40 grader	Ensidig sveis	0271-M-TW340	3	Bjelke	Fabrikk		

73	MIG	Nei	Klisseveis	Tverrsteg	Flens/Mannehull	30	20	Horizontal	Full innbrenning	20	Ja	Halv V, 40 grader	Ensidig sveis	0271-M-TW340	3	Prefab/Bjelke	Fabrikk		
74	MIG	Nei	Klisseveis	Steg	Brakett	30	30	Vertikal	5				Tosidig sveis	0271-M-TW340	3	Prefab/Bjelke	Fabrikk		
75	MIG	Nei	Klisseveis	Flens	Brakett	30	30	Horizontal	5				Tosidig sveis	0271-M-TW340	3	Prefab/Bjelke	Fabrikk		
76	MIG		Klisseveis	Kantplate	Topplate	8	16	Horizontal	4	-			Tosidig sveis	0272-M-TW340	2	Sandwich	Fabrikk		
77	MIG		Butt	Kantplate	Kantplate	8	8	Vertikal	-	Delvis innbrenning	6	Ja	V-fuge, 30deg, N=2	Ensidig sveis	0151-M-BW	2	Sandwich	Fabrikk	
78	MIG	Nei	Klisseveis	Rekkverksstøtte	Topplate	8	16	Horizontal	4	-	-	-	Tosidig sveis	0271-M-TW340	5	Sandwich	Fabrikk		
79	MIG	Nei	Klisseveis	Rekkverksstøtte	Langgående profil/ Sidekant	8	8/20	Vertikal	4	-	-	-	Tosidig sveis	0271-M-TW340	5	Sandwich	Fabrikk		
80	MIG		Klisseveis	Steg (Rekkverks-innfesting)	Flens (Rekkverks-innfesting)	20	30	Horizontal	5	Full innbrenning	-	-	Tosidig sveis	0271-M-TW340	3	Sandwich	Fabrikk		
81	MIG		Klisseveis	Steg (Rekkverks-innfesting)	Topplate	20	16	Horizontal	5	Full innbrenning			Tosidig sveis	0271-M-TW340	3				
82	MIG	Ja	Klisseveis	Langgående stiver	Endeplate	8	20	Vertikal	8	Full innbrenning	8	Ja	Halv V, 30grader	Ensidig sveis	0271-M-TW340	3	Sandwich		
83	MIG	Nei	Klisseveis	Sluk	Langgående stiver	8	8	Vertikal	5				Tosidig sveis	0272-M-TW340					

84	MIG	Nei	Klissveits	Sluk	Langsgående siver	8	8	8	Horisontal	5		Tosidlig sveits	0272-M TW340		
85	MIG	Nei	Klissveits	Sluk	Topplate	8	16	8	Horisontal	5		Tosidlig sveits	0271-M TW340		
86	MIG	Nei	Klissveits	Sluk	Bumplate	5	8	8	Horisontal	5		Ensidlig sveits	0271-M TW340	Det som gjenstår er plate til midtrekkverk mot toppplate, og detaljer på "kasse" til sluk.	
87	MIG	Nei	Klissveits	Sluk	Sluk	8	8	8	Horisontal	5			0272-M TW340		
88	MIG	Nei	Klissveits	Sluk	Sluk	8	8	8	Vertikal	5			0272-M TW340		
89	MIG	Nei	Klissveits	Sluk	Sluk	5	8	8	Horisontal	5			0272-M TW340		
90	MIG	Nei	Klissveits	Topplate	Langsgående siver	16	8	8	Horisontal		Full innbrenning	Hav V, 30deg	0272-M TW340		
91	MIG	Nei	Klissveits	Tverrbjelke	Langsgående siver	30	8	7	Vertikal		Delvis innbrenning	Hav V, 30deg	0272-M TW340		
92	MIG	Nei	Klissveits	Tverrbjelke	Langsgående steg	30	20	20	Vertikal	5	Delvis innbrenning	K-Fuge	0261-M- BWT1040	3	Bjelke Fabrikk
93		Nei				8	8	8	Horisontal		Full innbrenning	Hav V, 30deg	0271-M- TW340	3	



# 20021 – ELVERHØY BRU INSPECTION & TEST PLAN





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## REFERENCES

### STANDARDS

- NS-EN 1090-1:2009 Execution of steel structures and aluminum structures - Part 1 Requirements for conformity assessment of structural components
- NS-EN 1090-2:2018 Execution of steel structures and aluminum structures - Part 2: Technical requirements for steel structures
- NS-EN ISO 3834-2 Quality requirements for fusion welding of metallic materials – Part 2: Comprehensive quality requirements
- NS-EN ISO 3834-3 Quality requirements for fusion welding of metallic materials- Part 3: Standard quality requirements
- NS-EN ISO 5817 Welding-Fusion-welded joints in steel, nickel, titanium and their alloys (beam welding excluded) Quality levels for imperfections
- NS-EN ISO 15609-1/4/6 Specification and qualification of welding procedures for metallic materials(WPS)
- NS-EN ISO 15614-1/11/14 Specification and qualification of welding procedures for metallic materials(WPQR)

### EXTERNAL DOCUMENTS

- Håndbok R762 Prosesskode 2: Standard beskrivelse for bruer og kaier (2018)

### INTERNAL DOCUMENTS

- 2021\_Welding plan
  - 2021\_WeldingTable
  - 2021\_Produksjonsmetodikk
  - Execution drawings
  - Welding procedure: Documents\Prosedyrer\Sveiseprosedyrer\Godkjente prosedyrer
  - Internal procedures: Production procedures, NDT procedures, Deviation procedure.
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## 1 OBJECTIVE AND USE OF INSPECTION & TEST PLAN

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This document describes how the quality inspection of a particular element of the construction works must be managed.

The purpose of this I&TP is to lay down all inspection activities to be executed during building of the bridge (internally or by subcontractors). The I&TP states when, where, by whom, the inspections must be carried out and how the results of these inspections have to be registered. The I&TP format describes the subject, specification of Inspection activity, identification of requirements (Reference document), detailing of associated evidence (Registration Doc.), and definition of involvement of parties. The term 'inspection' may not only refer to the physical construction works but could be a document, an item of equipment used for the works, a (welder) qualification, etc. which should be 'inspected'.

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## 2 EXPLANATION OF INDICATED INSPECTION POINTS

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### **''Hold'' point (H)**

Point of notification for inspection. Production stop is required for inspection. Continuation of production activities is allowed only after execution of inspection and the results meet the specifications. The results of such inspection are registered and available for viewing.

### **''Witness'' point (W)**

Point of notification for inspection. Production stop is not necessary for inspection. The production should carry on with the next phase. The results of such inspection are registered and available for viewing.

### **''Review'' (R)**

Review is the act of examining documents to determine traceability, identification and to confirm that processes continue to conform with standards, regulations, and procedures. The Client also may inspect all the registrations in documents as mentioned in this I&TP

### **''Random or Survey'' (S)**

Random inspection as part of survey activities. Notification for inspection is not relevant. Production stop is not necessary. Besides, the Client may perform random inspections during building activities.

### 3 INSPECTION AND TESTING BEFORE THE PRODUCTION CAN START

#### 3.1 CONTROL OF DOCUMENTATION

No.	Inspection point	Activity	Reference Standard/document	Responsible
1	(R)	Checking - suitability and validity of the welder's and welding operator's certificates;	EN ISO 14732	Welding coordinator
2	(H)	Control of WPS/WPQR - the existence of all the necessary procedures to cover all types of welds used - their availability	EN ISO 3834-2 par.10.2; 10.3 EN ISO 3834-5 table 4	Welding coordinator
3	(R)	Control of filler material and related materials	EN ISO 14341	Welding coordinator
4	(R)	Checking material certificate		Warehouse Manager
5	(R)	Control of NDT-procedure: - their availability		QC
6	(R)	Control of NDT personnel: - control of certificates - control of qualification level	EN ISO 3834-2,3 par.8.2 EN ISO 1090-2 par.12.4.1	QC
7	(H)	Required production documentation available		Design dept.

#### 3.2 CONTROL OF PARTS AND COMPONENTS

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	Checking the quality certificates of the arrived parts and components	EN ISO 1090-2 par.12.2.1 /par.12.2.2	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Warehouse Manager / QC
2	(S)	Inspection of the parts and components surface and physical condition + markings	Execution drawing	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Warehouse Manager / QC
3	(S)	Dimensional verification random of parts and components.	EN ISO 1090-2 par.12.2.1 /par.12.2.2 Execution drawing	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Foreman
4	(S)	Control with a focus on bevel geometry	EN ISO 1090-2 par.12.2.1	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Welding coordinator

5	(R)	Documents of components shall be checked to verify that the information on the components supplied matches those ordered.	EN ISO 1090-2 par.12.2.1 /par.12.2.2	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Warehouse Manager
6	(S)	Check the way of handling and storage of parts and components	EN ISO 3834-1 Annex A EN ISO 3834-6 par 9.13	Non / Conformity Notice (NCN or CN)	Warehouse Manager

### 3.3 CONTROL OF ENVIRONMENT

Before production can start, it must be checked that the environment is suitable. Both the welder and the work area must be adequately protected against the effects of wind, rain and snow.

The area must be clean and tidy, without combustible material in the vicinity. If there are components in the vicinity that can be damaged by the welding work, these must be covered or moved to a safe distance.

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	Control of working area: - order and cleanliness - materials arranged by categories - ventilation - correct lighting		-	Foreman/operator
2	(S)	Weather protection against rain, wind, snow, and cold.		-	Foreman /operator

### 3.4 CONTROL OF EQUIPMENT

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(W)	Check the calibration on the welding machines and the reports Maintenance list to be updated		Maintenance record/ Calibration report	Welding coordinator
2	(S)	Check if the equipment is suitable for the job		-	Welding coordinator / foreman

### 3.5 CONTROL OF WELDING CONSUMABLES

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	Check the filler materials certificates and gas specification		Non / Conformity Notice (Ledelsessystem/Avviksregister)	Welding coordinator
2	(R)	Documents of filler material supplied shall match with those ordered.	EN ISO 1090-2 par.1.2.2.1	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Welding coordinator
3	(S)	Check the way of handling and storage of welding consumables	EN ISO 3834-1 Annex A	Non / Conformity Notice (Ledelsessystem/Avviksregister)	Welding coordinator

### 3.6 INITIAL TYPE TESTING

#### 3.6.1 PERFORM AND ISSUE WELDING PROCEDURES

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(W)	Welding performed for each group of material and different positions	EN ISO 1090-2	Welding logs	Operator/ Welding coordinator /3 <sup>rd</sup> party
2	(W)	After welding: -NDT will be performed -all probes will be sent to the DT laboratory	EN ISO.5817/ EN ISO 15614	Inspection reports	QC / NDT inspector/ specialized laboratory
3	(W)	Issue of WPS or make available valid WPS <i>based on performed WPQR</i>	EN ISO15609-1, -4, -6 /EN ISO15614-1, -11, -14	WPQR & WPS	IWE / Welding coordinator /3 <sup>rd</sup> party

#### 3.6.2 TEST PRODUCTION

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(W)	Produce UT reference blocks from the material delivered to be used for the project	Reference blocks shall be made as described in ISO 16811 Annex B.	Conformity Notice	QC / NDT inspector
2	(W)	Destructive production test of different welds as agreed.		Conformity Notice	QC/ Welding coordinator

## 4 PROJECT REQUIREMENTS

### 4.1 CE MARKING OF STEEL STRUCTURES:

Steel structures must be CE-marked in accordance with the NS-EN 1090 series. This includes, among other things, the following:  
Execution must be done in accordance with the company's FPC system, and in accordance with NS-EN 1090-2 (Requirements for applicable execution class).

Declaration of performance and application of the CE mark (Use S04.06\_M04 Template for declaration of performance and CE mark - steel structures)

### 4.2 DRAFTING AND FILING OF REPORTS & QC DOCUMENTS

The registration is drawn up for all inspection points by the PRODTEx QC department:

-Geometry measurements are executed by a certified operator in the presence of QC, and the reports are to be submitted.

-NDT reports are to be done by a certified level 2 inspector and stored by the QC department in the specific project folder.

-Inspection reports are done by PRODTEx QC representative and stored in the specific project folder.

QC documents and reports to be stored in Prodtex AB\Prosjekt industri - Documents\20021 - Elverhøy bru\07 QC

### 4.3 GEOMETRIC DIMENSION AND TOLERANCE

REF. NS-EN 1090-2 par. 11 - Geometric tolerances

Reference to production drawing. - dimension drawing or similar

Engineering drawings need to show the dimensions for all features of a part.

Next to the dimensions, a tolerance value needs to be specified with the minimum and maximum acceptable limit. Tolerance is the difference between the minimum and maximum limits.

The following types of control will be performed related to geometry:

- Form control: straightness, flatness
- Orientation control: parallelism, perpendicularity, angularity
- Location control: position, symmetry

The acceptance criteria will be stipulated in the drawings.



## 4.4 WELD CONTROL/NDT

Weld inspection will be done according to PRODTEx internal procedure “KC04.05 Inspeksjon og prøving av sveis” which means 100% visual inspection and supplementary for each NDT method according to EXC3 :

- [KC04.05 P01 Prosedyre for NDT - VT](#), [KC04.05 P02 Prosedyre for NDT - PT](#), [KC04.05 P03 Prosedyre for NDT - MT](#), [KC04.05 P04 Prosedyre for NDT - UT](#)

### 4.4.1 Weld control is divided into the following actions:

- Type testing
- Routine inspection and testing
- Project-specific control - welding control classes /WIC. (Ref. NS-EN 1090-2 pkt 12.4.2.4 and Annex L)
- Production tests of welding

### 4.4.2 Acceptance criteria

EXECUTION CLASS	QUALITY LEVEL
EXC3*	B** (ref. NS-EN ISO 5817:2014)
* Ref. <i>Håndbok R762 Prosskode 2: Standard beskrivelse for bruer og kaier (2018), pkt. 85 c)</i>	
** Ref. <i>NS-EN 1090-2 pkt. 7.6.1</i>	

### 4.4.3 NDT Documentation

Extent of NDT is defined by WIC in EN-ISO 1090-2, Table L.2 and Table L.1 provides guidance on a systematic method for choosing welding control class. However, all the welds are checked according to the WIC agreed with the owner. Reference to **Chapter 5. Inspection and testing during production**. The NDT tables for each phase of the project with an overview of all welds. The tables contain the welding inspection class, the NDT method performed and the percent amount of the welds to be done. (ref. 1090 chap. 12.4.2.3, Table 24).

The NDT reports shall be stored in a specific project folder and available for review.

Relevant standards:

Visual inspection (VT): ISO 5817 / ISO 17637, Penetration testing (PT): ISO 23277 / ISO 3452-1

Magnetic particle testing (MT): ISO 23278 / ISO 17638, Ultrasonic testing (UT): ISO 11666 / ISO 16810

## 5 INSPECTION AND TESTING DURING PRODUCTION

### 5.1 CONTROL OF PREFAB BEAM ELEMENTS

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	After mounting elements together to be checked: - Location control - Orientation control Joint preparation before welding	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2 production drawing,	-	Foreman/fitter
2	(R)	During the welding -check if the WPS is followed -check visually all the root welds	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2, WPS, Production drawing	-	Foreman / Welding coordinator
3	(W)	-flatness to be checked		-	QC/ Foreman
4	(H)	After welding: -all the welds are 100% visually checked	EN ISO 1090-2 par.12.4.2; EN ISO 3834-2 par.14.4, production drawing,	NDT report	QC / NDT inspector
5	(H)	Check the measurements after welding: -flatness & buckling in the welding area	EN ISO 3834-2 par.14.4, production drawing,	Inspection report	QC / Foreman

#### 5.1.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W36	2	-	5%	100%	R, FW Tverbjelke & Tverbjelke flens	NDT report	QC	
W48	2	-	5%	100%	R, FW Tverrame flens & Tverrame vertical steg	NDT report	QC	
W49	3	-	20%	100%	R, FW Tverrame flens & Tverrame horisontal steg	NDT report	QC	

W51	2	-	5%	100%	R, FW Langsgående steg & Bjelke Langsgående flens	Bjelke	NDT report	QC
W73	3	-	20%	100%	M, FW Tversteg& flens Mannhull		NDT report	QC
W74	3	-	20%	100%	R, BW Steg& Brakett		NDT report	QC
W75	3	-	20%	100%	R, FW Flens & Brakett		NDT report	QC

## 5.2 CONTROL OF AKSE 1-2

Build up description: Akse are built up from two parts A-Akse 1-2 and B-Akse 1-2

No.	Inspection point	Control Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	After mounting of longitudinal elements on the top plate to be checked: - Location control - Orientation control	Ref. Production drawing	-	QC/ Foreman / Welding coordinator
2	(R)	- Joint preparation before welding. Check the cleanliness of the joint. Contaminants like rust, oil, dirt, paint should be removed	EN ISO 1090-2	-	operator
3	(R)	- Moisture check before welding - Surfaces to be welded must be kept dry and free from condensation. - If the material's temperature is below 5 °C, suitable heating may be necessary	EN ISO 1090-2	-	operator
4	(W)	Top plate connected to another top plate: - Joint preparation before welding - Alignment of two plates	Ref. Production drawing	-	operator
5	(W)	Transversal element mounted: - Location control and joint preparation before welding			

6	(R)	Form control and Orientation control: The alignment and flatness				-	Foreman /operator
7	(R)	After mounting a new top plate together with a previous one: - All the elements are in place - Orientation control for all elements: alignment with the elements from previous top plate segment - Joint preparation before welding		Ref. Production drawing		-	Foreman / Welding coordinator
8	(W)	During welding, the correct welding sequence is checked, parameters.		EN ISO 3834-2 par.14.2		-	operator
9	(H)	Before NDT, waiting time should be minimum 24 h		NDT procedures KC04.05		-	QC
10	(H)	Before mounting bottom plate: -all the welds are done -all the welds are 100% visually checked -other NDT method if requested		EN ISO 1090-2 Table 24; Welding table, Production drawing EN ISO 23278, ISO 11666, ISO 5817	NDT report		QC
11	(R)	After welding cool down: -Form control: the flatness of structure		Production drawing		-	Foreman (QC)
12	(S)	-check the position of the bottom plate when mounted. It should be mounted with an accuracy of less than 1 mm. -check the welding stage		EN ISO 1090-2 par.12.2.1 Production drawing, Welding table		-	operator / Welding coordinator
13	(R)	End plate mounted: - Orientation control: the alignment		Production drawing			Foreman/ fitter
14	(H)	After welding the bottom plate -all the welds are 100% visually checked		EN ISO 1090-2 par.12.4.2.2, Welding table	NDT report		(QC) Welding coordinator
15	(H)	When complete: -Form control & Orientation control (flatness and geometric dimensions to be checked)		EN ISO 1090-2 par.12.2.1, Production drawing	Inspection report		QC

**5.2.1 NDT-table**

Ref. NS-EN 1090-2 Annex L, Table L2

For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B:

SIDE A DECK SECTION WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W1.1	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W1.2	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W4.1	5	-	100%	100%	R+LH, FW, side pl. h	NDT report	QC	
W4.2	5	-	100%	100%	R+LH, FW t, side pl. h	NDT report	QC	
W7.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.31, W6.16, W7.46	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.32, W6.17, W7.47	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.33, W6.18, W7.48	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.34, W6.19, W7.49	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.35, W6.20, W7.50	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.36, W6.21, W7.51	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.37, W6.22, W7.52	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.38, W6.23, W7.53	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT

W7.39, W6.24, W7.54	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	
W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	
W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	
W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	
W7.44, W6.29, W7.59	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	
W7.45, W6.30, W7.60	5	-	20%	100%	LH+R, FW L-profile	NDT report	QC	
W8.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W9.1	5	-	20%	100%	LH, Fillet, Tr. +top pl	NDT report	QC	
W9.2	5	-	20%	100%	LH, Fillet, Tr. +top pl	NDT report	QC	
W57.1, W31.1, W31.16, W57.16	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.2, W31.2, W31.17, W57.17	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.3, W31.3, W31.18, W57.18	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.4, W31.4, W31.19, W57.19	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.5, W31.5, W31.20, W57.20	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.6, W31.6, W31.21, W57.21	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.9, W31.9, W31.24, W57.24	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.10, W31.10, W31.25, W57.25	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.11, W31.11, W31.26, W57.26	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW vertical	NDT report	QC	
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW vertical	NDT report	QC	
W39.1, W32.1	3	-	20%	100%	R, fillet vert., tr+side	NDT report	QC	
W39.2, W39.3, W32.2, W32.3	4	50%	100%	100%	R, fillet vert. tr+long	NDT report	QC	
W38.1, W30.1	3	-	20%	100%	R, fillet vertical, side	NDT report	QC	
W42.1, W42.2	5	100%	100%	100%	BW, long. pl.	NDT report	QC	
W55.1, W55.2	5	100%	100%	100%	BW, side. pl.	NDT report	QC	
<b>Bottom plate Welds</b>								
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	NDT report	QC	
W13.15, W13.30	2	-	10%	100%	Laser Lap welds	NDT report	QC	

W13.14, W13.29	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.13, W13.28	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.12, W13.27	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.11, W13.26	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.10, W13.25	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.9, W13.24	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.8, W13.23	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.7, W13.22	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.6, W13.21	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.5, W13.20	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.4, W13.19	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.3, W13.18	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.2, W13.17	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.1, W13.16	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.1, W14.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.2, W14.3, W14.5, W14.6	2	-	10%	100%	Laser Lap welds	NDT report	QC
W15.1, W15.2, W15.3, W15.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W16.1, W16.2, W16.3, W16.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

SIDE B DECK SECTION WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W1.1	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W1.2	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W4.1	5	-	100%	100%	LH, FW, side pl. h	NDT report	QC	
W4.2	5	-	100%	100%	LH, FW, side pl. h	NDT report	QC	
W5.1	5	-	100%	100%	R, FW, side pl. h	NDT report	QC	
W5.2	5	-	100%	100%	R, FW, side pl. h	NDT report	QC	
W7.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	



W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	“-,-”
W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	“-,-”
W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	“-,-”
W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.31, W6.16, W7.46	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.32, W6.17, W7.47	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.33, W6.18, W7.48	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.34, W6.19, W7.49	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.35, W6.20, W7.50	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.36, W6.21, W7.51	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.37, W6.22, W7.52	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.38, W6.23, W7.53	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.39, W6.24, W7.54	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.44, W6.29, W7.59	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.45, W6.30, W7.60	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W8.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W9.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W9.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
	5	-	100%	100%	LH, Fillet, Long. pl.	NDT report	QC	
	5	-	100%	100%	LH, Fillet, Long. pl.	NDT report	QC	
W57.1, W31.1, W31.16, W57.16	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.2, W31.2, W31.17, W57.17	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.3, W31.3, W31.18, W57.18	3	-	20%	100%	R, FW, vertical	NDT report	QC	

W57.4, W31.4, W31.19, W57.19	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.5, W31.5, W31.20, W57.20	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.6, W31.6, W31.21, W57.21	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.9, W31.9, W31.24, W57.24	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.10, W31.10, W31.25, W57.25	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.11, W31.11, W31.26, W57.26	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW, vertical	NDT report	QC
W39.1, W39.2, W32.2	4	50%	100%	100%	R, fillet vert. tr+long	NDT report	QC
W30.1, W38.1	3	-	20%	100%	R, fillet vert., tr+side	NDT report	QC
W42.1	5	100%	100%	100%	BW, long. pl.	NDT report	QC
W55.1, W55.2	5	100%	100%	100%	BW, long. pl.	NDT report	QC
<b>Bottom plate Welds</b>							
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.15, W13.30	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.14, W13.29	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.13, W13.28	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.12, W13.27	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.11, W13.26	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.10, W13.25	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.9, W13.24	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.8, W13.23	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.7, W13.22	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.6, W13.21	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.5, W13.20	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.4, W13.19	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.3, W13.18	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.2, W13.17	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.1, W13.16	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

W15.1, W15.2, W15.3, W15.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W16.1, W16.2, W16.3, W16.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

### 5.3 CONTROL OF AKSE 2-3, AKSE 3-4

Build-up description: Akse is built up from two parts A-Akse 2-3 and B-Akse 2-3, A-Akse 3-4 and B-Akse 3-4

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	After mounting of longitudinal elements on the top plate to be checked: - Location control - Orientation control	Ref. Production drawing	-	QC/ Foreman / Welding coordinator
2	(R)	- Joint preparation before welding. Check the cleanliness of the joint. Contaminants like rust, oil, dirt, paint should be removed	EN ISO 1090-2	-	operator
3	(R)	- Moisture check before welding Surfaces to be welded must be kept dry and free from condensation. - If the material's temperature is below 5 °C, suitable heating may be necessary	EN ISO 1090-2	-	operator
4	(W)	Top plate connected to another top plate: - Joint preparation before welding - Alignment of two plates	Ref. Production drawing	-	operator
5	(W)	Transversal element mounted: - Location control and joint preparation before welding			
6	(R)	Form control and Orientation control: The alignment and flatness		-	Foreman /operator
7	(R)	After mounting a new top plate together with a previous one: - All the elements are in place	Ref. Production drawing	-	Foreman / Welding coordinator

		<ul style="list-style-type: none"> <li>- Orientation control for all elements: alignment with the elements from previous top plate segment</li> <li>- Joint preparation before welding</li> </ul>											
8	(R)	During welding, the correct welding sequence is checked and parameters. Before NDT, waiting time should be minimum of 24 h	EN ISO 3834-2 par.14.2										operator
9	(H)	Before mounting the bottom plate: -all the welds are done -all the welds are 100% visually checked -other NDT method if requested	NDT procedures KC04.05										QC
10	(H)	After welding cool down: -Form control: the flatness of structure	EN ISO 1090-2 Table 24; Welding table, Production drawing EN ISO 23278, ISO 11666, ISO 5817										QC
11	(R)	-Check the position of the bottom plate when mounted. It should be mounted with an accuracy of less than 1 mm. -check the welding stage	Production drawing										Foreman (QC)
12	(S)	After welding the bottom plate -all the welds are 100% visually checked	EN ISO 1090-2 par.12.2.1										operator / Welding coordinator
13	(H)	When complete: -Form control & Orientation control (flatness and geometric dimensions to be checked)	EN ISO 1090-2 par.12.4.2.2, Welding table										(QC) Welding coordinator
14	(H)		EN ISO 1090-2 par.12.2.1, Production drawing										QC

### 5.3.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B:

SIDE A DECK SECTION WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W1.1	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W1.2	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	

W4.1	5	-	100%	100%	R+LH, FW, side pl. h	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W4.2	5	-	100%	100%	R+LH, FW t, side pl. h	NDT report	QC	
W7.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.31, W6.16, W7.46	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.32, W6.17, W7.47	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.33, W6.18, W7.48	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.34, W6.19, W7.49	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.35, W6.20, W7.50	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.36, W6.21, W7.51	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.37, W6.22, W7.52	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.38, W6.23, W7.53	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.39, W6.24, W7.54	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.44, W6.29, W7.59	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.45, W6.30, W7.60	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W8.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	

W9.1	5	-	20%	100%	LH, Fillet, Tr. +top pl	NDT report	QC
W9.2	5	-	20%	100%	LH, Fillet, Tr. +top pl	NDT report	QC
W57.1, W31.1, W31.16, W57.16	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.2, W31.2, W31.17, W57.17	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.3, W31.3, W31.18, W57.18	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.4, W31.4, W31.19, W57.19	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.5, W31.5, W31.20, W57.20	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.6, W31.6, W31.21, W57.21	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.9, W31.9, W31.24, W57.24	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.10, W31.10, W31.25, W57.25	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.11, W31.11, W31.26, W57.26	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW vertical	NDT report	QC
W39.1, W32.1	3	-	20%	100%	R, fillet vert., tr+side	NDT report	QC
W39.2, W39.3, W32.2, W32.3	4	50%	100%	100%	R, fillet vert. tr+long	NDT report	QC
W38.1, W30.1	3	-	20%	100%	R, fillet vertical, side	NDT report	QC
W42.1, W42.2	5	100%	100%	100%	BW, long. pl.	NDT report	QC
W55.1, W55.2	5	100%	100%	100%	BW, side. pl.	NDT report	QC
<b>Bottom plate Welds</b>							
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.15, W13.30	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.14, W13.29	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.13, W13.28	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.12, W13.27	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.11, W13.26	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.10, W13.25	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.9, W13.24	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.8, W13.23	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.7, W13.22	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.6, W13.21	2	-	10%	100%	Laser Lap welds	NDT report	QC

W13.5, W13.20	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.4, W13.19	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.3, W13.18	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.2, W13.17	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.1, W13.16	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.1, W14.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.2, W14.3, W14.5, W14.6	2	-	10%	100%	Laser Lap welds	NDT report	QC
W15.1, W15.2, W15.3, W15.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W16.1, W16.2, W16.3, W16.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

SIDE B DECK SECTION WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W1.1	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W1.2	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W4.1	5	-	100%	100%	LH, FW, side pl. h	NDT report	QC	
W4.2	5	-	100%	100%	LH, FW, side pl. h	NDT report	QC	
W5.1	5	-	100%	100%	R, FW, side pl. h	NDT report	QC	
W5.2	5	-	100%	100%	R, FW, side pl. h	NDT report	QC	
W7.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	



W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.31, W6.16, W7.46	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.32, W6.17, W7.47	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.33, W6.18, W7.48	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.34, W6.19, W7.49	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.35, W6.20, W7.50	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.36, W6.21, W7.51	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.37, W6.22, W7.52	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.38, W6.23, W7.53	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.39, W6.24, W7.54	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.44, W6.29, W7.59	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W7.45, W6.30, W7.60	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC
W8.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC
W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC
W9.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC
W9.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC
	5	-	100%	100%	LH, Fillet, Long. pl.	NDT report	QC
	5	-	100%	100%	LH, Fillet, Long. pl.	NDT report	QC
W57.1, W31.1, W31.16, W57.16	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.2, W31.2, W31.17, W57.17	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.3, W31.3, W31.18, W57.18	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.4, W31.4, W31.19, W57.19	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.5, W31.5, W31.20, W57.20	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.6, W31.6, W31.21, W57.21	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.9, W31.9, W31.24, W57.24	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.10, W31.10, W31.25, W57.25	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.11, W31.11, W31.26, W57.26	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW, vertical	NDT report	QC

Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT

W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW, vertical	NDT report	QC
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW, vertical	NDT report	QC
W39.1, W39.2, W32.2	4	50%	100%	100%	R, fillet vert. tr+long	NDT report	QC
W30.1, W38.1	3	-	20%	100%	R, fillet vert., tr+side	NDT report	QC
W42.1	5	100%	100%	100%	BW, long. pl.	NDT report	QC
W55.1, W55.2	5	100%	100%	100%	BW, long. pl.	NDT report	QC
<b>Bottom plate Welds</b>							
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.15, W13.30	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.14, W13.29	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.13, W13.28	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.12, W13.27	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.11, W13.26	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.10, W13.25	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.9, W13.24	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.8, W13.23	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.7, W13.22	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.6, W13.21	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.5, W13.20	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.4, W13.19	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.3, W13.18	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.2, W13.17	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.1, W13.16	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W15.1, W15.2, W15.3, W15.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W16.1, W16.2, W16.3, W16.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

## 5.4 CONTROL OF AKSE 4-5

Build-up description: Akse is built up from two parts A-Akse 4-5 and B-Akse 4-5

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	After mounting of longitudinal elements on the top plate to be checked: - All the elements are in place - All elements are precise mounted	Ref. Production drawing	-	QC/ Foreman / Welding coordinator
2	(R)	- Joint preparation before welding. Check the cleanliness of the joint. Contaminants like rust, oil, dirt, paint should be removed	EN ISO 1090-2	-	operator
3	(R)	- Moisture check before welding - Surfaces to be welded must be kept dry and free from condensation. If the material's temperature is below 5 °C, suitable heating may be necessary	EN ISO 1090-2	-	operator
4	(R)	Top plate connected to another top plate: - Joint preparation before welding - Alignment of two plates	Ref. Production drawing	-	operator
5	(R)	Transversal element mounted: -check position and joint preparation before welding			
6	(R)	The alignment and flatness need to be checked		-	Foreman /operator
7	(R)	After mounting a new top plate together with a previous one to be checked: - All the elements are in place - All elements are aligned with the elements from previous top plate segment - Joint preparation before welding	Ref. Production drawing	-	Foreman / Welding coordinator

8	(R)		During welding, the correct welding sequence is checked and parameters	EN ISO 3834-2 par.14.2	-	operator
9	(H)		Before NDT, waiting time should be minimum 24 h	NDT procedures KC04.05	-	QC
10	(H)		Before mounting the bottom plate: -all the welds are done -all the welds are 100% visually checked -other NDT method if requested	EN ISO 1090-2 Table 24; Welding table, Production drawing <i>EN ISO 23278, ISO 11666, ISO 5817</i>	NDT report	QC
11	(R)		After welding cool down: -the flatness of structure	Production drawing	-	Foreman (QC)
12	(S)		-check the position of the bottom plate when mounted. It should be mounted with an accuracy of less than 1 mm. -check the welding stage	EN ISO 1090-2 par.12.2.1 Production drawing, Welding table	-	operator / Welding coordinator
13	(R)		End plate mounted: -check the alignment	Production drawing		Foreman/ fitter
14	(H)		After welding the bottom plate -all the welds are 100% visually checked	EN ISO 1090-2 par.12.4.2.2, Welding table	NDT report	(QC) Welding coordinator
15	(H)		The flatness and geometry to be checked	EN ISO 1090-2 par.12.2.1, Production drawing	Inspection report	QC

#### 5.4.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B:

SIDE A DECK SECTION WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W1.1	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W1.2	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W4.1	5	-	100%	100%	R+LH, FW, side pl. h	NDT report	QC	
W4.2	5	-	100%	100%	R+LH, FW t, side pl. h	NDT report	QC	

W7.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.31, W6.16, W7.46	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.32, W6.17, W7.47	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.33, W6.18, W7.48	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.34, W6.19, W7.49	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.35, W6.20, W7.50	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.36, W6.21, W7.51	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.37, W6.22, W7.52	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.38, W6.23, W7.53	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.39, W6.24, W7.54	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.44, W6.29, W7.59	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W7.45, W6.30, W7.60	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
W8.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W9.1	5	-	20%	100%	LH, Fillet, Tr. +top pl	NDT report	QC	
W9.2	5	-	20%	100%	LH, Fillet, Tr. +top pl	NDT report	QC	

W57.1, W31.1, W31.16, W57.16	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.2, W31.2, W31.17, W57.17	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.3, W31.3, W31.18, W57.18	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.4, W31.4, W31.19, W57.19	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.5, W31.5, W31.20, W57.20	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.6, W31.6, W31.21, W57.21	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.9, W31.9, W31.24, W57.24	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.10, W31.10, W31.25, W57.25	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.11, W31.11, W31.26, W57.26	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW vertical	NDT report	QC
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW vertical	NDT report	QC
W39.1, W32.1	3	-	20%	100%	R, fillet vert., tr+side	NDT report	QC
W39.2, W39.3, W32.2, W32.3	4	50%	100%	100%	R, fillet vert. tr+long	NDT report	QC
W38.1, W30.1	3	-	20%	100%	R, fillet vertical, side	NDT report	QC
W42.1, W42.2	5	100%	100%	100%	BW, long. pl.	NDT report	QC
W55.1, W55.2	5	100%	100%	100%	BW, side. pl.	NDT report	QC
<b>Bottom plate Welds</b>							
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.15, W13.30	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.14, W13.29	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.13, W13.28	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.12, W13.27	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.11, W13.26	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.10, W13.25	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.9, W13.24	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.8, W13.23	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.7, W13.22	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.6, W13.21	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.5, W13.20	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.4, W13.19	2	-	10%	100%	Laser Lap welds	NDT report	QC

W13.3, W13.18	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.2, W13.17	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.1, W13.16	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.1, W14.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.2, W14.3, W14.5, W14.6	2	-	10%	100%	Laser Lap welds	NDT report	QC
W15.1, W15.2, W15.3, W15.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W16.1, W16.2, W16.3, W16.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

SIDE B DECK SECTION WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W1.1	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W1.2	5	100%	100%	100%	LH, BW top& top pl	NDT report	QC	
W4.1	5	-	100%	100%	LH, FW, side pl. h	NDT report	QC	
W4.2	5	-	100%	100%	LH, FW, side pl. h	NDT report	QC	
W5.1	5	-	100%	100%	R, FW, side pl. h	NDT report	QC	
W5.2	5	-	100%	100%	R, FW, side pl. h	NDT report	QC	
W7.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.31, W6.16, W7.46	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
								Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
								Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT



W7.32, W6.17, W7.47	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. if weld failures occur, the test will be set again to 100% MT
W7.33, W6.18, W7.48	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.34, W6.19, W7.49	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.35, W6.20, W7.50	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.36, W6.21, W7.51	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.37, W6.22, W7.52	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.38, W6.23, W7.53	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.39, W6.24, W7.54	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.44, W6.29, W7.59	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W7.45, W6.30, W7.60	5	-	20%	100%	LH+R, FW, L profile	NDT report	QC	
W8.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W9.1	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
W9.2	3	-	20%	100%	R, Fillet, Tr. +top pl	NDT report	QC	
	5	-	100%	100%	LH, Fillet, Long. pl.	NDT report	QC	
	5	-	100%	100%	LH, Fillet, Long. pl.	NDT report	QC	
W57.1, W31.1, W31.16, W57.16	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.2, W31.2, W31.17, W57.17	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.3, W31.3, W31.18, W57.18	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.4, W31.4, W31.19, W57.19	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.5, W31.5, W31.20, W57.20	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.6, W31.6, W31.21, W57.21	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.9, W31.9, W31.24, W57.24	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.10, W31.10, W31.25, W57.25	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.11, W31.11, W31.26, W57.26	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW, vertical	NDT report	QC	
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW, vertical	NDT report	QC	

W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW, vertical	NDT report	QC
W39.1, W39.2, W32.2	4	50%	100%	100%	R, fillet vert. tr+long	NDT report	QC
W30.1, W38.1	3	-	20%	100%	R, fillet vert., tr+side	NDT report	QC
W42.1	5	100%	100%	100%	BW, long. pl.	NDT report	QC
W55.1, W55.2	5	100%	100%	100%	BW, long. pl.	NDT report	QC
<b>Bottom plate Welds</b>							
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.15, W13.30	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.14, W13.29	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.13, W13.28	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.12, W13.27	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.11, W13.26	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.10, W13.25	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.9, W13.24	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.8, W13.23	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.7, W13.22	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.6, W13.21	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.5, W13.20	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.4, W13.19	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.3, W13.18	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.2, W13.17	2	-	10%	100%	Laser Lap welds	NDT report	QC
W13.1, W13.16	2	-	10%	100%	Laser Lap welds	NDT report	QC
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W15.1, W15.2, W15.3, W15.4	2	-	10%	100%	Laser Lap welds	NDT report	QC
W16.1, W16.2, W16.3, W16.4	2	-	10%	100%	Laser Lap welds	NDT report	QC

## 5.5 CONTROL OF SUPPORTING BEAMS

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(S)	Internal stiffeners are prefabricated: -check the position of the web on the flange - check the gap and joint preparation	Production drawing	-	Operator/ fitter

2	(S)	When welding the web on the flange – the welding way to be checked (from middle to sides)	EN ISO 3834-2 par.14.3	-	Welding coordinator / Operator/welder
3	(R)	After prefab welding is done, it should be checked 100% visually.	Production drawing	-	Operator/ Welding coordinator
4	(R)	Connection of plates -check the joint before welding -check the alignment and flatness	EN ISO 3834-2 par.14.2 Welding table	-	Fitter
5	(R)	After welding of plates: check visually 100%	EN ISO 3834-2 par.14.4 Production drawing	-	Welder/ Welding coordinator
6	(R)	Assembly of supporting beams: -check flatness & alignment -check the existence of all elements -check the correctness of the assembly	Production drawing	-	Foreman/ QC/
7	(S)	During welding of supporting beam: -check the welding phases	EN ISO 3834-2 par.14.3 Welding table	-	Welder/ Welding coordinator
8	(R)	Before and after welding the root: -check the joint preparation -check visually all the root welds	EN ISO 3834-2 par.14.4	-	Welder/ foreman
9	(H)	After welding of supporting beam: -all the welds are 100% visually checked -other NDT method according to control class	EN ISO 1090-2 tab. 24 EN ISO 3834-2 par.14.4/14.2 EN ISO 23278, ISO 11666, ISO 5817	NDT report	QC / NDT inspector
10	(H)	-Dimensional measurements & reports	EN ISO 3834-2 par.14.4	Inspection report	QC &3D Leica operator

### 5.5.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

WELD NO.	WIC	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W18,	5	100%	100%	100%	LH, BW, bunnflens &bunflens	NDT report	QC	
W20, W21,	2	-	5%	100%	R, FW, bunnflens &Langsgaende stegstivere	NDT report	QC	
W22,	5	100%	100%	100%	R, FW, Bunnflens &Tversteg Lager	NDT report	QC	

W23.1, W23.2	3	-	20%	100%	R, FW, Tverramme. +bunnflens	NDT report	QC
W27.1, W27.2, W27.3, W27.4, W27.5, W27.6	2	-	5%	100%	R, FW, long+ bunnflens	NDT report	QC
W42	5	100%	100%	100%	R, BW, Langsgaende stegstivere&Langsgaende stegstivere	NDT report	QC
W19	3	-	20%	100%	R, FW, Bunnflens &Lagerbrakett	NDT report	QC
W24	3	20%	20%	100%	R, BW, Bunnflens &Tverbjelke flens	NDT report	QC
W26	3	-	20%	100%	R, FW, Bunnflens & Lagerfundament	NDT report	QC
W34, W35	4	-	100%	100%	R, Tverbjelke&Langsgaende stegstivere	NDT report	QC
W36	2	-	5%	100%	R, FW, Tverbjelke &Tverbjelke flens	NDT report	QC
W43, W44, W45	3	-	20%	100%	R, FW, Tverramme steg & Langsgaende stegstiver	NDT report	QC
W46	4	-	100%	100%	R, FWvert. endeplate& Langsgaende stegstiver	NDT report	QC

## 6 INSPECTION AND TESTING DURING ASSEMBLY ON SITE

### 6.1 CONTROL OF ASSEMBLY

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(H)	Coupling the deck segments in the assembly area: -check flatness & alignment -check the joint before welding -check dimension measurements	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2 production drawing, measurements design sheet	-	Foreman/ QC
2	(W)	During the welding -check if the WPS is followed -check visually all the root welds -if in doubt, check with die penetrant	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2, WPS,	-	Foreman / Welding coordinator
3	(H)	After welding:	EN ISO 1090-2	NDT report	QC / NDT inspector

		-all the welds are 100% visually checked -other NDT method according to control class	par.12.4.2; EN ISO 3834-2 par.14.4, production drawing,		
4	(H)	Check the measurements after welding: - flatness & buckling in the welding area - dimension measurements & reports	EN ISO 3834-2 par.14.4, production drawing,	Inspection report	QC / Foreman

### 6.1.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

WELD NO.	WIC	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W2	5	100%	100%	100%	R, BW, Topplate&topplate	NDT report	QC	
W17	2	-	5%	100%	M, bunnplate slice	NDT report	QC	
W58	3	20%	20%	100%	R, FW, langsgående&tværbjelke sandwich	NDT report	QC	
W59	3	20%	20%	100%	R, FW, bunnplate slice&tværbjelke sandwich	NDT report	QC	
W60	5	100%	100%	100%	R, BW, bunnplate slice&bunnplate	NDT report	QC	
W61	2	-	5%	100%	M, FW, bunnplate slice& langsgående	NDT report	QC	
W63	5	100%	100%	100%	M, BW, langsgående & langsgående	NDT report	QC	
W64	5	100%	100%	100%	M, BW, sideplate & sideplate	NDT report	QC	

### 6.2 CONTROL OF MOUNTING SUPPORT BEAMS UNDER

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(H)	Coupling the supporting beam under the bridge: -check the correctness of the assembly - check the joint before welding -check dimension measurements	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2 production drawing, measurements design sheet	-	Foreman/  (S) Welding coordinator
2	(W)	During the welding -check if the WPS is followed	Welding table, WPS	-	Operator/Foreman / Welding coordinator

3	(H)	After welding: -all the welds are 100% visually checked -other NDT methods according to control class	EN ISO 1090-2 par.12.4.2; EN ISO 3834-2 par.14.4, production dwg., EN ISO 23278, ISO 11666, ISO 5817	NDT report	QC / NDT inspector
4	(H)	Check the measurements after welding: - flatness & buckling in the welding area - dimension measurements & reports	EN ISO 3834-2 par.14.4, production drawing,	Inspection report	QC / Foreman & 3D Leica operator

### 6.2.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W69,	5	100%	100%	100%	M, BW Bunnflens & Bunnflens	NDT report	QC	
W25,	5	100%	100%	100%	R, BW Bunnflens & Endeplate	NDT report	QC	
W68	2	-	5%	100%	R, FW Bunnflens & Langsgaende stegstivere	NDT report	QC	
W17	2	-	5%	100%	R, FW Bunnplate & Langsgaende stegstivere	NDT report	QC	
W28	3	20%	20%	100%	M, BW Tverbjelke & Tverbjelke	NDT report	QC	
W29	4	50%	100%	100%	M, BW Tverbjelke & Tverskott	NDT report	QC	
W33	3	20%	20%	100%	M, BW Tverbjelke & Tverramme	NDT report	QC	
W37	3	-	20%	100%	M, FW Tverbjelke & Sideplate	NDT report	QC	
W54	3	-	20%	100%	M, FW Tverbjelke flens & Sideplate	NDT report	QC	
W59	3	20%	20%	100%	R, BW Bunnplate & Tverbjelke	NDT report	QC	
W41	3	20%	20%	100%	M, BW Langsgaende stegstivere & Langsgaende stegstivere	NDT report	QC	

W70	5	100%	100%	100%	M, BW stegstivere &Langsgaende stegstivere	NDT report	QC	Area welded on mounting site
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### 6.3 CONTROL OF MOUNTING ENDPLATE

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(H)	Coupling the endplate in the assembly area: -check flatness & alignment -check the joint before welding -check dimension measurements	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2 production drawing, measurements design sheet	-	Foreman/ QC
2	(W)	During the welding -check if the WPS is followed	EN ISO 1090-2 par.12.4.1; EN ISO 3834-2 par.14.2, WPS,	-	Foreman / Welding coordinator
3	(H)	After welding: -all the welds are 100% visually checked	EN ISO 1090-2 par.12.4.2; EN ISO 3834-2 par.14.4, production drawing,	NDT report	QC / NDT inspector
4	(H)	Check the measurements after welding: - flatness & buckling in the welding area	EN ISO 3834-2 par.14.4, production drawing,	Inspection report	QC / Foreman

#### 6.3.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

WELD NO.	W I C	UT	MT/PT	VT	WELD DETAILS	Registered doc.	RESPONSIBLE	COMMENTS
W3	5	100%	100%	100%	R, BW Topplate & Endeplate	NDT report	QC	
W11	4	50%	100%	100%	R, BW Bumplate & Endeplate	NDT report	QC	
W25	5	20%	100%	100%	R, BW Bunnflens & Endeplate	NDT report	QC	
W46	4	-	100%	100%	R, BW Bumplate & Endeplate	NDT report	QC	
W56	5	-	100%	100%	R, BW Sideplate & Endeplate	NDT report	QC	

## 7 INSPECTION AND TESTING AFTER PRODUCTION

### 7.1 PRESSURE TESTING

The ductile-to-brittle transition temperature and the possibility of brittle fracture must be considered when conducting pressure tests.

Pneumatic testing involves the hazard of released energy stored in compressed gas in the event of a breach of containment.

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	Test fluid: - If not air, the gas shall be non-flammable and nontoxic	-	-	Foreman/
2	(R)	Test pressure shall be in accordance with R762 at 0,5 bar	-	-	Foreman /QC
3		All visual inspections and non-destructive examinations required shall be completed and evaluated as acceptable			Foreman /QC
4	(R)	Care must be taken to minimize the chance of brittle fracture during the pneumatic leak test	-	-	Foreman
5	(R)	Parts of assembly must not be adjusted while the deck system is under pressure	-	-	/Foreman
6	(R)	Calibrated pressure gauges shall be used during the test	-	-	Foreman /QC
7	(R)	Valves shall be used to isolate the equipment from the pressure source	-	-	Foreman
8	(R)	Adequate anchoring shall be provided for equipment to be tested.	-	-	Foreman /
9	(R)	The safe distance shall be identified by placing appropriate barriers			Foreman /QC
10	(R)	All staff associated with or conducting a pneumatic pressure test shall be deemed competent	-	-	Foreman /
11	(R)	A pre-test safety meeting should be conducted to ensure all personnel present on the site that may be exposed are aware of the hazards, mitigations and emergency response plan	-	-	Foreman /QC
12	(H)	After testing inspection report is to be issued	-	Inspection report	QC



## 8 NON-CONFORMANCE MANAGEMENT

Because of the high cost of non-conformances, PRODTEx works extremely hard to create procedures and processes which 'catch' non-conformances and action them as early as possible - in the form of corrective actions.

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(H)	Notifying of any identified non-conformance	EN ISO 9001	-	All members of staff
2	(R)	Documenting the non-conformance (With evidence/proof in the form of photos)	EN ISO 3834-2 par.18, EN ISO 1090-1 par.6.3.8 production drawing,		QC / Foreman
3	(R)	Identifying who was at fault for the non-conformance (was it a supplier, contractor)	-	-	QC / Foreman
4	(R)	Recommended corrective actions	EN ISO 3834-2par.15, EN ISO 1090-2 par12.3 production drawing,	-	QC / Foreman
5	(R)	Root cause analysis	EN ISO 9001	-	QC Manager
6	(R)	Preventative actions which will stop the non-conformance from occurring again	EN ISO 3834-2 par.15,	-	Foreman
7	(R)	Closeout signatures once both or all parties have rectified and closed the non-conformance	EN ISO 3834-2 par.15, production drawing, internal procedure	Ref. Internal procedure: S04.01_L1 Avviksregister	QC Manager

## 9 CONTROL OF DOCUMENTATION BEFORE HANDOVER

The project manager will endorse the documents before being released.

No.	Inspection point	Activity	Reference Standard/document	Registered Doc.	Responsible
1	(R)	All documents shall contain the following information: - Company Name and Logo - Document Title - Document ID - Current Revision and Date - Copy Number	EN ISO 9001	-	QC Manager/
2	(R)	Prepare declaration of performance and application of the CE mark	EN ISO 1090-2	S04.06_M04 Declaration of performance and CE mark	QC Manager/ Project Manager
3	(R)	- create new documents deemed necessary	-	-	3D Leica operator/ NDT inspector/ QC Welding coordinator
4	(R)	- ensure that the changes in the current version of documents are identified.	EN ISO 9001	-	QC
5	(R)	- prevent the unintended use of obsolete documents and apply suitable identification to them, if they are retained for any purpose. Retention of documents: -all files will be backed up by IT staff	EN ISO 9001	-	/Foreman /QC Welding coordinator
6	(R)	Retention of documents: -all files will be backed up by IT staff	EN ISO 9001	-	IT department
7	(R)	Endorse the documents before being released: - Check according to the document list	Ref. document list	-	Project Manager

# WELD TRACEABILITY FORM

Project	Elverhøy Bru
Responsible welding coordinator	Ódön Bogdan Bindiu

Section	Welding no.	Date	Type of weld	Welder/ Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P1A	W1.1	12.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P1A	W1.2	12.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P1A	W4.1	12.06	R-LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P1A	W4.2	12.06	R-LH, FW1, side pl. h	MM	GJN		5	-	100%	100%		
P1A	W7.1, W6.1, W7.16	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.2, W6.2, W7.17	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.3, W6.3, W7.18	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.4, W6.4, W7.19	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.5, W6.5, W7.20	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.6, W6.6, W7.21	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.7, W6.7, W7.22	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.8, W6.8, W7.23	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.9, W6.9, W7.24	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.10, W6.10, W7.25	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.11, W6.11, W7.26	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.12, W6.12, W7.27	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.13, W6.13, W7.28	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.14, W6.14, W7.29	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W7.15, W6.15, W7.30	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P1A	W8.1	12.06	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%		
P1A	W8.2	12.06	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%		
P1A	W9.1	12.06	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%		
P1A	W9.2	12.06	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%		
P1A	W10.1	12.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P1A	W10.2	12.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P1A	W10.3	12.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P1A	W10.4	12.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P1A	W57.1, W31.1,6	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.2, W31.2,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.3, W31.3,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.4, W31.4,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.5, W31.5,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.6, W31.6,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.7, W31.7,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.8, W31.8,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.9, W31.9,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.10, W31.10,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.11, W31.11,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.12, W31.12,	13.06	R, FW vertical		GJN		3	-	20%	100%		
P1A	W57.13, W31.13,	13.06	R, FW vertical		GJN		3	-	20%	100%		

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

P1A	W57.14, W31.14,	13.06	R, FW vertical		GJN	3	-	20%	100%
P1A	W57.15, W31.15,	13.06	R, FW vertical		GJN	3	-	20%	100%
P1A	W39.1, W32.1	13.06	R, fillet vert., Ir-side		GJN	3	-	20%	100%
P1A	W39.2, W39.3,	13.06	R, fillet vert. Ir-long		GJN	4	50%	100%	100%
P1A	W38.1, W30.1	13.06	R, fillet vertical, side		GJN	3	-	20%	100%
P1A	W42.1, W42.2	13.06	BW, long, pl.		GJN	5	100%	100%	100%
P1A	W55.1,	13.06	BW, side, pl.		GJN	5	100%	100%	100%
<b>Bottom plate Welds</b>									
P1A	W12.1,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.15,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.14,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.13,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.12,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.11,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.10,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.9,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.8,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.7,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.6,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.5,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.4,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.3,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.2,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W13.1,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W14.1,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W14.2,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W15.1, W15.2,	15.06	Laser Lap welds		GJN	2	-	10%	100%
P1A	W16.1, W16.2,	15.06	Laser Lap welds		GJN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Manually						
P2A	W1.1	9.06	LH, BW top & top pl			5	100%	100%	100%		
P2A	W1.2	9.06	LH, BW top & top pl			5	100%	100%	100%		
P2A	W4.1	9.06	R+LH, FW, side pl. h		GJN	5	-	100%	100%		
P2A	W4.2	9.06	R+LH, FW, side pl. h		GJN	5	-	100%	100%		
P2A	W7.1, W6.1, W7.16	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.2, W6.2, W7.17	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.3, W6.3, W7.18	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.4, W6.4, W7.19	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.5, W6.5, W7.20	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.6, W6.6, W7.21	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.7, W6.7, W7.22	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.8, W6.8, W7.23	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.9, W6.9, W7.24	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.10, W6.10, W7.25	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.11, W6.11, W7.26	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.12, W6.12, W7.27	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.13, W6.13, W7.28	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.14, W6.14, W7.29	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.15, W6.15, W7.30	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		
P2A	W7.31, W6.16, W7.46	9.06	LH+R, FW L profile		GJN	5	-	20%	100%		

P2A	W7.32, W6.17, W7.47	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.33, W6.18, W7.48	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.34, W6.19, W7.49	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.35, W6.20, W7.50	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.36, W6.21, W7.51	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.37, W6.22, W7.52	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.38, W6.23, W7.53	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.39, W6.24, W7.54	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.40, W6.25, W7.55	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.41, W6.26, W7.56	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.42, W6.27, W7.57	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.43, W6.28, W7.58	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.44, W6.29, W7.59	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W7.45, W6.30, W7.60	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P2A	W8.1	12.06	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P2A	W8.2	12.06	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P2A	W9.1	12.06	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P2A	W9.2	12.06	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P2A	W10.1	12.06	LH, Fillet, Long pl.	MM			5	-	100%	100%
P2A	W10.2	12.06	LH, Fillet, Long pl.	MM			5	-	100%	100%
P2A	W10.3	12.06	LH, Fillet, Long pl.	MM			5	-	100%	100%
P2A	W10.4	12.06	LH, Fillet, Long pl.	MM			5	-	100%	100%
P2A	W57.1, W31.1, W31.16, W57.16	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.2, W31.2, W31.17, W57.17	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.3, W31.3, W31.18, W57.18	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.4, W31.4, W31.19, W57.19	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.5, W31.5, W31.20, W57.20	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.6, W31.6, W31.21, W57.21	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.7, W31.7, W31.22, W57.22	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.8, W31.8, W31.23, W57.23	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.9, W31.9, W31.24, W57.24	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.10, W31.10, W31.25, W57.25	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.11, W31.11, W31.26, W57.26	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.12, W31.12, W31.27, W57.27	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.13, W31.13, W31.28, W57.28	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.14, W31.14, W31.29, W57.29	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W57.15, W31.15, W31.30, W57.30	12.06	R, FW vertical	MM	GJN		3	-	20%	100%
P2A	W39.1, W32.1	12.06	R, fillet vert. tr+side	MM	GJN		3	-	20%	100%
P2A	W39.2, W39.3, W32.2, W32.3	12.06	R, fillet vert. tr+long	MM	GJN		4	50%	100%	100%
P2A	W38.1, W30.1	12.06	R, fillet vertical, side	MM	GJN		3	-	20%	100%
P2A	W42.1, W42.2	12.06	BW, long, pl.	MM	GJN		5	100%	100%	100%
P2A	W55.1, W55.2	12.06	BW, side, pl.	MM	GJN		5	100%	100%	100%
Bottom plate Welds										
P2A	W12.1, W12.2	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.15, W13.30	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.14, W13.29	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.13, W13.28	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.12, W13.27	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.11, W13.26	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.10, W13.25	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.9, W13.24	14.06	Laser Lap welds	GJN			2	-	10%	100%
P2A	W13.8, W13.23	14.06	Laser Lap welds	GJN			2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P2A	W13.7, W13.22	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W13.6, W13.21	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W13.5, W13.20	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W13.4, W13.19	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W13.3, W13.18	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W13.2, W13.17	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W13.1, W13.16	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W14.1, W14.4	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W14.2, W14.3, W14.5, W14.6	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W15.1, W15.2, W15.3, W15.4	14.06	Laser Lap welds	GJN		2	-	10%	100%
P2A	W16.1, W16.2, W16.3, W16.4	14.06	Laser Lap welds	GJN		2	-	10%	100%
	SW								

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P3A	W1.1	7.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P3A	W1.2	7.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P3A	W4.1	7.06	R-LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P3A	W4.2	7.06	R-LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P3A	W7.1, W6.1, W7.16	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.2, W6.2, W7.17	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.3, W6.3, W7.18	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.4, W6.4, W7.19	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.5, W6.5, W7.20	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.6, W6.6, W7.21	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.7, W6.7, W7.22	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.8, W6.8, W7.23	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.9, W6.9, W7.24	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.10, W6.10, W7.25	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.11, W6.11, W7.26	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.12, W6.12, W7.27	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.13, W6.13, W7.28	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.14, W6.14, W7.29	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.15, W6.15, W7.30	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.31, W6.16, W7.46	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.32, W6.17, W7.47	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.33, W6.18, W7.48	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.34, W6.19, W7.49	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.35, W6.20, W7.50	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.36, W6.21, W7.51	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.37, W6.22, W7.52	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.38, W6.23, W7.53	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.39, W6.24, W7.54	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.40, W6.25, W7.55	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.41, W6.26, W7.56	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.42, W6.27, W7.57	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.43, W6.28, W7.58	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.44, W6.29, W7.59	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W7.45, W6.30, W7.60	7.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P3A	W8.1	8.06	R, Fillet, Tr. +top pl		GJN	3	-	20%	100%		
P3A	W8.2	8.06	R, Fillet, Tr. +top pl		GJN	3	-	20%	100%		
P3A	W9.1	8.06	LH, Fillet, Tr. +top pl	MM	GJN	5	-	20%	100%		

P3A	W9.2	8.06	LH, Fillet, Tr.+top pl	MM		5	-	20%	100%
P3A	W10.1	8.06	LH, Fillet, Long. pl.	MM		5	-	100%	100%
P3A	W10.2	8.06	LH, Fillet, Long. pl.	MM		5	-	100%	100%
P3A	W10.3	8.06	LH, Fillet, Long. pl.	MM		5	-	100%	100%
P3A	W10.4	8.06	LH, Fillet, Long. pl.	MM		5	-	100%	100%
P3A	W57.1, W31.1, W31.16, W57.16	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.2, W31.2, W31.17, W57.17	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.3, W31.3, W31.18, W57.18	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.4, W31.4, W31.19, W57.19	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.5, W31.5, W31.20, W57.20	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.6, W31.6, W31.21, W57.21	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.7, W31.7, W31.22, W57.22	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.8, W31.8, W31.23, W57.23	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.9, W31.9, W31.24, W57.24	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.10, W31.10, W31.25, W57.25	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.11, W31.11, W31.26, W57.26	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.12, W31.12, W31.27, W57.27	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.13, W31.13, W31.28, W57.28	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.14, W31.14, W31.29, W57.29	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W57.15, W31.15, W31.30, W57.30	9.06	R, FW vertical	GJN		3	-	20%	100%
P3A	W39.1, W32.1	9.06	R, fillet vert., tr+side	GJN		3	-	20%	100%
P3A	W39.2, W39.3, W32.2, W32.3	9.06	R, fillet vert. tr+long	GJN		4	50%	100%	100%
P3A	W38.1, W30.1	9.06	R, fillet vertical, side	GJN		3	-	20%	100%
P3A	W42.1, W42.2	9.06	BW, long. pl.	GJN		5	100%	100%	100%
P3A	W55.1, W55.2	9.06	BW, side. pl.	GJN		5	100%	100%	100%
Bottom plate Welds									
P3A	W12.1, W12.2	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.15, W13.30	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.14, W13.29	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.13, W13.28	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.12, W13.27	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.11, W13.26	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.10, W13.25	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.9, W13.24	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.8, W13.23	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.7, W13.22	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.6, W13.21	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.5, W13.20	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.4, W13.19	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.3, W13.18	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.2, W13.17	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W13.1, W13.16	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W14.1, W14.4	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W14.2, W14.3, W14.5, W14.6	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W15.1, W15.2, W15.3, W15.4	14.06	Laser Lap welds	GJN		2	-	10%	100%
P3A	W16.1, W16.2, W16.3, W16.4	14.06	Laser Lap welds	GJN		2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Manually						
P4A	W1.1	5.06	LH, BW, top & top pl	MM		5	100%	100%	100%		

P4A	W1.2	5.06	LH, BW top & top pl	MM	GJN		5	100%	100%	100%
P4A	W4.1	5.06	R-LH, FW, side pl. h	MM	GJN		5	-	100%	100%
P4A	W4.2	5.06	R-LH, FW, side pl. h	MM	GJN		5	-	100%	100%
P4A	W7.1, W6.1, W7.16	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.2, W6.2, W7.17	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.3, W6.3, W7.18	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.4, W6.4, W7.19	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.5, W6.5, W7.20	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.6, W6.6, W7.21	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.7, W6.7, W7.22	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.8, W6.8, W7.23	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.9, W6.9, W7.24	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.10, W6.10, W7.25	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.11, W6.11, W7.26	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.12, W6.12, W7.27	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.13, W6.13, W7.28	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.14, W6.14, W7.29	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.15, W6.15, W7.30	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.31, W6.16, W7.46	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.32, W6.17, W7.47	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.33, W6.18, W7.48	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.34, W6.19, W7.49	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.35, W6.20, W7.50	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.36, W6.21, W7.51	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.37, W6.22, W7.52	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.38, W6.23, W7.53	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.39, W6.24, W7.54	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.40, W6.25, W7.55	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.41, W6.26, W7.56	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.42, W6.27, W7.57	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.43, W6.28, W7.58	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.44, W6.29, W7.59	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W7.45, W6.30, W7.60	6.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P4A	W8.1	6.06	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P4A	W8.2	6.06	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P4A	W9.1	6.06	LH, Fillet, Tr. +top pl	MM	GJN		5	-	20%	100%
P4A	W9.2	6.06	LH, Fillet, Tr. +top pl	MM	GJN		5	-	20%	100%
P4A	W10.1	6.06	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
P4A	W10.2	6.06	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
P4A	W10.3	6.06	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
P4A	W10.4	6.06	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
P4A	W57.1, W31.1, W31.16, W57.16	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.2, W31.2, W31.17, W57.17	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.3, W31.3, W31.18, W57.18	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.4, W31.4, W31.19, W57.19	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.5, W31.5, W31.20, W57.20	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.6, W31.6, W31.21, W57.21	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.7, W31.7, W31.22, W57.22	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.8, W31.8, W31.23, W57.23	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.9, W31.9, W31.24, W57.24	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.10, W31.10, W31.25, W57.25	7.06	R, FW vertical	MM	GJN		3	-	20%	100%
P4A	W57.11, W31.11, W31.26, W57.26	7.06	R, FW vertical	MM	GJN		3	-	20%	100%

UT, MT, VT reports,  
measurement and  
pressure test report

Area inside sandwich deck  
was checked before closing.  
Weld defects are stated in  
NDT reports.



P4A	W57.12, W31.12, W31.27, W57.27	R, FW vertical	GJN	3	-	20%	100%
P4A	W57.13, W31.13, W31.28, W57.28	R, FW vertical	GJN	3	-	20%	100%
P4A	W57.14, W31.14, W31.29, W57.29	R, FW vertical	GJN	3	-	20%	100%
P4A	W57.15, W31.15, W31.30, W57.30	R, FW vertical	GJN	3	-	20%	100%
P4A	W39.1, W32.1	R, fillet vert., Ir+side	GJN	3	-	20%	100%
P4A	W39.2, W39.3, W32.2, W32.3	R, fillet vert. Ir+long	GJN	4	50%	100%	100%
P4A	W38.1, W30.1	R, fillet vertical, side	GJN	3	-	20%	100%
P4A	W42.1, W42.2	R, M, BW, long pl.	GJN	5	100%	100%	100%
P4A	W55.1, W55.2	R, M, BW, side, pl.	GJN	5	100%	100%	100%
Bottom plate Welds							
P4A	W12.1, W12.2	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.15, W13.30	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.14, W13.29	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.13, W13.28	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.12, W13.27	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.11, W13.26	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.10, W13.25	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.9, W13.24	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.8, W13.23	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.7, W13.22	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.6, W13.21	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.5, W13.20	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.4, W13.19	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.3, W13.18	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.2, W13.17	Laser Lap welds	GJN	2	-	10%	100%
P4A	W13.1, W13.16	Laser Lap welds	GJN	2	-	10%	100%
P4A	W14.1, W14.4	Laser Lap welds	GJN	2	-	10%	100%
P4A	W14.2, W14.3, W14.5, W14.6	Laser Lap welds	GJN	2	-	10%	100%
P4A	W15.1, W15.2, W15.3, W15.4	Laser Lap welds	GJN	2	-	10%	100%
P4A	W16.1, W16.2, W16.3, W16.4	Laser Lap welds	GJN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P5A	W1.1	2.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P5A	W1.2	2.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P5A	W4.1	2.06	R+LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P5A	W4.2	2.06	R+LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P5A	W7.1, W6.1, W7.16	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.2, W6.2, W7.17	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.3, W6.3, W7.18	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.4, W6.4, W7.19	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.5, W6.5, W7.20	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.6, W6.6, W7.21	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.7, W6.7, W7.22	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.8, W6.8, W7.23	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.9, W6.9, W7.24	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.10, W6.10, W7.25	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.11, W6.11, W7.26	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.12, W6.12, W7.27	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P5A	W7.13, W6.13, W7.28	2.06	LH+R, FW L profile	MM	GJN	5	-	20%	100%		

P5A	W7.14, W6.14, W7.29	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.15, W6.15, W7.30	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.31, W6.16, W7.46	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.32, W6.17, W7.47	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.33, W6.18, W7.48	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.34, W6.19, W7.49	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.35, W6.20, W7.50	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.36, W6.21, W7.51	2.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.37, W6.22, W7.52	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.38, W6.23, W7.53	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.39, W6.24, W7.54	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.40, W6.25, W7.55	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.41, W6.26, W7.56	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.42, W6.27, W7.57	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.43, W6.28, W7.58	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.44, W6.29, W7.59	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W7.45, W6.30, W7.60	5.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P5A	W8.1	5.06	R, Fillet, Tr, +top pl	MM	GJN		3	-	20%	100%
P5A	w	5.06	R, Fillet, Tr, +top pl	MM	GJN		3	-	20%	100%
P5A	W9.1	5.06	LH, Fillet, Tr, +top pl	MM	GJN		5	-	20%	100%
P5A	W9.2	5.06	LH, Fillet, Tr, +top pl	MM	GJN		5	-	20%	100%
P5A	W10.1	6.06	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P5A	W10.2	6.06	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P5A	W10.3	6.06	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P5A	W10.4	6.06	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P5A	W57.1, W31.1, W31.16, W57.16	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.2, W31.2, W31.17, W57.17	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.3, W31.3, W31.18, W57.18	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.4, W31.4, W31.19, W57.19	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.5, W31.5, W31.20, W57.20	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.6, W31.6, W31.21, W57.21	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.7, W31.7, W31.22, W57.22	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.8, W31.8, W31.23, W57.23	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.9, W31.9, W31.24, W57.24	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.10, W31.10, W31.25, W57.25	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.11, W31.11, W31.26, W57.26	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.12, W31.12, W31.27, W57.27	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.13, W31.13, W31.28, W57.28	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.14, W31.14, W31.29, W57.29	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W57.15, W31.15, W31.30, W57.30	6.06	R, FW vertical	MM	GJN		3	-	20%	100%
P5A	W39.1, W32.1	6.06	R, fillet vert., tr+side	MM	GJN		3	-	20%	100%
P5A	W39.2, W39.3, W32.2, W32.3	6.06	R, fillet vert. tr+long	MM	GJN		4	50%	100%	100%
P5A	W38.1, W30.1	6.06	R, fillet vertical, side	MM	GJN		3	-	20%	100%
P5A	W42.1, W42.2	6.06	BW, long, pl.	MM	GJN		5	100%	100%	100%
P5A	W55.1, W55.2	6.06	BW, side, pl.	MM	GJN		5	100%	100%	100%
Bottom plate Welds										
P5A	W12.1, W12.2	12.06	Laser Lap welds	GJN			2	-	10%	100%
P5A	W13.15, W13.30	12.06	Laser Lap welds	GJN			2	-	10%	100%
P5A	W13.14, W13.29	12.06	Laser Lap welds	GJN			2	-	10%	100%
P5A	W13.13, W13.28	12.06	Laser Lap welds	GJN			2	-	10%	100%
P5A	W13.12, W13.27	12.06	Laser Lap welds	GJN			2	-	10%	100%
P5A	W13.11, W13.26	12.06	Laser Lap welds	GJN			2	-	10%	100%

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

P5A	W13.10, W13.25	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.9, W13.24	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.8, W13.23	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.7, W13.22	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.6, W13.21	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.5, W13.20	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.4, W13.19	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.3, W13.18	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.2, W13.17	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W13.1, W13.16	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W14.1, W14.4	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W14.2, W14.3, W14.5, W14.6	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W15.1, W15.2, W15.3, W15.4	12.06	Laser Lap welds	GJN		2	-	10%	100%
P5A	W16.1, W16.2, W16.3, W16.4	12.06	Laser Lap welds	GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P1B	W1.1	27.07	LH, BW top & top pl	MM			5	100%	100%	100%		
P1B	W1.2	27.07	LH, BW top & top pl	MM			5	100%	100%	100%		
P1B	W4.1	27.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P1B	W4.2	27.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P1B	W5.1	27.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P1B	W5.2	27.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P1B	W7.1, W6.1, W7.16	27.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.2, W6.2, W7.17	27.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.3, W6.3, W7.18	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.4, W6.4, W7.19	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.5, W6.5, W7.20	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.6, W6.6, W7.21	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.7, W6.7, W7.22	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.8, W6.8, W7.23	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.9, W6.9, W7.24	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.10, W6.10, W7.25	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.11, W6.11, W7.26	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.12, W6.12, W7.27	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.13, W6.13, W7.28	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.14, W6.14, W7.29	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W7.15, W6.15, W7.30	28.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P1B	W8.1	28.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P1B	W8.2	28.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P1B	W9.1	28.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P1B	W9.2	28.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P1B	W10.1	28.07	LH, Fillet, Long pl	MM			5	-	100%	100%		
P1B	W57.1, W31.1,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.2, W31.2,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.3, W31.3,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.4, W31.4,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.5, W31.5,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.6, W31.6,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.7, W31.7,	28.07	R, FW, vertical		GJN		3	-	20%	100%		
P1B	W57.8, W31.8,	28.07	R, FW, vertical		GJN		3	-	20%	100%		

UT, MT, VT reports, measurement and  
 Area inside sandwich deck  
 was checked before closing.  
 Weld defects are stated in

Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Comments		
				Laser	Robot	Manually					
P1B	W57.9, W31.9	28.07	R, FW, vertical	GJN				3	-	20%	100%
P1B	W57.10, W31.10	1.08	R, FW, vertical	GJN				3	-	20%	100%
P1B	W57.11, W31.11	1.08	R, FW, vertical	GJN				3	-	20%	100%
P1B	W57.12, W31.12	1.08	R, FW, vertical	GJN				3	-	20%	100%
P1B	W57.13, W31.13	1.08	R, FW, vertical	GJN				3	-	20%	100%
P1B	W57.14, W31.14	1.08	R, FW, vertical	GJN				3	-	20%	100%
P1B	W57.15, W31.15	1.08	R, FW, vertical	GJN				3	-	20%	100%
P1B	W39.1, W39.2, W32.2	1.08	R, fillet vert. tr-long	GJN				4	50%	100%	100%
P1B	W30.1, W38.1	1.08	R, fillet vert. tr-side	GJN				3	-	20%	100%
P1B	W42.1	1.08	BW, long, pl.	GJN				5	100%	100%	100%
P1B	W55.1	1.08	BW, long, pl.	GJN				5	100%	100%	100%
<b>Bottom plate Welds</b>											
P1B	W12.1, W12.2	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.15	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.14	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.13	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.12	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.11	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.10	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.9	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.8	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.7	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.6	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.5	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.4	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.3	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.2	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W13.1	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W14.1, W14.2	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W15.1, W15.2	2.08	Laser Lap welds	GJN				2	-	10%	100%
P1B	W16.1, W16.2	2.08	Laser Lap welds	GJN				2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Registered doc.	Comments	
				Laser	Robot	Manually					
P2B	W1.1	25.07	LH, BW, top & top pl	MM				5	100%	100%	100%
P2B	W1.2	25.07	LH, BW, top & top pl	MM				5	100%	100%	100%
P2B	W4.1	25.07	LH, FW, side pl. h	MM	GJN			5	-	100%	100%
P2B	W4.2	25.07	LH, FW, side pl. h	MM	GJN			5	-	100%	100%
P2B	W5.1	25.07	R, FW, side pl. h	MM	GJN			5	-	100%	100%
P2B	W5.2	25.07	R, FW, side pl. h	MM	GJN			5	-	100%	100%
P2B	W7.1, W6.1, W7.16	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.2, W6.2, W7.17	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.3, W6.3, W7.18	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.4, W6.4, W7.19	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.5, W6.5, W7.20	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.6, W6.6, W7.21	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.7, W6.7, W7.22	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.8, W6.8, W7.23	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.9, W6.9, W7.24	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.10, W6.10, W7.25	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%
P2B	W7.11, W6.11, W7.26	25.07	LH+R, FW, L profile	MM	GJN			5	-	20%	100%

P2B	W7.12, W6.12, W7.27	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.13, W6.13, W7.28	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.14, W6.14, W7.29	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.15, W6.15, W7.30	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.31, W6.16, W7.46	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.32, W6.17, W7.47	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.33, W6.18, W7.48	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.34, W6.19, W7.49	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.35, W6.20, W7.50	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.36, W6.21, W7.51	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.37, W6.22, W7.52	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.38, W6.23, W7.53	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.39, W6.24, W7.54	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.40, W6.25, W7.55	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.41, W6.26, W7.56	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.42, W6.27, W7.57	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.43, W6.28, W7.58	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.44, W6.29, W7.59	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W7.45, W6.30, W7.60	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P2B	W8.1	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P2B	W8.2	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P2B	W9.1	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P2B	W9.2	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P2B	W10.1	LH, Fillet, Long, pl	MM			5	-	100%	100%
P2B	W10.2	LH, Fillet, Long, pl	MM			5	-	100%	100%
P2B	W57.1, W31.1, W31.16, W57.16	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.2, W31.2, W31.17, W57.17	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.3, W31.3, W31.18, W57.18	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.4, W31.4, W31.19, W57.19	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.5, W31.5, W31.20, W57.20	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.6, W31.6, W31.21, W57.21	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.7, W31.7, W31.22, W57.22	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.8, W31.8, W31.23, W57.23	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.9, W31.9, W31.24, W57.24	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.10, W31.10, W31.25, W57.25	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.11, W31.11, W31.26, W57.26	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.12, W31.12, W31.27, W57.27	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.13, W31.13, W31.28, W57.28	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.14, W31.14, W31.29, W57.29	R, FW, vertical		GJN		3	-	20%	100%
P2B	W57.15, W31.15, W31.30, W57.30	R, FW, vertical		GJN		3	-	20%	100%
P2B	W39.1, W39.2, W32.2	R, fillet vert, tr+long		GJN		4	50%	100%	100%
P2B	W30.1, W38.1	R, fillet vert., tr+side		GJN		3	-	20%	100%
P2B	W42.1	BW, long, pl.		GJN		5	100%	100%	100%
P2B	W55.1, W55.2	BW, long, pl.		GJN		5	100%	100%	100%
Bottom plate Welds									
P2B	W12.1, W12.2	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.15, W13.30	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.14, W13.29	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.13, W13.28	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.12, W13.27	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.11, W13.26	Laser Lap welds	GJN			2	-	10%	100%

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

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P2B	W13.10, W13.25	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.9, W13.24	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.8, W13.23	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.7, W13.22	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.6, W13.21	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.5, W13.20	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.4, W13.19	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.3, W13.18	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.2, W13.17	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W13.1, W13.16	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W14.1, W14.2, W14.3, W14.4	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W15.1, W15.2, W15.3, W15.4	2.08	Laser Lap welds	GJN			2	-	10%	100%
P2B	W16.1, W16.2, W16.3, W16.4	2.08	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P3B	W1.1	21.07	LH, BW top & top pl	MM			5	100%	100%	100%		
P3B	W1.2	21.07	LH, BW top & top pl	MM			5	100%	100%	100%		
P3B	W4.1	21.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P3B	W4.2	21.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P3B	W5.1	21.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P3B	W5.2	21.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P3B	W7.1, W6.1, W7.16	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.2, W6.2, W7.17	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.3, W6.3, W7.18	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.4, W6.4, W7.19	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.5, W6.5, W7.20	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.6, W6.6, W7.21	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.7, W6.7, W7.22	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.8, W6.8, W7.23	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.9, W6.9, W7.24	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.10, W6.10, W7.25	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.11, W6.11, W7.26	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.12, W6.12, W7.27	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.13, W6.13, W7.28	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.14, W6.14, W7.29	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.15, W6.15, W7.30	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.31, W6.16, W7.46	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.32, W6.17, W7.47	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.33, W6.18, W7.48	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.34, W6.19, W7.49	21.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.35, W6.20, W7.50	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.36, W6.21, W7.51	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.37, W6.22, W7.52	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.38, W6.23, W7.53	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.39, W6.24, W7.54	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.40, W6.25, W7.55	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.41, W6.26, W7.56	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.42, W6.27, W7.57	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.43, W6.28, W7.58	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P3B	W7.44, W6.29, W7.59	24.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		

P3B	W7.45, W6.30, W7.60	24.07	LH+R, FW, L profile		G.JN		5	-	20%	100%
P3B	W8.1	24.07	R, Fillet, Tr. +top pl	MM			3	-	20%	100%
P3B	W8.2	24.07	R, Fillet, Tr. +top pl	MM			3	-	20%	100%
P3B	W9.1	24.07	R, Fillet, Tr. +top pl	MM			3	-	20%	100%
P3B	W9.2	24.07	R, Fillet, Tr. +top pl	MM			3	-	20%	100%
P3B	W10.1	24.07	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P3B	W10.2	24.07	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P3B	W57.1, W31.1, W31.16, W57.16	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.2, W31.2, W31.17, W57.17	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.3, W31.3, W31.18, W57.18	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.4, W31.4, W31.19, W57.19	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.5, W31.5, W31.20, W57.20	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.6, W31.6, W31.21, W57.21	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.7, W31.7, W31.22, W57.22	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.8, W31.8, W31.23, W57.23	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.9, W31.9, W31.24, W57.24	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.10, W31.10, W31.25, W57.25	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.11, W31.11, W31.26, W57.26	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.12, W31.12, W31.27, W57.27	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.13, W31.13, W31.28, W57.28	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.14, W31.14, W31.29, W57.29	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W57.15, W31.15, W31.30, W57.30	24.07	R, FW, vertical		G.JN		3	-	20%	100%
P3B	W39.1, W39.2, W32.2	24.07	R, fillet vert. tr+long		G.JN		4	50%	100%	100%
P3B	W30.1, W38.1	24.07	R, fillet vert. tr+side		G.JN		3	-	20%	100%
P3B	W42.1	24.07	BW, long. pl.		G.JN		5	100%	100%	100%
P3B	W55.1, W55.2	24.07	BW, long. pl.		G.JN		5	100%	100%	100%
Bottom plate welds										
P3B	W12.1, W12.2	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.15, W13.30	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.14, W13.29	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.13, W13.28	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.12, W13.27	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.11, W13.26	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.10, W13.25	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.9, W13.24	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.8, W13.23	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.7, W13.22	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.6, W13.21	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.5, W13.20	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.4, W13.19	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.3, W13.18	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.2, W13.17	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W13.1, W13.16	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W14.1, W14.2, W14.3, W14.4	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W15.1, W15.2, W15.3, W15.4	1.08	Laser Lap welds		G.JN		2	-	10%	100%
P3B	W16.1, W16.2, W16.3, W16.4	1.08	Laser Lap welds		G.JN		2	-	10%	100%

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Manually						
P4B	W1.1	18.07	LH, BW, top & top pl	MM		5	100%	100%	100%		

P4B	W1.2	18.07	LH, BW, top & top pl	MM	GJN		5	100%	100%	100%
P4B	W4.1	18.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%
P4B	W4.2	18.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%
P4B	W5.1	18.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%
P4B	W5.2	18.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%
P4B	W7.1, W6.1, W7.16	18.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.2, W6.2, W7.17	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.3, W6.3, W7.18	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.4, W6.4, W7.19	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.5, W6.5, W7.20	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.6, W6.6, W7.21	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.7, W6.7, W7.22	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.8, W6.8, W7.23	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.9, W6.9, W7.24	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.10, W6.10, W7.25	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.11, W6.11, W7.26	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.12, W6.12, W7.27	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.13, W6.13, W7.28	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.14, W6.14, W7.29	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.15, W6.15, W7.30	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.31, W6.16, W7.46	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.32, W6.17, W7.47	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.33, W6.18, W7.48	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.34, W6.19, W7.49	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.35, W6.20, W7.50	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.36, W6.21, W7.51	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.37, W6.22, W7.52	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.38, W6.23, W7.53	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.39, W6.24, W7.54	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.40, W6.25, W7.55	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.41, W6.26, W7.56	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.42, W6.27, W7.57	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.43, W6.28, W7.58	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.44, W6.29, W7.59	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W7.45, W6.30, W7.60	19.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P4B	W8.1	20.07	R, Fillet, Tr. + top pl	MM			3	-	20%	100%
P4B	W8.2	20.07	R, Fillet, Tr. + top pl	MM			3	-	20%	100%
P4B	W9.1	20.07	R, Fillet, Tr. + top pl	MM			3	-	20%	100%
P4B	W9.2	20.07	R, Fillet, Tr. + top pl	MM			3	-	20%	100%
P4B	W10.1	20.07	LH, Fillet, Long pl	MM			5	-	100%	100%
P4B	W10.2	20.07	LH, Fillet, Long pl	MM			5	-	100%	100%
P4B	W57.1, W31.1, W31.16, W57.16	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.2, W31.2, W31.17, W57.17	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.3, W31.3, W31.18, W57.18	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.4, W31.4, W31.19, W57.19	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.5, W31.5, W31.20, W57.20	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.6, W31.6, W31.21, W57.21	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.7, W31.7, W31.22, W57.22	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.8, W31.8, W31.23, W57.23	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.9, W31.9, W31.24, W57.24	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.10, W31.10, W31.25, W57.25	20.07	R, FW, vertical		GJN		3	-	20%	100%
P4B	W57.11, W31.11, W31.26, W57.26	20.07	R, FW, vertical		GJN		3	-	20%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.



Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Comments
P4B	W57.12, W31.12, W31.27, W57.27	20.07	R, FW, vertical	GJN	3	-	20%	100%	
P4B	W57.13, W31.13, W31.28, W57.28	20.07	R, FW, vertical	GJN	3	-	20%	100%	
P4B	W57.14, W31.14, W31.29, W57.29	20.07	R, FW, vertical	GJN	3	-	20%	100%	
P4B	W57.15, W31.15, W31.30, W57.30	20.07	R, FW, vertical	GJN	3	-	20%	100%	
P4B	W39.1, W39.2, W32.2	20.07	R, fillet vert, lr+long	GJN	4	50%	100%	100%	
P4B	W30.1, W38.1	20.07	R, fillet vert, lr+side	GJN	3	-	20%	100%	
P4B	W42.1	20.07	BW, long, pl.	GJN	5	100%	100%	100%	
P4B	W55.1, W55.2	20.07	BW, long, pl.	GJN	5	100%	100%	100%	
<b>Bottom plate Welds</b>									
P4B	W12.1, W12.2	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.15, W13.30	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.14, W13.29	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.13, W13.28	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.12, W13.27	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.11, W13.26	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.10, W13.25	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.9, W13.24	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.8, W13.23	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.7, W13.22	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.6, W13.21	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.5, W13.20	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.4, W13.19	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.3, W13.18	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.2, W13.17	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W13.1, W13.16	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W14.1, W14.2, W14.3, W14.4	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W15.1, W15.2, W15.3, W15.4	1.08	Laser Lap welds	GJN	2	-	10%	100%	
P4B	W16.1, W16.2, W16.3, W16.4	1.08	Laser Lap welds	GJN	2	-	10%	100%	

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Manually						
P5B	W1.1	17.07	LH, BW, top & top pl	MM		5	100%	100%	100%		
P5B	W1.2	17.07	LH, BW, top & top pl	MM		5	100%	100%	100%		
P5B	W4.1	17.07	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P5B	W4.2	17.07	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P5B	W5.1	17.07	R, FW, side pl. h	MM	GJN	5	-	100%	100%		
P5B	W5.2	17.07	R, FW, side pl. h	MM	GJN	5	-	100%	100%		
P5B	W7.1, W6.1, W7.16	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.2, W6.2, W7.17	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.3, W6.3, W7.18	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.4, W6.4, W7.19	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.5, W6.5, W7.20	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.6, W6.6, W7.21	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.7, W6.7, W7.22	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.8, W6.8, W7.23	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.9, W6.9, W7.24	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.10, W6.10, W7.25	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.11, W6.11, W7.26	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.12, W6.12, W7.27	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P5B	W7.13, W6.13, W7.28	17.07	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		

P5B	W7.14, W6.14, W7.29	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.15, W6.15, W7.30	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.31, W6.16, W7.46	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.32, W6.17, W7.47	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.33, W6.18, W7.48	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.34, W6.19, W7.49	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.35, W6.20, W7.50	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.36, W6.21, W7.51	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.37, W6.22, W7.52	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.38, W6.23, W7.53	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.39, W6.24, W7.54	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.40, W6.25, W7.55	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.41, W6.26, W7.56	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.42, W6.27, W7.57	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.43, W6.28, W7.58	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.44, W6.29, W7.59	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W7.45, W6.30, W7.60	17.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P5B	W8.1	18.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P5B	W8.2	18.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P5B	W9.1	18.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P5B	W9.2	18.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P5B	W10.1	18.07	LH, Fillet, Long, pl.	MM			5	-	100%	100%
P5B	W10.2	18.07	LH, Fillet, Long, pl.	MM			5	-	100%	100%
P5B	W57.1, W31.1, W31.16, W57.16	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.2, W31.2, W31.17, W57.17	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.3, W31.3, W31.18, W57.18	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.4, W31.4, W31.19, W57.19	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.5, W31.5, W31.20, W57.20	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.6, W31.6, W31.21, W57.21	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.7, W31.7, W31.22, W57.22	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.8, W31.8, W31.23, W57.23	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.9, W31.9, W31.24, W57.24	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.10, W31.10, W31.25, W57.25	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.11, W31.11, W31.26, W57.26	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.12, W31.12, W31.27, W57.27	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.13, W31.13, W31.28, W57.28	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.14, W31.14, W31.29, W57.29	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W57.15, W31.15, W31.30, W57.30	18.07	R, FW, vertical		GJN		3	-	20%	100%
P5B	W39.1, W39.2, W32.2	18.07	R, fillet vert. tr+long		GJN		4	50%	100%	100%
P5B	W30.1, W38.1	18.07	R, fillet vert., tr+side		GJN		3	-	20%	100%
P5B	W42.1	18.07	BW, long, pl.		GJN		5	100%	100%	100%
P5B	W55.1, W55.2	18.07	BW, long, pl.		GJN		5	100%	100%	100%
Bottom plate Welds										
P5B	W12.1, W12.2	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.15, W13.30	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.14, W13.29	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.13, W13.28	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.12, W13.27	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.11, W13.26	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.10, W13.25	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.9, W13.24	29.07	Laser Lap welds	GJN			2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P5B	W13.8, W13.23	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.7, W13.22	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.6, W13.21	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.5, W13.20	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.4, W13.19	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.3, W13.18	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.2, W13.17	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W13.1, W13.16	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W14.1, W14.2, W14.3, W14.4	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W15.1, W15.2, W15.3, W15.4	29.07	Laser Lap welds	GJN			2	-	10%	100%
P5B	W16.1, W16.2, W16.3, W16.4	29.07	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P6A	W1.1	26.05	LH, BW, top & top pl	MM		WOC4146GDA3	5	100%	100%	100%		
P6A	W1.2	26.05	LH, BW, top & top pl	MM		WOC4146GDA3	5	100%	100%	100%		
P6A	W4.1	26.05	R-LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P6A	W4.2	26.05	R-LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P6A	W7.1, W6.1, W7.16	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.2, W6.2, W7.17	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.3, W6.3, W7.18	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.4, W6.4, W7.19	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.5, W6.5, W7.20	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.6, W6.6, W7.21	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.7, W6.7, W7.22	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.8, W6.8, W7.23	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.9, W6.9, W7.24	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.10, W6.10, W7.25	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.11, W6.11, W7.26	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.12, W6.12, W7.27	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.13, W6.13, W7.28	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.14, W6.14, W7.29	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.15, W6.15, W7.30	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.31, W6.16, W7.46	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.32, W6.17, W7.47	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.33, W6.18, W7.48	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.34, W6.19, W7.49	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.35, W6.20, W7.50	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.36, W6.21, W7.51	26.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.37, W6.22, W7.52	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.38, W6.23, W7.53	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.39, W6.24, W7.54	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.40, W6.25, W7.55	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.41, W6.26, W7.56	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.42, W6.27, W7.57	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.43, W6.28, W7.58	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.44, W6.29, W7.59	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W7.45, W6.30, W7.60	30.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%		
P6A	W8.1	30.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%		
P6A	W8.2	30.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%		
P6A	W9.1	30.05	LH, Fillet, Tr. +top pl	MM	GJN		5	-	20%	100%		
P6A	W9.2	30.05	LH, Fillet, Tr. +top pl	MM	GJN		5	-	20%	100%		

Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Registered doc.	Comments	
P6A	W10.1	30.05	LH, Fillet, Long, pl.	MM				100%		Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.	
P6A	W10.2	30.05	LH, Fillet, Long, pl.	MM				100%			
P6A	W10.3	30.05	LH, Fillet, Long, pl.	MM				100%			
P6A	W10.4	30.05	LH, Fillet, Long, pl.	MM				100%			
P6A	W57.1, W31.1, W31.16, W57.16	30.05	R, FW vertical	GJN				20%			
P6A	W57.2, W31.2, W31.17, W57.17	30.05	R, FW vertical	GJN				20%			
P6A	W57.3, W31.3, W31.18, W57.18	30.05	R, FW vertical	GJN				20%			
P6A	W57.4, W31.4, W31.19, W57.19	30.05	R, FW vertical	GJN				20%			
P6A	W57.5, W31.5, W31.20, W57.20	30.05	R, FW vertical	GJN				20%			
P6A	W57.6, W31.6, W31.21, W57.21	30.05	R, FW vertical	GJN				20%			
P6A	W57.7, W31.7, W31.22, W57.22	30.05	R, FW vertical	GJN				20%			
P6A	W57.8, W31.8, W31.23, W57.23	30.05	R, FW vertical	GJN				20%			
P6A	W57.9, W31.9, W31.24, W57.24	30.05	R, FW vertical	GJN				20%			
P6A	W57.10, W31.10, W31.25, W57.25	30.05	R, FW vertical	GJN				20%			
P6A	W57.11, W31.11, W31.26, W57.26	30.05	R, FW vertical	GJN				20%			
P6A	W57.12, W31.12, W31.27, W57.27	30.05	R, FW vertical	GJN				20%			
P6A	W57.13, W31.13, W31.28, W57.28	30.05	R, FW vertical	GJN				20%			
P6A	W57.14, W31.14, W31.29, W57.29	30.05	R, FW vertical	GJN				20%			
P6A	W57.15, W31.15, W31.30, W57.30	30.05	R, FW vertical	GJN				20%			
P6A	W39.1, W32.1	30.05	R, fillet vert., tr+side	GJN				20%			
P6A	W39.2, W39.3, W32.2, W32.3	30.05	R, fillet vert. tr+long	GJN	WOC4146GDA3	4	50%	100%			
P6A	W38.1, W30.1	30.05	R, fillet vertical, side	GJN				20%			
P6A	W42.1, W42.2	30.05	BW, long, pl.	GJN	WOC4146GDA3	5	100%	100%			
P6A	W55.1, W55.2	30.05	BW, side, pl.	GJN	WOC4146GDA3	5	100%	100%			
Bottom plate Welds											
P6A	W12.1, W12.2	1.06	Laser Lap welds	GJN				10%			
P6A	W13.15, W13.30	1.06	Laser Lap welds	GJN				10%			
P6A	W13.14, W13.29	1.06	Laser Lap welds	GJN				10%			
P6A	W13.13, W13.28	1.06	Laser Lap welds	GJN				10%			
P6A	W13.12, W13.27	1.06	Laser Lap welds	GJN				10%			
P6A	W13.11, W13.26	1.06	Laser Lap welds	GJN				10%			
P6A	W13.10, W13.25	1.06	Laser Lap welds	GJN				10%			
P6A	W13.9, W13.24	1.06	Laser Lap welds	GJN				10%			
P6A	W13.8, W13.23	1.06	Laser Lap welds	GJN				10%			
P6A	W13.7, W13.22	1.06	Laser Lap welds	GJN				10%			
P6A	W13.6, W13.21	1.06	Laser Lap welds	GJN				10%			
P6A	W13.5, W13.20	1.06	Laser Lap welds	GJN				10%			
P6A	W13.4, W13.19	1.06	Laser Lap welds	GJN				10%			
P6A	W13.3, W13.18	1.06	Laser Lap welds	GJN				10%			
P6A	W13.2, W13.17	1.06	Laser Lap welds	GJN				10%			
P6A	W13.1, W13.16	1.06	Laser Lap welds	GJN				10%			
P6A	W14.1, W14.4	1.06	Laser Lap welds	GJN				10%			
P6A	W14.2, W14.3, W14.5, W14.6	1.06	Laser Lap welds	GJN				10%			
P6A	W15.1, W15.2, W15.3, W15.4	1.06	Laser Lap welds	GJN				10%			
P6A	W16.1, W16.2, W16.3, W16.4	1.06	Laser Lap welds	GJN				10%			
SW											

Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Registered doc.	Comments
P7A	W1.1	25.05	LH, BW top & top pl	Manually WOC4146GDA3	5	100%	100%	100%		
P7A	W1.2	25.05	LH, BW top & top pl	WOC4146GDA3	5	100%	100%	100%		
P7A	W4.1	25.05	R+LH, FW, side pl, h	GJN	5	-	100%	100%		

PTA	W4.2	25.05	R+LH, FW L, side pl. h	MM	GJN		5	-	100%	100%
PTA	W7.1, W6.1, W7.16	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.2, W6.2, W7.17	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.3, W6.3, W7.18	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.4, W6.4, W7.19	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.5, W6.5, W7.20	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.6, W6.6, W7.21	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.7, W6.7, W7.22	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.8, W6.8, W7.23	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.9, W6.9, W7.24	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.10, W6.10, W7.25	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.11, W6.11, W7.26	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.12, W6.12, W7.27	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.13, W6.13, W7.28	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.14, W6.14, W7.29	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.15, W6.15, W7.30	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.31, W6.16, W7.46	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.32, W6.17, W7.47	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.33, W6.18, W7.48	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.34, W6.19, W7.49	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.35, W6.20, W7.50	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.36, W6.21, W7.51	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.37, W6.22, W7.52	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.38, W6.23, W7.53	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.39, W6.24, W7.54	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.40, W6.25, W7.55	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.41, W6.26, W7.56	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.42, W6.27, W7.57	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.43, W6.28, W7.58	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.44, W6.29, W7.59	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W7.45, W6.30, W7.60	25.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
PTA	W8.1	26.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
PTA	W8.2	26.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
PTA	W9.1	26.05	LH, Fillet, Tr. +top pl	MM	GJN		5	-	20%	100%
PTA	W9.2	26.05	LH, Fillet, Tr. +top pl	MM	GJN		5	-	20%	100%
PTA	W10.1	26.05	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
PTA	W10.2	26.05	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
PTA	W10.3	26.05	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
PTA	W10.4	26.05	LH, Fillet, Long. pl.	MM	GJN		5	-	100%	100%
PTA	W57.1, W31.1, W31.16, W57.16	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.2, W31.2, W31.17, W57.17	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.3, W31.3, W31.18, W57.18	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.4, W31.4, W31.19, W57.19	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.5, W31.5, W31.20, W57.20	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.6, W31.6, W31.21, W57.21	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.7, W31.7, W31.22, W57.22	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.8, W31.8, W31.23, W57.23	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.9, W31.9, W31.24, W57.24	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.10, W31.10, W31.25, W57.25	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.11, W31.11, W31.26, W57.26	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.12, W31.12, W31.27, W57.27	26.05	R, FW vertical	MM	GJN		3	-	20%	100%
PTA	W57.13, W31.13, W31.28, W57.28	26.05	R, FW vertical	MM	GJN		3	-	20%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P7A	W57.14, W31.14, W31.29, W57.29	26.05	R, FW vertical		GJN		3	-	20%	100%
P7A	W57.15, W31.15, W31.30, W57.30	26.05	R, FW vertical		GJN		3	-	20%	100%
P7A	W39.1, W32.1	26.05	R, fillet vert., Ir-side		GJN		3	-	20%	100%
P7A	W39.2, W39.3, W32.2, W32.3	26.05	R, fillet vert. Ir-long		GJN	WOC4146GDA3	4	50%	100%	100%
P7A	W38.1, W30.1	26.05	R, fillet vertical, side		GJN		3	-	20%	100%
P7A	W42.1, W42.2	26.05	BW, long, pl.		GJN	WOC4146GDA3	5	100%	100%	100%
P7A	W55.1, W55.2	26.05	BW, stde. pl.		GJN	WOC4146GDA3	5	100%	100%	100%
<b>Bottom plate Welds</b>										
P7A	W12.1, W12.2	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.15, W13.30	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.14, W13.29	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.13, W13.28	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.12, W13.27	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.11, W13.26	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.10, W13.25	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.9, W13.24	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.8, W13.23	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.7, W13.22	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.6, W13.21	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.5, W13.20	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.4, W13.19	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.3, W13.18	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.2, W13.17	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W13.1, W13.16	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W14.1, W14.4	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W14.2, W14.3, W14.5, W14.6	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W15.1, W15.2, W15.3, W15.4	1.06	Laser Lap welds		GJN		2	-	10%	100%
P7A	W16.1, W16.2, W16.3, W16.4	1.06	Laser Lap welds		GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P8A	W1.1	22.05	LH, BW top & top pl	MM		WOC4146GDA3	5	100%	100%	100%	
P8A	W1.2	22.05	LH, BW top & top pl	MM		WOC4146GDA3	5	100%	100%	100%	
P8A	W4.1	23.05	R+LH, FW, side pl. h	MM	GJN		5	-	100%	100%	
P8A	W4.2	23.05	R+LH, FW, side pl. h	MM	GJN		5	-	100%	100%	
P8A	W7.1, W6.1, W7.16	23.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.2, W6.2, W7.17	23.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.3, W6.3, W7.18	23.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.4, W6.4, W7.19	23.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.5, W6.5, W7.20	23.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.6, W6.6, W7.21	23.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.7, W6.7, W7.22	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.8, W6.8, W7.23	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.9, W6.9, W7.24	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.10, W6.10, W7.25	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.11, W6.11, W7.26	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.12, W6.12, W7.27	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.13, W6.13, W7.28	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.14, W6.14, W7.29	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.15, W6.15, W7.30	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P8A	W7.31, W6.16, W7.46	24.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	

P8A	W7.32, W6.17, W7.47	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.33, W6.18, W7.48	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.34, W6.19, W7.49	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.35, W6.20, W7.50	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.36, W6.21, W7.51	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.37, W6.22, W7.52	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.38, W6.23, W7.53	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.39, W6.24, W7.54	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.40, W6.25, W7.55	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.41, W6.26, W7.56	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.42, W6.27, W7.57	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.43, W6.28, W7.58	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.44, W6.29, W7.59	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W7.45, W6.30, W7.60	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8A	W8.1	24.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P8A	W8.2	24.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P8A	W9.1	24.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P8A	W9.2	24.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P8A	W10.1	24.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P8A	W10.2	24.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P8A	W10.3	24.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P8A	W10.4	24.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P8A	W57.1, W31.1, W31.16, W57.16	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.2, W31.2, W31.17, W57.17	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.3, W31.3, W31.18, W57.18	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.4, W31.4, W31.19, W57.19	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.5, W31.5, W31.20, W57.20	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.6, W31.6, W31.21, W57.21	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.7, W31.7, W31.22, W57.22	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.8, W31.8, W31.23, W57.23	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.9, W31.9, W31.24, W57.24	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.10, W31.10, W31.25, W57.25	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.11, W31.11, W31.26, W57.26	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.12, W31.12, W31.27, W57.27	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.13, W31.13, W31.28, W57.28	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.14, W31.14, W31.29, W57.29	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W57.15, W31.15, W31.30, W57.30	24.05	R, FW vertical	MM	GJN		3	-	20%	100%
P8A	W39.1, W32.1	24.05	R, fillet vert. tr+side	MM	GJN		3	-	20%	100%
P8A	W39.2, W39.3, W32.2, W32.3	24.05	R, fillet vert. tr+long	MM	GJN	QC4146GDA2	4	50%	100%	100%
P8A	W38.1, W30.1	24.05	R, fillet vertical, side	MM	GJN		3	-	20%	100%
P8A	W42.1, W42.2	24.05	R, M, BW, long pl.	MM	GJN	QC4146GDA2	5	100%	100%	100%
P8A	W55.1, W55.2	24.05	R, M, BW, side pl.	MM	GJN	QC4146GDA3	5	100%	100%	100%
Bottom plate Welds										
P8A	W12.1, W12.2	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.15, W13.30	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.14, W13.29	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.13, W13.28	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.12, W13.27	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.11, W13.26	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.10, W13.25	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.9, W13.24	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.8, W13.23	1.06	Laser Lap welds	GJN			2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P8A	W13.7, W13.22	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.6, W13.21	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.5, W13.20	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.4, W13.19	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.3, W13.18	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.2, W13.17	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W13.1, W13.16	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W14.1, W14.4	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W14.2, W14.3, W14.5, W14.6	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W15.1, W15.2, W15.3, W15.4	1.06	Laser Lap welds	GJN			2	-	10%	100%
P8A	W16.1, W16.2, W16.3, W16.4	1.06	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P9A	W1.1	22.05	LH, BW top & top pl	MM		WQC4146GDA2	5	100%	100%		
P9A	W1.2	22.05	LH, BW top & top pl	MM		WQC4146GDA2	5	100%	100%		
P9A	W4.1	22.05	R-LH, FW, side pl. h	MM	GJN		5	-	100%	100%	
P9A	W4.2	22.05	R-LH, FW1, side pl. h	MM	GJN		5	-	100%	100%	
P9A	W7.1, W6.1, W7.16	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.2, W6.2, W7.17	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.3, W6.3, W7.18	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.4, W6.4, W7.19	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.5, W6.5, W7.20	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.6, W6.6, W7.21	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.7, W6.7, W7.22	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.8, W6.8, W7.23	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.9, W6.9, W7.24	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.10, W6.10, W7.25	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.11, W6.11, W7.26	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.12, W6.12, W7.27	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.13, W6.13, W7.28	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.14, W6.14, W7.29	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.15, W6.15, W7.30	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.31, W6.16, W7.46	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.32, W6.17, W7.47	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.33, W6.18, W7.48	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.34, W6.19, W7.49	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.35, W6.20, W7.50	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.36, W6.21, W7.51	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.37, W6.22, W7.52	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.38, W6.23, W7.53	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.39, W6.24, W7.54	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.40, W6.25, W7.55	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.41, W6.26, W7.56	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.42, W6.27, W7.57	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.43, W6.28, W7.58	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.44, W6.29, W7.59	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W7.45, W6.30, W7.60	22.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P9A	W8.1	23.05	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%	
P9A	W8.2	23.05	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%	
P9A	W9.1	23.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%	



Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Registered doc.	Comments	
P10A	W1.1	19.05	LH, BW top & top.pl	Laser	MM						
P9A	W9.2	23.05	LH, Fillet, Tr. +top.pl	MM						Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.	
P9A	W10.1	23.05	LH, Fillet, Long.pl	MM							
P9A	W10.2	23.05	LH, Fillet, Long.pl	MM							
P9A	W10.3	23.05	LH, Fillet, Long.pl	MM							
P9A	W10.4	23.05	LH, Fillet, Long.pl	MM							
P9A	W57.1, W31.1, W31.16, W57.16	23.05	R, FW vertical	GJN							
P9A	W57.2, W31.2, W31.17, W57.17	23.05	R, FW vertical	GJN							
P9A	W57.3, W31.3, W31.18, W57.18	23.05	R, FW vertical	GJN							
P9A	W57.4, W31.4, W31.19, W57.19	23.05	R, FW vertical	GJN							
P9A	W57.5, W31.5, W31.20, W57.20	23.05	R, FW vertical	GJN							
P9A	W57.6, W31.6, W31.21, W57.21	23.05	R, FW vertical	GJN							
P9A	W57.7, W31.7, W31.22, W57.22	23.05	R, FW vertical	GJN							
P9A	W57.8, W31.8, W31.23, W57.23	23.05	R, FW vertical	GJN							
P9A	W57.9, W31.9, W31.24, W57.24	23.05	R, FW vertical	GJN							
P9A	W57.10, W31.10, W31.25, W57.25	23.05	R, FW vertical	GJN							
P9A	W57.11, W31.11, W31.26, W57.26	23.05	R, FW vertical	GJN							
P9A	W57.12, W31.12, W31.27, W57.27	23.05	R, FW vertical	GJN							
P9A	W57.13, W31.13, W31.28, W57.28	23.05	R, FW vertical	GJN							
P9A	W57.14, W31.14, W31.29, W57.29	23.05	R, FW vertical	GJN							
P9A	W57.15, W31.15, W31.30, W57.30	23.05	R, FW vertical	GJN							
P9A	W39.1, W32.1	23.05	R, fillet vert., tr+side	GJN							
P9A	W39.2, W39.3, W32.2, W32.3	23.05	R, fillet vert. tr+long	GJN	WQC4146GDA3	50%					
P9A	W38.1, W30.1	23.05	R, fillet vertical, side	GJN							
P9A	W42.1, W42.2	23.05	BW, long.pl.	GJN	WQC4146GDA3	5	100%	100%			
P9A	W55.1, W55.2	23.05	BW, side.pl.	GJN	WQC4146GDA3	5	100%	100%			
Bottom plate Welds											
P9A	W12.1, W12.2	31.05	Laser Lap welds	GJN							
P9A	W13.15, W13.30	31.05	Laser Lap welds	GJN							
P9A	W13.14, W13.29	31.05	Laser Lap welds	GJN							
P9A	W13.13, W13.28	31.05	Laser Lap welds	GJN							
P9A	W13.12, W13.27	31.05	Laser Lap welds	GJN							
P9A	W13.11, W13.26	31.05	Laser Lap welds	GJN							
P9A	W13.10, W13.25	31.05	Laser Lap welds	GJN							
P9A	W13.9, W13.24	31.05	Laser Lap welds	GJN							
P9A	W13.8, W13.23	31.05	Laser Lap welds	GJN							
P9A	W13.7, W13.22	31.05	Laser Lap welds	GJN							
P9A	W13.6, W13.21	31.05	Laser Lap welds	GJN							
P9A	W13.5, W13.20	31.05	Laser Lap welds	GJN							
P9A	W13.4, W13.19	31.05	Laser Lap welds	GJN							
P9A	W13.3, W13.18	31.05	Laser Lap welds	GJN							
P9A	W13.2, W13.17	31.05	Laser Lap welds	GJN							
P9A	W13.1, W13.16	31.05	Laser Lap welds	GJN							
P9A	W14.1, W14.4	31.05	Laser Lap welds	GJN							
P9A	W14.2, W14.3, W14.5, W14.6	31.05	Laser Lap welds	GJN							
P9A	W15.1, W15.2, W15.3, W15.4	31.05	Laser Lap welds	GJN							
P9A	W16.1, W16.2, W16.3, W16.4	31.05	Laser Lap welds	GJN							

Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Registered doc.	Comments
P10A	W1.1	19.05	LH, BW top & top.pl	Laser	MM					
				Robot						
				Manually	WQC4146GDA3	5	100%	100%		



P10A	W57.12, W31.12, W31.27, W57.27	22.05	R, FW vertical		GJN		3	-	20%	100%
P10A	W57.13, W31.13, W31.28, W57.28	22.05	R, FW vertical		GJN		3	-	20%	100%
P10A	W57.14, W31.14, W31.29, W57.29	22.05	R, FW vertical		GJN		3	-	20%	100%
P10A	W57.15, W31.15, W31.30, W57.30	22.05	R, FW vertical		GJN		3	-	20%	100%
P10A	W39.1, W32.1	22.05	R, fillet vert., Ir+side		GJN		3	-	20%	100%
P10A	W39.2, W39.3, W32.2, W32.3	22.05	R, fillet vert. Ir+long		GJN	IOC4146GDA3	4	50%	100%	100%
P10A	W38.1, W30.1	22.05	R, fillet vertical, side		GJN		3	-	20%	100%
P10A	W42.1, W42.2	22.05	BW, long, pl.		GJN	IOC4146GDA3	5	100%	100%	100%
P10A	W55.1, W55.2	22.05	BW, side, pl.		GJN	IOC4146GDA3	5	100%	100%	100%
Bottom plate Welds										
P10A	W12.1, W12.2	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.15, W13.30	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.14, W13.29	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.13, W13.28	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.12, W13.27	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.11, W13.26	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.10, W13.25	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.9, W13.24	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.8, W13.23	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.7, W13.22	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.6, W13.21	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.5, W13.20	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.4, W13.19	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.3, W13.18	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.2, W13.17	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W13.1, W13.16	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W14.1, W14.4	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W14.2, W14.3, W14.5, W14.6	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W15.1, W15.2, W15.3, W15.4	31.05	Laser Lap welds		GJN		2	-	10%	100%
P10A	W16.1, W16.2, W16.3, W16.4	31.05	Laser Lap welds		GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P6B	W1.1	7.07	LH, BW top & top pl	MM			5	100%	100%	100%		
P6B	W1.2	7.07	LH, BW top & top pl	MM			5	100%	100%	100%		
P6B	W4.1	13.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P6B	W4.2	13.07	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P6B	W5.1	13.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P6B	W5.2	13.07	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P6B	W7.1, W6.1, W7.16	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.2, W6.2, W7.17	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.3, W6.3, W7.18	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.4, W6.4, W7.19	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.5, W6.5, W7.20	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.6, W6.6, W7.21	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.7, W6.7, W7.22	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.8, W6.8, W7.23	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.9, W6.9, W7.24	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.10, W6.10, W7.25	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.11, W6.11, W7.26	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P6B	W7.12, W6.12, W7.27	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		

P6B	W7.13, W6.13, W7.28	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.14, W6.14, W7.29	13.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.15, W6.15, W7.30	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.31, W6.16, W7.46	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.32, W6.17, W7.47	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.33, W6.18, W7.48	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.34, W6.19, W7.49	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.35, W6.20, W7.50	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.36, W6.21, W7.51	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.37, W6.22, W7.52	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.38, W6.23, W7.53	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.39, W6.24, W7.54	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.40, W6.25, W7.55	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.41, W6.26, W7.56	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.42, W6.27, W7.57	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.43, W6.28, W7.58	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.44, W6.29, W7.59	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W7.45, W6.30, W7.60	14.07	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P6B	W8.1	14.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P6B	W8.2	14.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P6B	W9.1	14.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P6B	W9.2	14.07	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P6B	W10.1	14.07	LH, Fillet, Long, pl	MM			5	-	100%	100%
P6B	W10.2	14.07	LH, Fillet, Long, pl	MM			5	-	100%	100%
P6B	W57.1, W31.1, W31.16, W57.16	14.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.2, W31.2, W31.17, W57.17	14.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.3, W31.3, W31.18, W57.18	14.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.4, W31.4, W31.19, W57.19	14.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.5, W31.5, W31.20, W57.20	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.6, W31.6, W31.21, W57.21	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.7, W31.7, W31.22, W57.22	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.8, W31.8, W31.23, W57.23	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.9, W31.9, W31.24, W57.24	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.10, W31.10, W31.25, W57.25	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.11, W31.11, W31.26, W57.26	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.12, W31.12, W31.27, W57.27	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.13, W31.13, W31.28, W57.28	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.14, W31.14, W31.29, W57.29	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W57.15, W31.15, W31.30, W57.30	15.07	R, FW, vertical	MM	GJN		3	-	20%	100%
P6B	W39.1, W39.2, W32.2	15.07	R, fillet vert, lr+long	MM	GJN		4	50%	100%	100%
P6B	W30.1, W38.1	15.07	R, fillet vert, lr+side	MM	GJN		3	-	20%	100%
P6B	W42.1	15.07	BW, long, pl	MM	GJN		5	100%	100%	100%
P6B	W55.1, W55.2	15.07	BW, long, pl	MM	GJN		5	100%	100%	100%
Bottom plate Welds										
P6B	W12.1, W12.2	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.15, W13.30	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.14, W13.29	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.13, W13.28	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.12, W13.27	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.11, W13.26	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.10, W13.25	16.06	Laser Lap welds	GJN			2	-	10%	100%
P6B	W13.9, W13.24	16.06	Laser Lap welds	GJN			2	-	10%	100%

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

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P6B	W13.8, W13.23	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.7, W13.22	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.6, W13.21	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.5, W13.20	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.4, W13.19	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.3, W13.18	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.2, W13.17	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W13.1, W13.16	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W14.1, W14.2, W14.3, W14.4	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W15.1, W15.2, W15.3, W15.4	16.06	Laser Lap welds	GJN		2	-	10%	100%
P6B	W16.1, W16.2, W16.3, W16.4	16.06	Laser Lap welds	GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P7B	W1.1	6.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P7B	W1.2	6.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P7B	W4.1	12.06	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P7B	W4.2	12.06	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P7B	W5.1	12.06	R, FW, side pl. h	MM	GJN	5	-	100%	100%		
P7B	W5.2	12.06	R, FW, side pl. h	MM	GJN	5	-	100%	100%		
P7B	W7.1, W6.1, W7.16	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.2, W6.2, W7.17	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.3, W6.3, W7.18	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.4, W6.4, W7.19	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.5, W6.5, W7.20	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.6, W6.6, W7.21	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.7, W6.7, W7.22	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.8, W6.8, W7.23	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.9, W6.9, W7.24	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.10, W6.10, W7.25	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.11, W6.11, W7.26	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.12, W6.12, W7.27	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.13, W6.13, W7.28	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.14, W6.14, W7.29	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.15, W6.15, W7.30	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.31, W6.16, W7.46	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.32, W6.17, W7.47	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.33, W6.18, W7.48	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.34, W6.19, W7.49	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.35, W6.20, W7.50	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.36, W6.21, W7.51	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.37, W6.22, W7.52	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.38, W6.23, W7.53	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.39, W6.24, W7.54	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.40, W6.25, W7.55	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.41, W6.26, W7.56	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.42, W6.27, W7.57	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.43, W6.28, W7.58	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.44, W6.29, W7.59	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W7.45, W6.30, W7.60	12.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P7B	W8.1	13.06	R, Fillet, Tr, +top pl	MM		3	-	20%	100%		

P7B	W8.2	13.06	R, Fillet, Tr, +top pl	MM		3	-	20%	100%
P7B	W9.1	13.06	R, Fillet, Tr, +top pl	MM		3	-	20%	100%
P7B	W9.2	13.06	R, Fillet, Tr, +top pl	MM		3	-	20%	100%
P7B	W10.1	13.06	LH, Fillet, Long, pl.	MM		5	-	100%	100%
P7B	W10.2	13.06	LH, Fillet, Long, pl.	MM		5	-	100%	100%
P7B	W57.1, W31.1, W31.16, W57.16	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.2, W31.2, W31.17, W57.17	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.3, W31.3, W31.18, W57.18	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.4, W31.4, W31.19, W57.19	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.5, W31.5, W31.20, W57.20	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.6, W31.6, W31.21, W57.21	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.7, W31.7, W31.22, W57.22	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.8, W31.8, W31.23, W57.23	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.9, W31.9, W31.24, W57.24	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.10, W31.10, W31.25, W57.25	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.11, W31.11, W31.26, W57.26	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.12, W31.12, W31.27, W57.27	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.13, W31.13, W31.28, W57.28	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.14, W31.14, W31.29, W57.29	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W57.15, W31.15, W31.30, W57.30	13.06	R, FW, vertical	GJN		3	-	20%	100%
P7B	W39.1, W39.2, W32.2	13.06	R, fillet vert, tr+long	GJN		4	50%	100%	100%
P7B	W30.1, W38.1	13.06	R, fillet vert, tr+side	GJN		3	-	20%	100%
P7B	W42.1	13.06	BW, long, pl.	GJN		5	100%	100%	100%
P7B	W55.1, W55.2	13.06	BW, long, pl.	GJN		5	100%	100%	100%
Bottom plate Welds									
P7B	W12.1, W12.2	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.15, W13.30	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.14, W13.29	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.13, W13.28	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.12, W13.27	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.11, W13.26	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.10, W13.25	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.9, W13.24	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.8, W13.23	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.7, W13.22	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.6, W13.21	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.5, W13.20	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.4, W13.19	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.3, W13.18	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.2, W13.17	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W13.1, W13.16	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W14.1, W14.2, W14.3, W14.4	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W15.1, W15.2, W15.3, W15.4	16.06	Laser Lap welds	GJN		2	-	10%	100%
P7B	W16.1, W16.2, W16.3, W16.4	16.06	Laser Lap welds	GJN		2	-	10%	100%

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P8B	W1.1	5.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P8B	W1.2	5.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P8B	W4.1	8.06	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P8B	W4.2	8.06	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		

P8B	W5.1	8.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%
P8B	W5.2	8.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%
P8B	W7.1, W6.1, W7.16	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.2, W6.2, W7.17	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.3, W6.3, W7.18	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.4, W6.4, W7.19	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.5, W6.5, W7.20	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.6, W6.6, W7.21	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.7, W6.7, W7.22	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.8, W6.8, W7.23	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.9, W6.9, W7.24	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.10, W6.10, W7.25	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.11, W6.11, W7.26	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.12, W6.12, W7.27	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.13, W6.13, W7.28	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.14, W6.14, W7.29	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.15, W6.15, W7.30	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.31, W6.16, W7.46	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.32, W6.17, W7.47	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.33, W6.18, W7.48	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.34, W6.19, W7.49	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.35, W6.20, W7.50	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.36, W6.21, W7.51	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.37, W6.22, W7.52	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.38, W6.23, W7.53	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.39, W6.24, W7.54	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.40, W6.25, W7.55	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.41, W6.26, W7.56	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.42, W6.27, W7.57	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.43, W6.28, W7.58	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.44, W6.29, W7.59	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W7.45, W6.30, W7.60	8.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P8B	W8.1	9.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P8B	W8.2	9.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P8B	W9.1	9.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P8B	W9.2	9.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P8B	W10.1	9.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P8B	W10.2	9.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P8B	W57.1, W31.1, W31.16, W57.16	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.2, W31.2, W31.17, W57.17	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.3, W31.3, W31.18, W57.18	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.4, W31.4, W31.19, W57.19	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.5, W31.5, W31.20, W57.20	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.6, W31.6, W31.21, W57.21	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.7, W31.7, W31.22, W57.22	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.8, W31.8, W31.23, W57.23	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.9, W31.9, W31.24, W57.24	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.10, W31.10, W31.25, W57.25	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.11, W31.11, W31.26, W57.26	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.12, W31.12, W31.27, W57.27	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.13, W31.13, W31.28, W57.28	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P8B	W57.14, W31.14, W31.29, W57.29	9.06	R, FW, vertical	MM	GJN		3	-	20%	100%

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Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P8B	W57.15, W31.15, W31.30, W57.30	9.06	R, FW, vertical		GJN	3	-	20%	100%
P8B	W39.1, W39.2, W32.2	9.06	R, fillet vert. tr+long		GJN	4	50%	100%	100%
P8B	W30.1, W38.1	9.06	R, fillet vert., tr+side		GJN	3	-	20%	100%
P8B	W42.1	9.06	BW, long, pl.		GJN	5	100%	100%	100%
P8B	W55.1, W55.2	9.06	BW, long, pl.		GJN	5	100%	100%	100%
<b>Bottom plate welds</b>									
P8B	W12.1, W12.2	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.15, W13.30	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.14, W13.29	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.13, W13.28	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.12, W13.27	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.11, W13.26	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.10, W13.25	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.9, W13.24	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.8, W13.23	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.7, W13.22	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.6, W13.21	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.5, W13.20	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.4, W13.19	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.3, W13.18	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.2, W13.17	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W13.1, W13.16	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W14.1, W14.2, W14.3, W14.4	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W15.1, W15.2, W15.3, W15.4	15.06	Laser Lap welds		GJN	2	-	10%	100%
P8B	W16.1, W16.2, W16.3, W16.4	15.06	Laser Lap welds		GJN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P9B	W1.1	2.06	LH, BW, top & top pl	MM			5	100%	100%	100%		
P9B	W1.2	2.06	LH, BW, top & top pl	MM			5	100%	100%	100%		
P9B	W4.1	6.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P9B	W4.2	6.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P9B	W5.1	6.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P9B	W5.2	6.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P9B	W7.1, W6.1, W7.16	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.2, W6.2, W7.17	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.3, W6.3, W7.18	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.4, W6.4, W7.19	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.5, W6.5, W7.20	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.6, W6.6, W7.21	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.7, W6.7, W7.22	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.8, W6.8, W7.23	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.9, W6.9, W7.24	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.10, W6.10, W7.25	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.11, W6.11, W7.26	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.12, W6.12, W7.27	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.13, W6.13, W7.28	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.14, W6.14, W7.29	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.15, W6.15, W7.30	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.31, W6.16, W7.46	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.32, W6.17, W7.47	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P9B	W7.33, W6.18, W7.48	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		



P9B	W7.34, W6.19, W7.49	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.35, W6.20, W7.50	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.36, W6.21, W7.51	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.37, W6.22, W7.52	6.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.38, W6.23, W7.53	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.39, W6.24, W7.54	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.40, W6.25, W7.55	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.41, W6.26, W7.56	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.42, W6.27, W7.57	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.43, W6.28, W7.58	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.44, W6.29, W7.59	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W7.45, W6.30, W7.60	7.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P9B	W8.1	7.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P9B	W8.2	7.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P9B	W9.1	7.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P9B	W9.2	7.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P9B	W10.1	7.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P9B	W10.2	7.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P9B	W57.1, W31.1, W31.16, W57.16	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.2, W31.2, W31.17, W57.17	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.3, W31.3, W31.18, W57.18	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.4, W31.4, W31.19, W57.19	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.5, W31.5, W31.20, W57.20	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.6, W31.6, W31.21, W57.21	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.7, W31.7, W31.22, W57.22	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.8, W31.8, W31.23, W57.23	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.9, W31.9, W31.24, W57.24	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.10, W31.10, W31.25, W57.25	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.11, W31.11, W31.26, W57.26	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.12, W31.12, W31.27, W57.27	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.13, W31.13, W31.28, W57.28	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.14, W31.14, W31.29, W57.29	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W57.15, W31.15, W31.30, W57.30	7.06	R, FW, vertical		GJN		3	-	20%	100%
P9B	W39.1, W39.2, W32.2	7.06	R, fillet vert, tr+long		GJN		4	50%	100%	100%
P9B	W30.1, W38.1	7.06	R, fillet vert., tr+side		GJN		3	-	20%	100%
P9B	W42.1	7.06	BW, long, pl.		GJN		5	100%	100%	100%
P9B	W55.1, W55.2	7.06	BW, long, pl.		GJN		5	100%	100%	100%
Bottom plate Welds										
P9B	W12.1, W12.2	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.15, W13.30	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.14, W13.29	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.13, W13.28	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.12, W13.27	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.11, W13.26	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.10, W13.25	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.9, W13.24	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.8, W13.23	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.7, W13.22	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.6, W13.21	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.5, W13.20	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.4, W13.19	15.06	Laser Lap welds		GJN		2	-	10%	100%
P9B	W13.3, W13.18	15.06	Laser Lap welds		GJN		2	-	10%	100%

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P9B	W13.2, W13.17	15.06	Laser Lap welds	GJN		2	-	10%	100%
P9B	W13.1, W13.16	15.06	Laser Lap welds	GJN		2	-	10%	100%
P9B	W14.1, W14.2, W14.3, W14.4	15.06	Laser Lap welds	GJN		2	-	10%	100%
P9B	W15.1, W15.2, W15.3, W15.4	15.06	Laser Lap welds	GJN		2	-	10%	100%
P9B	W16.1, W16.2, W16.3, W16.4	15.06	Laser Lap welds	GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P10B	W1.1	2.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P10B	W1.2	2.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P10B	W4.1	2.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P10B	W4.2	2.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P10B	W5.1	2.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P10B	W5.2	2.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P10B	W7.1, W6.1, W7.16	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.2, W6.2, W7.17	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.3, W6.3, W7.18	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.4, W6.4, W7.19	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.5, W6.5, W7.20	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.6, W6.6, W7.21	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.7, W6.7, W7.22	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.8, W6.8, W7.23	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.9, W6.9, W7.24	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.10, W6.10, W7.25	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.11, W6.11, W7.26	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.12, W6.12, W7.27	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.13, W6.13, W7.28	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.14, W6.14, W7.29	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.15, W6.15, W7.30	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.31, W6.16, W7.46	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.32, W6.17, W7.47	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.33, W6.18, W7.48	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.34, W6.19, W7.49	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.35, W6.20, W7.50	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.36, W6.21, W7.51	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.37, W6.22, W7.52	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.38, W6.23, W7.53	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.39, W6.24, W7.54	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.40, W6.25, W7.55	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.41, W6.26, W7.56	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.42, W6.27, W7.57	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.43, W6.28, W7.58	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.44, W6.29, W7.59	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W7.45, W6.30, W7.60	2.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P10B	W8.1	5.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P10B	W8.2	5.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P10B	W9.1	5.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P10B	W9.2	5.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P10B	W10.1	5.06	LH, Fillet, Long, pl	MM			5	-	100%	100%		
P10B	W10.2	5.06	LH, Fillet, Long, pl	MM			5	-	100%	100%		
P10B	W57.1, W31.1, W31.16, W57.16	5.06	R, FW, vertical	MM	GJN		3	-	20%	100%		
P10B	W57.2, W31.2, W31.17, W57.17	5.06	R, FW, vertical	MM	GJN		3	-	20%	100%		

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

Bottom plate welds										
Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Comments
				Laser	Robot	Manually				
P10B	W57.3, W31.3, W31.18, W57.18	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.4, W31.4, W31.19, W57.19	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.5, W31.5, W31.20, W57.20	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.6, W31.6, W31.21, W57.21	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.7, W31.7, W31.22, W57.22	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.8, W31.8, W31.23, W57.23	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.9, W31.9, W31.24, W57.24	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.10, W31.10, W31.25, W57.25	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.11, W31.11, W31.26, W57.26	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.12, W31.12, W31.27, W57.27	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.13, W31.13, W31.28, W57.28	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.14, W31.14, W31.29, W57.29	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W57.15, W31.15, W31.30, W57.30	5.06	R, FW, vertical		GJN		3	-	20%	100%
P10B	W39.1, W39.2, W32.2	5.06	R, fillet vert, lr+long		GJN		4	50%	100%	100%
P10B	W30.1, W38.1	5.06	R, fillet vert, lr+side		GJN		3	-	20%	100%
P10B	W42.1	5.06	BW, long, pl.		GJN		5	100%	100%	100%
P10B	W55.1, W55.2	5.06	BW, long, pl.		GJN		5	100%	100%	100%
P10B	W56.1, W56.2	5.06	BW, long, pl.		GJN		5	100%	100%	100%
P10B	W12.1, W12.2	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.15, W13.30	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.14, W13.29	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.13, W13.28	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.12, W13.27	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.11, W13.26	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.10, W13.25	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.9, W13.24	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.8, W13.23	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.7, W13.22	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.6, W13.21	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.5, W13.20	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.4, W13.19	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.3, W13.18	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.2, W13.17	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W13.1, W13.16	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W14.1, W14.2, W14.3, W14.4	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W15.1, W15.2, W15.3, W15.4	14.06	Laser Lap welds		GJN		2	-	10%	100%
P10B	W16.1, W16.2, W16.3, W16.4	14.06	Laser Lap welds		GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Comments
				Laser	Robot	Manually				
P11A	W1.1	22.05	LH, BW, top & top pl	MM			5	100%	100%	100%
P11A	W1.2	22.05	LH, BW, top & top pl	MM			5	100%	100%	100%
P11A	W4.1	22.05	R+LH, FW, side pl, h	MM	GJN		5	-	100%	100%
P11A	W4.2	22.05	R+LH, FW, side pl, h	MM	GJN		5	-	100%	100%
P11A	W7.1, W6.1, W7.16	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.2, W6.2, W7.17	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.3, W6.3, W7.18	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.4, W6.4, W7.19	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.5, W6.5, W7.20	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.6, W6.6, W7.21	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%

P11A	W7.7, W6.7, W7.22	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.8, W6.8, W7.23	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.9, W6.9, W7.24	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.10, W6.10, W7.25	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.11, W6.11, W7.26	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.12, W6.12, W7.27	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.13, W6.13, W7.28	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.14, W6.14, W7.29	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.15, W6.15, W7.30	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.31, W6.16, W7.46	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.32, W6.17, W7.47	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.33, W6.18, W7.48	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.34, W6.19, W7.49	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.35, W6.20, W7.50	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.36, W6.21, W7.51	22.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.37, W6.22, W7.52	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.38, W6.23, W7.53	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.39, W6.24, W7.54	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.40, W6.25, W7.55	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.41, W6.26, W7.56	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.42, W6.27, W7.57	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.43, W6.28, W7.58	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.44, W6.29, W7.59	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W7.45, W6.30, W7.60	24.05	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P11A	W8.1	24.05	R, Fillet, Tr, +top pl	MM	GJN		3	-	20%	100%
P11A	W8.2	24.05	R, Fillet, Tr, +top pl	MM	GJN		3	-	20%	100%
P11A	W9.1	24.05	LH, Fillet, Tr, +top pl	MM	GJN		5	-	20%	100%
P11A	W9.2	24.05	LH, Fillet, Tr, +top pl	MM	GJN		5	-	20%	100%
P11A	W10.1	24.05	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P11A	W10.2	24.05	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P11A	W10.3	24.05	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P11A	W10.4	24.05	LH, Fillet, Long, pl.	MM	GJN		5	-	100%	100%
P11A	W57.1, W31.1, W31.16, W57.16	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.2, W31.2, W31.17, W57.17	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.3, W31.3, W31.18, W57.18	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.4, W31.4, W31.19, W57.19	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.5, W31.5, W31.20, W57.20	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.6, W31.6, W31.21, W57.21	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.7, W31.7, W31.22, W57.22	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.8, W31.8, W31.23, W57.23	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.9, W31.9, W31.24, W57.24	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.10, W31.10, W31.25, W57.25	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.11, W31.11, W31.26, W57.26	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.12, W31.12, W31.27, W57.27	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.13, W31.13, W31.28, W57.28	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.14, W31.14, W31.29, W57.29	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W57.15, W31.15, W31.30, W57.30	25.05	R, FW vertical	MM	GJN		3	-	20%	100%
P11A	W39.1, W32.1	25.05	R, fillet vert., Ir+side	MM	GJN		3	-	20%	100%
P11A	W39.2, W32.2, W32.3	25.05	R, fillet vert., Ir+long	MM	GJN		4	50%	100%	100%
P11A	W38.1, W30.1	25.05	R, fillet vertical, side	MM	GJN		3	-	20%	100%
P11A	W42.1, W42.2	25.05	BW, long, pl.	MM	GJN		5	100%	100%	100%
P11A	W55.1, W55.2	25.05	BW, side, pl.	MM	GJN		5	100%	100%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

Bottom plate welds

Section	Welding no.	Date	Type of weld	Welder/Operator ID	WIC	UT	MT/PT	VT	Comments
P11A	W12.1, W12.2	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.15, W13.30	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.14, W13.29	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.13, W13.28	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.12, W13.27	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.11, W13.26	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.10, W13.25	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.9, W13.24	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.8, W13.23	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.7, W13.22	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.6, W13.21	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.5, W13.20	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.4, W13.19	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.3, W13.18	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.2, W13.17	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W13.1, W13.16	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W14.1, W14.4	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W14.2, W14.3, W14.5, W14.6	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W15.1, W15.2, W15.3, W15.4	30.05	Laser Lap welds	GJN	2	-	10%	100%	
P11A	W16.1, W16.2, W16.3, W16.4	30.05	Laser Lap welds	GJN	2	-	10%	100%	

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P12A	W1.1	12.05	LH, BW top & top pl	MM		5	100%	100%	100%		
P12A	W1.2	12.05	LH, BW top & top pl	MM		5	100%	100%	100%		
P12A	W4.1	12.05	R+LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P12A	W4.2	12.05	R+LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P12A	W7.1, W6.1, W7.16	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.2, W6.2, W7.17	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.3, W6.3, W7.18	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.4, W6.4, W7.19	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.5, W6.5, W7.20	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.6, W6.6, W7.21	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.7, W6.7, W7.22	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.8, W6.8, W7.23	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.9, W6.9, W7.24	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.10, W6.10, W7.25	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.11, W6.11, W7.26	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.12, W6.12, W7.27	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.13, W6.13, W7.28	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.14, W6.14, W7.29	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.15, W6.15, W7.30	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.31, W6.16, W7.46	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.32, W6.17, W7.47	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.33, W6.18, W7.48	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.34, W6.19, W7.49	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.35, W6.20, W7.50	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.36, W6.21, W7.51	12.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.37, W6.22, W7.52	15.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P12A	W7.38, W6.23, W7.53	15.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		

P12A	W7.39, W6.24, W7.54	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W7.40, W6.25, W7.55	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W7.41, W6.26, W7.56	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W7.42, W6.27, W7.57	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W7.43, W6.28, W7.58	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W7.44, W6.29, W7.59	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W7.45, W6.30, W7.60	15.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P12A	W8.1	15.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P12A	W8.2	15.05	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P12A	W9.1	15.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P12A	W9.2	15.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P12A	W10.1	15.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P12A	W10.2	15.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P12A	W10.3	15.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P12A	W10.4	15.05	LH, Fillet, Long pl.	MM			5	-	100%	100%
P12A	W57.1, W31.1, W31.16, W57.16	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.2, W31.2, W31.17, W57.17	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.3, W31.3, W31.18, W57.18	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.4, W31.4, W31.19, W57.19	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.5, W31.5, W31.20, W57.20	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.6, W31.6, W31.21, W57.21	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.7, W31.7, W31.22, W57.22	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.8, W31.8, W31.23, W57.23	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.9, W31.9, W31.24, W57.24	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.10, W31.10, W31.25, W57.25	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.11, W31.11, W31.26, W57.26	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.12, W31.12, W31.27, W57.27	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.13, W31.13, W31.28, W57.28	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.14, W31.14, W31.29, W57.29	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W57.15, W31.15, W31.30, W57.30	16.05	R, FW vertical	MM	GJN		3	-	20%	100%
P12A	W39.1, W32.1	16.05	R, fillet vert. tr+side	MM	GJN		3	-	20%	100%
P12A	W39.2, W39.3, W32.2, W32.3	16.05	R, fillet vert. tr+long	MM	GJN		4	50%	100%	100%
P12A	W38.1, W30.1	16.05	R, fillet vertical, side	MM	GJN		3	-	20%	100%
P12A	W42.1, W42.2	16.05	BW, long, pl.	MM	GJN		5	100%	100%	100%
P12A	W55.1, W55.2	16.05	BW, side, pl.	MM	GJN		5	100%	100%	100%
Bottom plate Welds										
P12A	W12.1, W12.2	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.15, W13.30	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.14, W13.29	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.13, W13.28	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.12, W13.27	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.11, W13.26	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.10, W13.25	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.9, W13.24	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.8, W13.23	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.7, W13.22	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.6, W13.21	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.5, W13.20	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.4, W13.19	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.3, W13.18	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.2, W13.17	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W13.1, W13.16	25.05	Laser Lap welds	GJN			2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P12A	W14.1, W14.4	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W14.2, W14.3, W14.5, W14.6	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W15.1, W15.2, W15.3, W15.4	25.05	Laser Lap welds	GJN			2	-	10%	100%
P12A	W16.1, W16.2, W16.3, W16.4	25.05	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P13A	W1.1	9.05	LH, BW top & top pl	MM		5	100%	100%	100%		
P13A	W1.2	9.05	LH, BW top & top pl	MM		5	100%	100%	100%		
P13A	W4.1	9.05	R-LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P13A	W4.2	9.05	R-LH, FW1, side pl. h	MM	GJN	5	-	100%	100%		
P13A	W7.1, W6.1, W7.16	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.2, W6.2, W7.17	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.3, W6.3, W7.18	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.4, W6.4, W7.19	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.5, W6.5, W7.20	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.6, W6.6, W7.21	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.7, W6.7, W7.22	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.8, W6.8, W7.23	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.9, W6.9, W7.24	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.10, W6.10, W7.25	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.11, W6.11, W7.26	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.12, W6.12, W7.27	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.13, W6.13, W7.28	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.14, W6.14, W7.29	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.15, W6.15, W7.30	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.31, W6.16, W7.46	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.32, W6.17, W7.47	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.33, W6.18, W7.48	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.34, W6.19, W7.49	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.35, W6.20, W7.50	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.36, W6.21, W7.51	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.37, W6.22, W7.52	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.38, W6.23, W7.53	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.39, W6.24, W7.54	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.40, W6.25, W7.55	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.41, W6.26, W7.56	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.42, W6.27, W7.57	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.43, W6.28, W7.58	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.44, W6.29, W7.59	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W7.45, W6.30, W7.60	9.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P13A	W8.1	11.05	R, Fillet, Tr. +top pl	MM	GJN	3	-	20%	100%		
P13A	W8.2	11.05	R, Fillet, Tr. +top pl	MM	GJN	3	-	20%	100%		
P13A	W9.1	11.05	LH, Fillet, Tr. +top pl	MM		5	-	20%	100%		
P13A	W9.2	11.05	LH, Fillet, Tr. +top pl	MM		5	-	20%	100%		
P13A	W10.1	11.05	LH, Fillet, Long pl	MM		5	-	100%	100%		
P13A	W10.2	11.05	LH, Fillet, Long pl	MM		5	-	100%	100%		
P13A	W10.3	11.05	LH, Fillet, Long pl	MM		5	-	100%	100%		
P13A	W10.4	11.05	LH, Fillet, Long pl	MM		5	-	100%	100%		
P13A	W57.1, W31.1, W31.16, W57.16	11.05	R, FW vertical		GJN	3	-	20%	100%		
P13A	W57.2, W31.2, W31.17, W57.17	11.05	R, FW vertical		GJN	3	-	20%	100%		

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

P13A	W57.3, W31.3, W31.18, W57.18	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.4, W31.4, W31.19, W57.19	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.5, W31.5, W31.20, W57.20	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.6, W31.6, W31.21, W57.21	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.7, W31.7, W31.22, W57.22	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.8, W31.8, W31.23, W57.23	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.9, W31.9, W31.24, W57.24	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.10, W31.10, W31.25, W57.25	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.11, W31.11, W31.26, W57.26	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.12, W31.12, W31.27, W57.27	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.13, W31.13, W31.28, W57.28	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.14, W31.14, W31.29, W57.29	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W57.15, W31.15, W31.30, W57.30	11.05	R, FW vertical		GJN	3	-	20%	100%
P13A	W39.1, W32.1	11.05	R, fillet vert., tr+side		GJN	3	-	20%	100%
P13A	W39.2, W39.3, W32.2, W32.3	11.05	R, fillet vert. tr+long		GJN	4	50%	100%	100%
P13A	W38.1, W30.1	11.05	R, fillet vertical, side		GJN	3	-	20%	100%
P13A	W42.1, W42.2	11.05	R, M, BW, long pl.		GJN	5	100%	100%	100%
P13A	W55.1, W55.2	11.05	R, M, BW, side, pl.		GJN	5	100%	100%	100%
<b>Bottom plate welds</b>									
P13A	W12.1, W12.2	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.15, W13.30	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.14, W13.29	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.13, W13.28	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.12, W13.27	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.11, W13.26	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.10, W13.25	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.9, W13.24	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.8, W13.23	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.7, W13.22	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.6, W13.21	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.5, W13.20	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.4, W13.19	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.3, W13.18	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.2, W13.17	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W13.1, W13.16	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W14.1, W14.4	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W14.2, W14.3, W14.5, W14.6	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W15.1, W15.2, W15.3, W15.4	25.05	Laser Lap welds		GJN	2	-	10%	100%
P13A	W16.1, W16.2, W16.3, W16.4	25.05	Laser Lap welds		GJN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P14A	W1.1	5.05	LH, BW lap & top pl	MM		5	100%	100%	100%		
P14A	W1.2	5.05	LH, BW lap & top pl	MM		5	100%	100%	100%		
P14A	W4.1	5.05	R+LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P14A	W4.2	5.05	R+LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P14A	W7.1, W6.1, W7.16	5.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P14A	W7.2, W6.2, W7.17	5.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P14A	W7.3, W6.3, W7.18	5.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P14A	W7.4, W6.4, W7.19	5.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		
P14A	W7.5, W6.5, W7.20	5.05	LH+R, FW L profile	MM	GJN	5	-	20%	100%		



P14A	W7.6, W6.6, W7.21	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.7, W6.7, W7.22	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.8, W6.8, W7.23	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.9, W6.9, W7.24	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.10, W6.10, W7.25	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.11, W6.11, W7.26	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.12, W6.12, W7.27	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.13, W6.13, W7.28	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.14, W6.14, W7.29	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.15, W6.15, W7.30	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.31, W6.16, W7.46	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.32, W6.17, W7.47	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.33, W6.18, W7.48	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.34, W6.19, W7.49	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.35, W6.20, W7.50	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.36, W6.21, W7.51	5.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.37, W6.22, W7.52	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.38, W6.23, W7.53	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.39, W6.24, W7.54	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.40, W6.25, W7.55	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.41, W6.26, W7.56	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.42, W6.27, W7.57	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.43, W6.28, W7.58	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.44, W6.29, W7.59	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W7.45, W6.30, W7.60	7.05	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P14A	W8.1	7.05	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%
P14A	W8.2	7.05	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%
P14A	W9.1	7.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P14A	W9.2	7.05	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P14A	W10.1	7.05	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P14A	W10.2	7.05	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P14A	W10.3	7.05	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P14A	W10.4	7.05	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P14A	W57.1, W31.1, W31.16, W57.16	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.2, W31.2, W31.17, W57.17	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.3, W31.3, W31.18, W57.18	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.4, W31.4, W31.19, W57.19	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.5, W31.5, W31.20, W57.20	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.6, W31.6, W31.21, W57.21	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.7, W31.7, W31.22, W57.22	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.8, W31.8, W31.23, W57.23	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.9, W31.9, W31.24, W57.24	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.10, W31.10, W31.25, W57.25	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.11, W31.11, W31.26, W57.26	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.12, W31.12, W31.27, W57.27	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.13, W31.13, W31.28, W57.28	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.14, W31.14, W31.29, W57.29	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W57.15, W31.15, W31.30, W57.30	9.05	R, FW vertical		GJN		3	-	20%	100%
P14A	W39.1, W32.1	9.05	R, fillet vert., Ir+side		GJN		3	-	20%	100%
P14A	W39.2, W32.2, W32.3	9.05	R, fillet vert., Ir+long		GJN		4	50%	100%	100%
P14A	W38.1, W30.1	9.05	R, fillet vertical, side		GJN		3	-	20%	100%
P14A	W42.1, W42.2	9.05	Bw, long. pl.		GJN		5	100%	100%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

W55.1, W55.2		9.05	Bw, side, pl.	Bottom plate Welds		G.JN	5	100%	100%	100%
P14A	W12.1, W12.2	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.15, W13.30	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.14, W13.29	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.13, W13.28	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.12, W13.27	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.11, W13.26	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.10, W13.25	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.9, W13.24	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.8, W13.23	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.7, W13.22	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.6, W13.21	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.5, W13.20	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.4, W13.19	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.3, W13.18	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.2, W13.17	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W13.1, W13.16	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W14.1, W14.4	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W14.2, W14.3, W14.5, W14.6	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W15.1, W15.2, W15.3, W15.4	10.05	Laser Lap welds	G.JN			2	-	10%	100%
P14A	W16.1, W16.2, W16.3, W16.4	10.05	Laser Lap welds	G.JN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P15A	W1.1	4.05	LH, BW top & top pl	MM		5	100%	100%	100%		
P15A	W1.2	4.05	LH, BW top & top pl	MM		5	100%	100%	100%		
P15A	W4.1	4.05	R+LH, FW, side pl, h	MM	G.JN	5	-	100%	100%		
P15A	W4.2	4.05	R+LH, FW, side pl, h	MM	G.JN	5	-	100%	100%		
P15A	W7.1, W6.1, W7.16	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.2, W6.2, W7.17	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.3, W6.3, W7.18	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.4, W6.4, W7.19	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.5, W6.5, W7.20	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.6, W6.6, W7.21	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.7, W6.7, W7.22	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.8, W6.8, W7.23	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.9, W6.9, W7.24	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.10, W6.10, W7.25	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.11, W6.11, W7.26	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.12, W6.12, W7.27	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.13, W6.13, W7.28	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.14, W6.14, W7.29	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.15, W6.15, W7.30	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.31, W6.16, W7.46	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.32, W6.17, W7.47	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.33, W6.18, W7.48	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.34, W6.19, W7.49	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.35, W6.20, W7.50	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.36, W6.21, W7.51	4.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		
P15A	W7.37, W6.22, W7.52	7.05	LH+R, FW, L profile	MM	G.JN	5	-	20%	100%		

P15A	W7.38, W6.23, W7.53	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.39, W6.24, W7.54	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.40, W6.25, W7.55	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.41, W6.26, W7.56	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.42, W6.27, W7.57	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.43, W6.28, W7.58	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.44, W6.29, W7.59	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W7.45, W6.30, W7.60	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15A	W8.1	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%
P15A	W8.2	R, Fillet, Tr. +top pl	MM	GJN		3	-	20%	100%
P15A	W9.1	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P15A	W9.2	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P15A	W10.1	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P15A	W10.2	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P15A	W10.3	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P15A	W10.4	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P15A	W57.1, W31.1, W31.16, W57.16	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.2, W31.2, W31.17, W57.17	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.3, W31.3, W31.18, W57.18	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.4, W31.4, W31.19, W57.19	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.5, W31.5, W31.20, W57.20	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.6, W31.6, W31.21, W57.21	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.7, W31.7, W31.22, W57.22	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.8, W31.8, W31.23, W57.23	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.9, W31.9, W31.24, W57.24	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.10, W31.10, W31.25, W57.25	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.11, W31.11, W31.26, W57.26	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.12, W31.12, W31.27, W57.27	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.13, W31.13, W31.28, W57.28	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.14, W31.14, W31.29, W57.29	R, FW vertical		GJN		3	-	20%	100%
P15A	W57.15, W31.15, W31.30, W57.30	R, FW vertical		GJN		3	-	20%	100%
P15A	W39.1, W32.1	R, fillet vert., lr-side		GJN		4	50%	100%	100%
P15A	W39.2, W39.3, W32.2, W32.3	R, fillet vert., lr+long		GJN		3	-	20%	100%
P15A	W38.1, W30.1	R, fillet vertical, side		GJN		3	-	20%	100%
P15A	W42.1, W42.2	BW, long. pl.		GJN		5	100%	100%	100%
P15A	W55.1, W55.2	BW, side. pl.		GJN		5	100%	100%	100%
Bottom plate welds									
P15A	W12.1, W12.2	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.15, W13.30	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.14, W13.29	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.13, W13.28	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.12, W13.27	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.11, W13.26	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.10, W13.25	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.9, W13.24	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.8, W13.23	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.7, W13.22	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.6, W13.21	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.5, W13.20	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.4, W13.19	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.3, W13.18	Laser Lap welds	GJN			2	-	10%	100%
P15A	W13.2, W13.17	Laser Lap welds	GJN			2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P15A	W13.1, W13.16	10.05	Laser Lap welds	GJN			2	-	10%	100%
P15A	W14.1, W14.4	10.05	Laser Lap welds	GJN			2	-	10%	100%
P15A	W14.2, W14.3, W14.5, W14.6	10.05	Laser Lap welds	GJN			2	-	10%	100%
P15A	W15.1, W15.2, W15.3, W15.4	10.05	Laser Lap welds	GJN			2	-	10%	100%
P15A	W16.1, W16.2, W16.3, W16.4	10.05	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P11B	W1.1	28.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P11B	W1.2	28.06	LH, BW top & top pl	MM		5	100%	100%	100%		
P11B	W4.1	30.06	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P11B	W4.2	30.06	LH, FW, side pl. h	MM	GJN	5	-	100%	100%		
P11B	W5.1	30.06	R, FW, side pl. h	MM	GJN	5	-	100%	100%		
P11B	W5.2	30.06	R, FW, side pl. h	MM	GJN	5	-	100%	100%		
P11B	W7.1, W6.1, W7.16	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.2, W6.2, W7.17	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.3, W6.3, W7.18	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.4, W6.4, W7.19	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.5, W6.5, W7.20	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.6, W6.6, W7.21	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.7, W6.7, W7.22	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.8, W6.8, W7.23	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.9, W6.9, W7.24	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.10, W6.10, W7.25	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.11, W6.11, W7.26	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.12, W6.12, W7.27	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.13, W6.13, W7.28	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.14, W6.14, W7.29	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.15, W6.15, W7.30	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.31, W6.16, W7.46	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.32, W6.17, W7.47	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.33, W6.18, W7.48	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.34, W6.19, W7.49	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.35, W6.20, W7.50	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.36, W6.21, W7.51	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.37, W6.22, W7.52	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.38, W6.23, W7.53	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.39, W6.24, W7.54	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.40, W6.25, W7.55	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.41, W6.26, W7.56	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.42, W6.27, W7.57	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.43, W6.28, W7.58	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.44, W6.29, W7.59	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W7.45, W6.30, W7.60	30.06	LH+R, FW, L profile	MM	GJN	5	-	20%	100%		
P11B	W8.1	3.07	R, Fillet, Tr. +top pl	MM		3	-	20%	100%		
P11B	W8.2	3.07	R, Fillet, Tr. +top pl	MM		3	-	20%	100%		
P11B	W9.1	3.07	R, Fillet, Tr. +top pl	MM		3	-	20%	100%		
P11B	W9.2	3.07	R, Fillet, Tr. +top pl	MM		3	-	20%	100%		
P11B	W10.1	3.07	LH, Fillet, Long. pl.	MM		5	-	100%	100%		
P11B	W10.2	3.07	LH, Fillet, Long. pl.	MM		5	-	100%	100%		
P11B	W57.1, W31.1, W31.16, W57.16	3.07	R, FW, vertical	MM	GJN	3	-	20%	100%		Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

Bottom plate Welds										
Section	Welding no.	Date	Type of weld	Laser	Robot	Manually	WIC	UT	MT/PT	VT
P11B	W57.2, W31.2, W31.17, W57.17	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.3, W31.3, W31.18, W57.18	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.4, W31.4, W31.19, W57.19	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.5, W31.5, W31.20, W57.20	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.6, W31.6, W31.21, W57.21	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.7, W31.7, W31.22, W57.22	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.8, W31.8, W31.23, W57.23	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.9, W31.9, W31.24, W57.24	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.10, W31.10, W31.25, W57.25	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.11, W31.11, W31.26, W57.26	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.12, W31.12, W31.27, W57.27	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.13, W31.13, W31.28, W57.28	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.14, W31.14, W31.29, W57.29	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W57.15, W31.15, W31.30, W57.30	3.07	R, FW, vertical		GJN		3	-	-	100%
P11B	W39.1, W39.2, W32.2	3.07	R, fillet vert. tr+long		GJN		4	50%	100%	100%
P11B	W30.1, W38.1	3.07	R, fillet vert. tr+side		GJN		3	-	-	100%
P11B	W42.1	3.07	BW, long, pl.		GJN		5	100%	100%	100%
P11B	W55.1, W55.2	3.07	BW, long, pl.		GJN		5	100%	100%	100%
P11B										
P11B	W12.1, W12.2	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.15, W13.30	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.14, W13.29	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.13, W13.28	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.12, W13.27	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.11, W13.26	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.10, W13.25	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.9, W13.24	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.8, W13.23	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.7, W13.22	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.6, W13.21	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.5, W13.20	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.4, W13.19	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.3, W13.18	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.2, W13.17	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W13.1, W13.16	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W14.1, W14.2, W14.3, W14.4	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W15.1, W15.2, W15.3, W15.4	4.07	Laser Lap welds		GJN		2	-	-	100%
P11B	W16.1, W16.2, W16.3, W16.4	4.07	Laser Lap welds		GJN		2	-	-	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P12B	W1.1	26.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P12B	W1.2	26.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P12B	W4.1	28.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P12B	W4.2	28.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P12B	W5.1	28.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P12B	W5.2	28.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P12B	W7.1, W6.1, W7.16	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P12B	W7.2, W6.2, W7.17	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P12B	W7.3, W6.3, W7.18	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		

P12B	W7.4, W6.4, W7.19	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.5, W6.5, W7.20	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.6, W6.6, W7.21	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.7, W6.7, W7.22	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.8, W6.8, W7.23	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.9, W6.9, W7.24	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.10, W6.10, W7.25	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.11, W6.11, W7.26	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.12, W6.12, W7.27	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.13, W6.13, W7.28	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.14, W6.14, W7.29	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.15, W6.15, W7.30	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.31, W6.16, W7.46	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.32, W6.17, W7.47	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.33, W6.18, W7.48	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.34, W6.19, W7.49	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.35, W6.20, W7.50	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.36, W6.21, W7.51	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.37, W6.22, W7.52	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.38, W6.23, W7.53	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.39, W6.24, W7.54	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.40, W6.25, W7.55	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.41, W6.26, W7.56	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.42, W6.27, W7.57	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.43, W6.28, W7.58	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.44, W6.29, W7.59	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W7.45, W6.30, W7.60	29.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P12B	W8.1	29.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P12B	W8.2	29.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P12B	W9.1	29.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P12B	W9.2	29.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P12B	W10.1	29.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P12B	W10.2	29.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P12B	W57.1, W31.1, W31.16, W57.16	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.2, W31.2, W31.17, W57.17	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.3, W31.3, W31.18, W57.18	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.4, W31.4, W31.19, W57.19	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.5, W31.5, W31.20, W57.20	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.6, W31.6, W31.21, W57.21	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.7, W31.7, W31.22, W57.22	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.8, W31.8, W31.23, W57.23	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.9, W31.9, W31.24, W57.24	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.10, W31.10, W31.25, W57.25	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.11, W31.11, W31.26, W57.26	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.12, W31.12, W31.27, W57.27	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.13, W31.13, W31.28, W57.28	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.14, W31.14, W31.29, W57.29	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W57.15, W31.15, W31.30, W57.30	29.06	R, FW, vertical		GJN		3	-	20%	100%
P12B	W39.1, W39.2, W32.2	29.06	R, fillet vert, tr+long		GJN		4	50%	100%	100%
P12B	W30.1, W38.1	29.06	R, fillet vert, tr+side		GJN		3	-	20%	100%
P12B	W42.1	29.06	BW, long, pl		GJN		5	100%	100%	100%
P12B	W55.1, W55.2	29.06	BW, long, pl		GJN		5	100%	100%	100%

UT, MT, VT reports,  
measurement and  
pressure test report

Area inside sandwich deck  
was checked before closing.  
Weld defects are stated in  
NDT reports.

Bottom plate Welds										
Section	Welding no.	Date	Type of weld	Laser	Robot	Manually	WIC	UT	MT/PT	VT
P12B	W12.1, W12.2	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.15, W13.30	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.14, W13.29	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.13, W13.28	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.12, W13.27	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.11, W13.26	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.10, W13.25	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.9, W13.24	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.8, W13.23	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.7, W13.22	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.6, W13.21	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.5, W13.20	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.4, W13.19	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.3, W13.18	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.2, W13.17	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W13.1, W13.16	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W14.1, W14.2, W14.3, W14.4	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W15.1, W15.2, W15.3, W15.4	4.07	Laser Lap welds	GJN			2	-	10%	100%
P12B	W16.1, W16.2, W16.3, W16.4	4.07	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P13B	W7.1	26.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P13B	W7.2	26.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P13B	W4.1	27.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P13B	W4.2	27.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P13B	W5.1	27.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P13B	W5.2	27.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P13B	W7.1, W6.1, W7.16	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.2, W6.2, W7.17	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.3, W6.3, W7.18	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.4, W6.4, W7.19	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.5, W6.5, W7.20	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.6, W6.6, W7.21	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.7, W6.7, W7.22	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.8, W6.8, W7.23	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.9, W6.9, W7.24	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.10, W6.10, W7.25	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.11, W6.11, W7.26	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.12, W6.12, W7.27	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.13, W6.13, W7.28	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.14, W6.14, W7.29	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.15, W6.15, W7.30	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.31, W6.16, W7.46	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.32, W6.17, W7.47	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.33, W6.18, W7.48	27.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.34, W6.19, W7.49	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.35, W6.20, W7.50	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P13B	W7.36, W6.21, W7.51	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		

P13B	W7.37, W6.22, W7.52	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.38, W6.23, W7.53	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.39, W6.24, W7.54	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.40, W6.25, W7.55	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.41, W6.26, W7.56	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.42, W6.27, W7.57	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.43, W6.28, W7.58	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.44, W6.29, W7.59	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W7.45, W6.30, W7.60	28.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P13B	W8.1	28.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P13B	W8.2	28.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P13B	W9.1	28.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P13B	W9.2	28.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P13B	W10.1	28.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P13B	W10.2	28.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P13B	W57.1, W31.1, W31.16, W57.16	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.2, W31.2, W31.17, W57.17	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.3, W31.3, W31.18, W57.18	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.4, W31.4, W31.19, W57.19	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.5, W31.5, W31.20, W57.20	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.6, W31.6, W31.21, W57.21	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.7, W31.7, W31.22, W57.22	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.8, W31.8, W31.23, W57.23	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.9, W31.9, W31.24, W57.24	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.10, W31.10, W31.25, W57.25	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.11, W31.11, W31.26, W57.26	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.12, W31.12, W31.27, W57.27	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.13, W31.13, W31.28, W57.28	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.14, W31.14, W31.29, W57.29	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W57.15, W31.15, W31.30, W57.30	28.06	R, FW, vertical	MM	GJN		3	-	20%	100%
P13B	W39.1, W39.2, W32.2	28.06	R, fillet vert, tr+long	MM	GJN		4	50%	100%	100%
P13B	W30.1, W38.1	28.06	R, fillet vert, tr+side	MM	GJN		3	-	20%	100%
P13B	W42.1	28.06	BW, long, pl.	MM	GJN		5	100%	100%	100%
P13B	W55.1, W55.2	28.06	BW, long, pl.	MM	GJN		5	100%	100%	100%
Bottom plate Welds										
P13B	W12.1, W12.2	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.15, W13.30	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.14, W13.29	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.13, W13.28	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.12, W13.27	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.11, W13.26	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.10, W13.25	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.9, W13.24	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.8, W13.23	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.7, W13.22	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.6, W13.21	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.5, W13.20	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.4, W13.19	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.3, W13.18	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.2, W13.17	4.07	Laser Lap welds	GJN			2	-	10%	100%
P13B	W13.1, W13.16	4.07	Laser Lap welds	GJN			2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.



P13B	W14.1, W14.2, W14.3, W14.4	4.07	Laser Lap welds	GJN	2	-	10%	100%
P13B	W15.1, W15.2, W15.3, W15.4	4.07	Laser Lap welds	GJN	2	-	10%	100%
P13B	W16.1, W16.2, W16.3, W16.4	4.07	Laser Lap welds	GJN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P14B	W1.1	22.06	LH, BW, top & top pl	MM			5	100%	100%	100%		
P14B	W1.2	22.06	LH, BW, top & top pl	MM			5	100%	100%	100%		
P14B	W4.1	22.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P14B	W4.2	22.06	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P14B	W5.1	22.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P14B	W5.2	22.06	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P14B	W7.1, W6.1, W7.16	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.2, W6.2, W7.17	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.3, W6.3, W7.18	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.4, W6.4, W7.19	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.5, W6.5, W7.20	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.6, W6.6, W7.21	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.7, W6.7, W7.22	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.8, W6.8, W7.23	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.9, W6.9, W7.24	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.10, W6.10, W7.25	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.11, W6.11, W7.26	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.12, W6.12, W7.27	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.13, W6.13, W7.28	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.14, W6.14, W7.29	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.15, W6.15, W7.30	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.31, W6.16, W7.46	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.32, W6.17, W7.47	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.33, W6.18, W7.48	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.34, W6.19, W7.49	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.35, W6.20, W7.50	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.36, W6.21, W7.51	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.37, W6.22, W7.52	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.38, W6.23, W7.53	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.39, W6.24, W7.54	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.40, W6.25, W7.55	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.41, W6.26, W7.56	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.42, W6.27, W7.57	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.43, W6.28, W7.58	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.44, W6.29, W7.59	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W7.45, W6.30, W7.60	26.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P14B	W8.1	26.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P14B	W8.2	26.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P14B	W9.1	26.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P14B	W9.2	26.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P14B	W10.1	26.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P14B	W10.2	26.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P14B	W57.1, W31.1, W31.16, W57.16	27.06	R, FW, vertical	MM	GJN		3	-	20%	100%		
P14B	W57.2, W31.2, W31.17, W57.17	27.06	R, FW, vertical	MM	GJN		3	-	20%	100%		
P14B	W57.3, W31.3, W31.18, W57.18	27.06	R, FW, vertical	MM	GJN		3	-	20%	100%		

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

UT, MT, VT reports, measurement and pressure test report

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P14B	W57.4, W31.4, W31.19, W57.19	27.06	R, FW, vertical									
P14B	W57.5, W31.5, W31.20, W57.20	27.06	R, FW, vertical									
P14B	W57.6, W31.6, W31.21, W57.21	27.06	R, FW, vertical									
P14B	W57.7, W31.7, W31.22, W57.22	27.06	R, FW, vertical									
P14B	W57.8, W31.8, W31.23, W57.23	27.06	R, FW, vertical									
P14B	W57.9, W31.9, W31.24, W57.24	27.06	R, FW, vertical									
P14B	W57.10, W31.10, W31.25, W57.25	27.06	R, FW, vertical									
P14B	W57.11, W31.11, W31.26, W57.26	27.06	R, FW, vertical									
P14B	W57.12, W31.12, W31.27, W57.27	27.06	R, FW, vertical									
P14B	W57.13, W31.13, W31.28, W57.28	27.06	R, FW, vertical									
P14B	W57.14, W31.14, W31.29, W57.29	27.06	R, FW, vertical									
P14B	W57.15, W31.15, W31.30, W57.30	27.06	R, FW, vertical									
P14B	W39.1, W39.2, W32.2	27.06	R, fillet vert. lr+long									
P14B	W30.1, W38.1	27.06	R, fillet vert. lr+side									
P14B	W42.1	27.06	BW, long, pl.									
P14B	W55.1, W55.2	27.06	BW, long, pl.									
P14B												
Bottom plate Welds												
P14B	W12.1, W12.2	3.07	Laser Lap welds	GJN								
P14B	W13.15, W13.30	3.07	Laser Lap welds	GJN								
P14B	W13.14, W13.29	3.07	Laser Lap welds	GJN								
P14B	W13.13, W13.28	3.07	Laser Lap welds	GJN								
P14B	W13.12, W13.27	3.07	Laser Lap welds	GJN								
P14B	W13.11, W13.26	3.07	Laser Lap welds	GJN								
P14B	W13.10, W13.25	3.07	Laser Lap welds	GJN								
P14B	W13.9, W13.24	3.07	Laser Lap welds	GJN								
P14B	W13.8, W13.23	3.07	Laser Lap welds	GJN								
P14B	W13.7, W13.22	3.07	Laser Lap welds	GJN								
P14B	W13.6, W13.21	3.07	Laser Lap welds	GJN								
P14B	W13.5, W13.20	3.07	Laser Lap welds	GJN								
P14B	W13.4, W13.19	3.07	Laser Lap welds	GJN								
P14B	W13.3, W13.18	3.07	Laser Lap welds	GJN								
P14B	W13.2, W13.17	3.07	Laser Lap welds	GJN								
P14B	W13.1, W13.16	3.07	Laser Lap welds	GJN								
P14B	W14.1, W14.2, W14.3, W14.4	3.07	Laser Lap welds	GJN								
P14B	W15.1, W15.2, W15.3, W15.4	3.07	Laser Lap welds	GJN								
P14B	W16.1, W16.2, W16.3, W16.4	3.07	Laser Lap welds	GJN								

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P15B	W1.1	22.06	LH, BW, top & top pl	MM								
P15B	W1.2	22.06	LH, BW, top & top pl	MM								
P15B	W4.1	22.06	LH, FW, side pl. h	MM	GJN							
P15B	W4.2	22.06	LH, FW, side pl. h	MM	GJN							
P15B	W5.1	22.06	R, FW, side pl. h	MM	GJN							
P15B	W5.2	22.06	R, FW, side pl. h	MM	GJN							
P15B	W7.1, W6.1, W7.16	22.06	LH+R, FW, L profile	MM	GJN							
P15B	W7.2, W6.2, W7.17	22.06	LH+R, FW, L profile	MM	GJN							
P15B	W7.3, W6.3, W7.18	22.06	LH+R, FW, L profile	MM	GJN							
P15B	W7.4, W6.4, W7.19	22.06	LH+R, FW, L profile	MM	GJN							
P15B	W7.5, W6.5, W7.20	22.06	LH+R, FW, L profile	MM	GJN							

P15B	W7.6, W6.6, W7.21	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.7, W6.7, W7.22	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.8, W6.8, W7.23	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.9, W6.9, W7.24	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.10, W6.10, W7.25	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.11, W6.11, W7.26	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.12, W6.12, W7.27	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.13, W6.13, W7.28	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.14, W6.14, W7.29	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.15, W6.15, W7.30	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.31, W6.16, W7.46	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.32, W6.17, W7.47	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.33, W6.18, W7.48	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.34, W6.19, W7.49	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.35, W6.20, W7.50	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.36, W6.21, W7.51	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.37, W6.22, W7.52	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.38, W6.23, W7.53	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.39, W6.24, W7.54	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.40, W6.25, W7.55	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.41, W6.26, W7.56	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.42, W6.27, W7.57	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.43, W6.28, W7.58	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.44, W6.29, W7.59	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W7.45, W6.30, W7.60	22.06	LH+R, FW, L profile	MM	GJN		5	-	20%	100%
P15B	W8.1	22.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P15B	W8.2	22.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P15B	W9.1	22.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P15B	W9.2	22.06	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P15B	W10.1	22.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P15B	W10.2	22.06	LH, Fillet, Long, pl	MM			5	-	100%	100%
P15B	W57.1, W31.1, W31.16, W57.16	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.2, W31.2, W31.17, W57.17	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.3, W31.3, W31.18, W57.18	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.4, W31.4, W31.19, W57.19	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.5, W31.5, W31.20, W57.20	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.6, W31.6, W31.21, W57.21	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.7, W31.7, W31.22, W57.22	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.8, W31.8, W31.23, W57.23	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.9, W31.9, W31.24, W57.24	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.10, W31.10, W31.25, W57.25	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.11, W31.11, W31.26, W57.26	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.12, W31.12, W31.27, W57.27	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.13, W31.13, W31.28, W57.28	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.14, W31.14, W31.29, W57.29	23.06	R, FW, vertical		GJN		3	-	20%	100%
P15B	W57.15, W31.15, W31.30, W57.30	23.06	R, Fillet vert, Ir+long		GJN		4	50%	100%	100%
P15B	W39.1, W39.2, W32.2	23.06	R, fillet vert, Ir+side		GJN		3	-	20%	100%
P15B	W30.1, W38.1	23.06	BW, long, pl.		GJN		5	100%	100%	100%
P15B	W42.1	23.06	BW, long, pl.		GJN		5	100%	100%	100%
P15B	W55.1, W55.2	23.06	BW, long, pl.		GJN		5	100%	100%	100%
P15B		23.06								

Bottom plate Welds

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P15B	W12.1, W12.2	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.15, W13.30	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.14, W13.29	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.13, W13.28	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.12, W13.27	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.11, W13.26	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.10, W13.25	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.9, W13.24	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.8, W13.23	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.7, W13.22	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.6, W13.21	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.5, W13.20	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.4, W13.19	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.3, W13.18	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.2, W13.17	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W13.1, W13.16	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W14.1, W14.2, W14.3, W14.4	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W15.1, W15.2, W15.3, W15.4	3.07	Laser Lap welds	GJN			2	-	10%	100%
P15B	W16.1, W16.2, W16.3, W16.4	3.07	Laser Lap welds	GJN			2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
P16A	W1.1	12.06	LH, BW top & top pl	MM			5	100%	100%		
P16A	W1.2	12.06	LH, BW top & top pl	MM			5	100%	100%		
P16A	W4.1	12.06	R-LH, FW, side pl. h	MM	GJN		5	-	100%		
P16A	W4.2	12.06	R-LH, FW1, side pl. h	MM	GJN		5	-	100%		
P16A	W7.1, W6.1, W7.16	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.2, W6.2, W7.17	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.3, W6.3, W7.18	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.4, W6.4, W7.19	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.5, W6.5, W7.20	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.6, W6.6, W7.21	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.7, W6.7, W7.22	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.8, W6.8, W7.23	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.9, W6.9, W7.24	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.10, W6.10, W7.25	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.11, W6.11, W7.26	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.12, W6.12, W7.27	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.13, W6.13, W7.28	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.14, W6.14, W7.29	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.15, W6.15, W7.30	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.31, W6.16, W7.46	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.32, W6.17, W7.47	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.33, W6.18, W7.48	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.34, W6.19, W7.49	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.35, W6.20, W7.50	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.36, W6.21, W7.51	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.37, W6.22, W7.52	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.38, W6.23, W7.53	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.39, W6.24, W7.54	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.40, W6.25, W7.55	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	
P16A	W7.41, W6.26, W7.56	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%	

P16A	W7.42, W6.27, W7.57	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P16A	W7.43, W6.28, W7.58	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P16A	W7.44, W6.29, W7.59	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P16A	W7.45, W6.30, W7.60	12.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P16A	W8.1	13.06	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%
P16A	W8.2	13.06	R, Fillet, Tr. +top pl		GJN		3	-	20%	100%
P16A	W9.1	13.06	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P16A	W9.2	13.06	LH, Fillet, Tr. +top pl	MM			5	-	20%	100%
P16A	W10.1	13.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P16A	W10.2	13.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P16A	W10.3	13.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P16A	W10.4	13.06	LH, Fillet, Long. pl.	MM			5	-	100%	100%
P16A	W57.1, W31.1, W31.16, W57.16	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.2, W31.2, W31.17, W57.17	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.3, W31.3, W31.18, W57.18	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.4, W31.4, W31.19, W57.19	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.5, W31.5, W31.20, W57.20	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.6, W31.6, W31.21, W57.21	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.7, W31.7, W31.22, W57.22	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.8, W31.8, W31.23, W57.23	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.9, W31.9, W31.24, W57.24	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.10, W31.10, W31.25, W57.25	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.11, W31.11, W31.26, W57.26	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.12, W31.12, W31.27, W57.27	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.13, W31.13, W31.28, W57.28	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.14, W31.14, W31.29, W57.29	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W57.15, W31.15, W31.30, W57.30	13.06	R, FW vertical		GJN		3	-	20%	100%
P16A	W39.1, W32.1	13.06	R, fillet vert., tr+side		GJN		3	-	20%	100%
P16A	W39.2, W39.3, W32.2, W32.3	13.06	R, fillet vert. tr+long		GJN		4	50%	100%	100%
P16A	W38.1, W30.1	13.06	R, fillet vertical, side		GJN		3	-	20%	100%
P16A	W42.1, W42.2	13.06	BW, long. pl.		GJN		5	100%	100%	100%
P16A	W55.1, W55.2	13.06	BW, side. pl.		GJN		5	100%	100%	100%
Bottom plate Welds										
P16A	W12.1, W12.2	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.15, W13.30	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.14, W13.29	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.13, W13.28	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.12, W13.27	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.11, W13.26	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.10, W13.25	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.9, W13.24	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.8, W13.23	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.7, W13.22	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.6, W13.21	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.5, W13.20	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.4, W13.19	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.3, W13.18	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.2, W13.17	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W13.1, W13.16	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W14.1, W14.4	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W14.2, W14.3, W14.5, W14.6	20.06	Laser Lap welds		GJN		2	-	10%	100%
P16A	W15.1, W15.2, W15.3, W15.4	20.06	Laser Lap welds		GJN		2	-	10%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P16A	W16.1, W16.2, W16.3, W16.4	20.06	Laser Lap welds	G.JN			2	-	10%	100%		
P17A	W1.1	12.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P17A	W1.2	12.06	LH, BW top & top pl	MM			5	100%	100%	100%		
P17A	W4.1	13.06	R-LH, FW, side pl. h	MM	G.JN		5	-	100%	100%		
P17A	W4.2	13.06	R-LH, FW, side pl. h	MM	G.JN		5	-	100%	100%		
P17A	W7.1, W6.1, W7.16	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.2, W6.2, W7.17	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.3, W6.3, W7.18	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.4, W6.4, W7.19	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.5, W6.5, W7.20	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.6, W6.6, W7.21	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.7, W6.7, W7.22	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.8, W6.8, W7.23	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.9, W6.9, W7.24	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.10, W6.10, W7.25	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.11, W6.11, W7.26	13.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.12, W6.12, W7.27	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.13, W6.13, W7.28	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.14, W6.14, W7.29	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.15, W6.15, W7.30	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.31, W6.16, W7.46	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.32, W6.17, W7.47	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.33, W6.18, W7.48	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.34, W6.19, W7.49	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.35, W6.20, W7.50	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.36, W6.21, W7.51	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.37, W6.22, W7.52	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.38, W6.23, W7.53	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.39, W6.24, W7.54	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.40, W6.25, W7.55	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.41, W6.26, W7.56	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.42, W6.27, W7.57	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.43, W6.28, W7.58	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.44, W6.29, W7.59	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W7.45, W6.30, W7.60	14.06	LH+R, FW L profile	MM	G.JN		5	-	20%	100%		
P17A	W8.1	14.06	R, Fillet, Tr, +top pl	MM	G.JN		3	-	20%	100%		
P17A	W8.2	14.06	R, Fillet, Tr, +top pl	MM	G.JN		3	-	20%	100%		
P17A	W9.1	14.06	LH, Fillet, Tr, +top pl	MM			5	-	20%	100%		
P17A	W9.2	14.06	LH, Fillet, Tr, +top pl	MM			5	-	20%	100%		
P17A	W10.1	14.06	LH, Fillet, Long pl.	MM			5	-	100%	100%		
P17A	W10.2	14.06	LH, Fillet, Long pl.	MM			5	-	100%	100%		
P17A	W10.3	14.06	LH, Fillet, Long pl.	MM			5	-	100%	100%		
P17A	W10.4	14.06	LH, Fillet, Long pl.	MM			5	-	100%	100%		
P17A	W57.1, W31.1, W31.16, W57.16	14.06	R, FW vertical	MM	G.JN		3	-	20%	100%		
P17A	W57.2, W31.2, W31.17, W57.17	14.06	R, FW vertical	MM	G.JN		3	-	20%	100%		
P17A	W57.3, W31.3, W31.18, W57.18	14.06	R, FW vertical	MM	G.JN		3	-	20%	100%		
P17A	W57.4, W31.4, W31.19, W57.19	14.06	R, FW vertical	MM	G.JN		3	-	20%	100%		
P17A	W57.5, W31.5, W31.20, W57.20	14.06	R, FW vertical	MM	G.JN		3	-	20%	100%		

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

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P17A	W57.6, W31.6, W31.21, W57.21	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.7, W31.7, W31.22, W57.22	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.8, W31.8, W31.23, W57.23	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.9, W31.9, W31.24, W57.24	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.10, W31.10, W31.25, W57.25	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.11, W31.11, W31.26, W57.26	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.12, W31.12, W31.27, W57.27	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.13, W31.13, W31.28, W57.28	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.14, W31.14, W31.29, W57.29	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W57.15, W31.15, W31.30, W57.30	14.06	R, FW vertical		G.JN	3	-	20%	100%
P17A	W39.1, W32.1	14.06	R, fillet vert., Ir-side		G.JN	4	50%	100%	100%
P17A	W39.2, W39.3, W32.2, W32.3	14.06	R, fillet vert. Ir-Along		G.JN	3	-	20%	100%
P17A	W38.1, W30.1	14.06	R, fillet vertical, side		G.JN	5	100%	100%	100%
P17A	W42.1, W42.2	14.06	BW, long, pl.		G.JN	5	100%	100%	100%
P17A	W55.1, W55.2	14.06	BW, side, pl.		G.JN	5	100%	100%	100%
Bottom plate Welds									
P17A	W12.1, W12.2	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.15, W13.30	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.14, W13.29	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.13, W13.28	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.12, W13.27	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.11, W13.26	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.10, W13.25	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.9, W13.24	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.8, W13.23	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.7, W13.22	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.6, W13.21	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.5, W13.20	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.4, W13.19	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.3, W13.18	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.2, W13.17	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W13.1, W13.16	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W14.1, W14.4	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W14.2, W14.3, W14.5, W14.6	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W15.1, W15.2, W15.3, W15.4	20.06	Laser Lap welds		G.JN	2	-	10%	100%
P17A	W16.1, W16.2, W16.3, W16.4	20.06	Laser Lap welds		G.JN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P18A	W1.1	14.06	LH, BW top & top pl				5	100%	100%	100%		
P18A	W1.2	14.06	LH, BW top & top pl				5	100%	100%	100%		
P18A	W4.1	15.06	R+LH, FW, side pl. h		G.JN		5	-	100%	100%		
P18A	W4.2	15.06	R+LH, FW, side pl. h		G.JN		5	-	100%	100%		
P18A	W7.31, W6.16, W7.46	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.32, W6.17, W7.47	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.33, W6.18, W7.48	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.34, W6.19, W7.49	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.35, W6.20, W7.50	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.36, W6.21, W7.51	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.37, W6.22, W7.52	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		
P18A	W7.38, W6.23, W7.53	15.06	LH+R, FW, L profile		G.JN		5	-	20%	100%		

P18A	W7.39, W6.24, W7.54	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W7.40, W6.25, W7.55	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W7.41, W6.26, W7.56	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W7.42, W6.27, W7.57	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W7.43, W6.28, W7.58	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W7.44, W6.29, W7.59	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W7.45, W6.30, W7.60	15.06	LH+R, FW L profile	MM	GJN		5	-	20%	100%
P18A	W8.1	15.06	R, Fillet, Tr, +top pl		GJN		3	-	20%	100%
P18A	W8.2	15.06	R, Fillet, Tr, +top pl		GJN		3	-	20%	100%
P18A	W10.3	15.06	LH, Fillet, Long pl	MM			5	-	100%	100%
P18A	W10.4	15.06	LH, Fillet, Long pl	MM			5	-	100%	100%
P18A	W31.16, W57.16	15.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.17, W57.17	15.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.18, W57.18	15.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.19, W57.19	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.20, W57.20	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.21, W57.21	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.22, W57.22	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.23, W57.23	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.24, W57.24	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.25, W57.25	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.26, W57.26	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.27, W57.27	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.28, W57.28	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.29, W57.29	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W31.30, W57.30	16.06	R, FW vertical		GJN		3	-	20%	100%
P18A	W32.1	16.06	R, fillet vert, tr+side		GJN		3	-	20%	100%
P18A	W32.2, W32.3	16.06	R, fillet vert, tr+long		GJN		4	50%	100%	100%
P18A	W30.1	16.06	R, fillet vertical, side		GJN		3	-	20%	100%
P18A	W55.2	16.06	R, M, BW, side, pl.		GJN		5	100%	100%	100%

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

Bottom plate Welds

P18A	W12.2	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.30	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.29	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.28	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.27	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.26	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.25	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.24	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.23	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.22	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.21	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.19	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.18	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.17	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W13.16	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W14.4	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W14.5, W14.6	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W15.3, W15.4	20.06	Laser Lap welds		GJN		2	-	10%	100%
P18A	W16.3, W16.4	20.06	Laser Lap welds		GJN		2	-	10%	100%



Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P16B	W1.1	7.08	LH, BW top & top pl	MM			5	100%	100%	100%		
P16B	W1.2	7.08	LH, BW top & top pl	MM			5	100%	100%	100%		
P16B	W4.1	7.08	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P16B	W4.2	7.08	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P16B	W5.1	7.08	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P16B	W5.2	7.08	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P16B	W7.1, W6.1, W7.16	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.2, W6.2, W7.17	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.3, W6.3, W7.18	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.4, W6.4, W7.19	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.5, W6.5, W7.20	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.6, W6.6, W7.21	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.7, W6.7, W7.22	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.8, W6.8, W7.23	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.9, W6.9, W7.24	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.10, W6.10, W7.25	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.11, W6.11, W7.26	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.12, W6.12, W7.27	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.13, W6.13, W7.28	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.14, W6.14, W7.29	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.15, W6.15, W7.30	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.31, W6.16, W7.46	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.32, W6.17, W7.47	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.33, W6.18, W7.48	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.34, W6.19, W7.49	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.35, W6.20, W7.50	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.36, W6.21, W7.51	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.37, W6.22, W7.52	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.38, W6.23, W7.53	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.39, W6.24, W7.54	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.40, W6.25, W7.55	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.41, W6.26, W7.56	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.42, W6.27, W7.57	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.43, W6.28, W7.58	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.44, W6.29, W7.59	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W7.45, W6.30, W7.60	7.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P16B	W8.1	8.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P16B	W8.2	8.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P16B	W9.1	8.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P16B	W9.2	8.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%		
P16B	W10.1	8.08	LH, Fillet, Long pl	MM			5	-	100%	100%		
P16B	W10.2	8.08	LH, Fillet, Long pl	MM			5	-	100%	100%		
P16B	W57.1, W31.1, W31.16, W57.17	8.08	R, FW, vertical		GJN		3	-	20%	100%		
P16B	W57.2, W31.2, W31.17, W57.18	8.08	R, FW, vertical		GJN		3	-	20%	100%		
P16B	W57.3, W31.3, W31.18, W57.19	8.08	R, FW, vertical		GJN		3	-	20%	100%		
P16B	W57.4, W31.4, W31.19, W57.20	8.08	R, FW, vertical		GJN		3	-	20%	100%		
P16B	W57.5, W31.5, W31.20, W57.21	8.08	R, FW, vertical		GJN		3	-	20%	100%		
P16B	W57.6, W31.6, W31.21, W57.22	8.08	R, FW, vertical		GJN		3	-	20%	100%		
P16B	W57.7, W31.7, W31.22, W57.23	8.08	R, FW, vertical		GJN		3	-	20%	100%		

UT, MT, VT reports, measurement and pressure test report

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

P16B	W57.8, W31.8, W31.23, W57.23	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.9, W31.9, W31.24, W57.24	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.10, W31.10, W31.25, W57.25	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.11, W31.11, W31.26, W57.26	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.12, W31.12, W31.27, W57.27	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.13, W31.13, W31.28, W57.28	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.14, W31.14, W31.29, W57.29	8.08	R, FW, vertical		GJN	3	-	20%	100%
P16B	W57.15, W31.15, W31.30, W57.30	8.08	R, fillet vert, lr+long		GJN	3	50%	100%	100%
P16B	W39.1, W39.2, W32.2	8.08	R, fillet vert., lr+side		GJN	3	-	20%	100%
P16B	W30.1, W38.1	8.08	BW, long, pl.		GJN	5	100%	100%	100%
P16B	W42.1	8.08	BW, long, pl.		GJN	5	100%	100%	100%
P16B	W55.1, W55.2	8.08	BW, long, pl.		GJN	5	100%	100%	100%
P16B									
Bottom plate welds									
P16B	W12.1, W12.2	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.15, W13.30	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.14, W13.29	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.13, W13.28	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.12, W13.27	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.11, W13.26	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.10, W13.25	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.9, W13.24	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.8, W13.23	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.7, W13.22	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.6, W13.21	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.5, W13.20	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.4, W13.19	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.3, W13.18	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.2, W13.17	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W13.1, W13.16	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W14.1, W14.2, W14.3, W14.4	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W15.1, W15.2, W15.3, W15.4	16.08	Laser Lap welds		GJN	2	-	10%	100%
P16B	W16.1, W16.2, W16.3, W16.4	16.08	Laser Lap welds		GJN	2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Manually						
P17B	W1.1	7.08	LH, BW, top & top pl			5	100%	100%	100%		
P17B	W1.2	7.08	LH, BW, top & top pl			5	100%	100%	100%		
P17B	W4.1	9.08	LH, FW, side pl. h		GJN	5	-	100%	100%		
P17B	W4.2	9.08	LH, FW, side pl. h		GJN	5	-	100%	100%		
P17B	W5.1	9.08	R, FW, side pl. h		GJN	5	-	100%	100%		
P17B	W5.2	9.08	R, FW, side pl. h		GJN	5	-	100%	100%		
P17B	W7.1, W6.1, W7.16	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.2, W6.2, W7.17	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.3, W6.3, W7.18	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.4, W6.4, W7.19	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.5, W6.5, W7.20	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.6, W6.6, W7.21	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.7, W6.7, W7.22	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.8, W6.8, W7.23	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		
P17B	W7.9, W6.9, W7.24	9.08	LH+R, FW, L profile		GJN	5	-	20%	100%		

P17B	W7.10, W6.10, W7.25	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.11, W6.11, W7.26	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.12, W6.12, W7.27	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.13, W6.13, W7.28	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.14, W6.14, W7.29	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.15, W6.15, W7.30	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.31, W6.16, W7.46	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.32, W6.17, W7.47	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.33, W6.18, W7.48	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.34, W6.19, W7.49	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.35, W6.20, W7.50	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.36, W6.21, W7.51	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.37, W6.22, W7.52	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.38, W6.23, W7.53	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.39, W6.24, W7.54	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.40, W6.25, W7.55	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.41, W6.26, W7.56	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.42, W6.27, W7.57	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.43, W6.28, W7.58	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.44, W6.29, W7.59	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W7.45, W6.30, W7.60	9.08	LH+R, FW, L profile	MM	G/JN		5	-	20%	100%
P17B	W8.1	9.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P17B	W8.2	9.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P17B	W9.1	9.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P17B	W9.2	9.08	R, Fillet, Tr, +top pl	MM			3	-	20%	100%
P17B	W10.1	9.08	LH, Fillet, Long, pl	MM			5	-	100%	100%
P17B	W10.2	9.08	LH, Fillet, Long, pl	MM			5	-	100%	100%
P17B	W57.1, W31.1, W31.16, W57.16	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.2, W31.2, W31.17, W57.17	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.3, W31.3, W31.18, W57.18	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.4, W31.4, W31.19, W57.19	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.5, W31.5, W31.20, W57.20	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.6, W31.6, W31.21, W57.21	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.7, W31.7, W31.22, W57.22	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.8, W31.8, W31.23, W57.23	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.9, W31.9, W31.24, W57.24	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.10, W31.10, W31.25, W57.25	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.11, W31.11, W31.26, W57.26	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.12, W31.12, W31.27, W57.27	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.13, W31.13, W31.28, W57.28	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.14, W31.14, W31.29, W57.29	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W57.15, W31.15, W31.30, W57.30	10.08	R, FW, vertical		G/JN		3	-	20%	100%
P17B	W39.1, W39.2, W32.2	10.08	R, fillet vert, lr+long		G/JN		3	-	20%	100%
P17B	W30.1, W38.1	10.08	R, fillet vert, lr+side		G/JN		3	-	20%	100%
P17B	W42.1	10.08	BW, long, pl.		G/JN		5	100%	100%	100%
P17B	W55.1, W55.2	10.08	BW, long, pl.		G/JN		5	100%	100%	100%
Bottom plate Welds										
P17B	W12.1, W12.2	16.08	Laser Lap welds		G/JN		2	-	10%	100%
P17B	W13.15, W13.30	16.08	Laser Lap welds		G/JN		2	-	10%	100%
P17B	W13.14, W13.29	16.08	Laser Lap welds		G/JN		2	-	10%	100%
P17B	W13.13, W13.28	16.08	Laser Lap welds		G/JN		2	-	10%	100%
P17B	W13.12, W13.27	16.08	Laser Lap welds		G/JN		2	-	10%	100%

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

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P17B	W13.11, W13.26	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.10, W13.25	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.9, W13.24	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.8, W13.23	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.7, W13.22	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.6, W13.21	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.5, W13.20	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.4, W13.19	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.3, W13.18	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.2, W13.17	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W13.1, W13.16	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W14.1, W14.2, W14.3, W14.4	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W15.1, W15.2, W15.3, W15.4	16.08	Laser Lap welds	GJN		2	-	10%	100%
P17B	W16.1, W16.2, W16.3, W16.4	16.08	Laser Lap welds	GJN		2	-	10%	100%

Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
P18B	W1.1	10.08	LH, BW top & top pl				5	100%	100%	100%		
P18B	W1.2	10.08	LH, BW top & top pl				5	100%	100%	100%		
P18B	W4.1	11.08	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P18B	W4.2	11.08	LH, FW, side pl. h	MM	GJN		5	-	100%	100%		
P18B	W5.1	11.08	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P18B	W5.2	11.08	R, FW, side pl. h	MM	GJN		5	-	100%	100%		
P18B	W7.31, W6.16, W7.46	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.32, W6.17, W7.47	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.33, W6.18, W7.48	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.34, W6.19, W7.49	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.35, W6.20, W7.50	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.36, W6.21, W7.51	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.37, W6.22, W7.52	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.38, W6.23, W7.53	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.39, W6.24, W7.54	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.40, W6.25, W7.55	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.41, W6.26, W7.56	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.42, W6.27, W7.57	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.43, W6.28, W7.58	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.44, W6.29, W7.59	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W7.45, W6.30, W7.60	11.08	LH+R, FW, L profile	MM	GJN		5	-	20%	100%		
P18B	W8.1	11.08	R, Fillet, Tr., +top pl	MM			3	-	20%	100%		
P18B	W8.2	11.08	R, Fillet, Tr., +top pl	MM			3	-	20%	100%		
P18B	W10.2	11.08	LH, Fillet, Long. pl.	MM			5	-	100%	100%		
P18B	W31.16, W57.16	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.17, W57.17	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.18, W57.18	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.19, W57.19	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.20, W57.20	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.21, W57.21	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.22, W57.22	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.23, W57.23	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.24, W57.24	11.08	R, FW, vertical		GJN		3	-	20%	100%		
P18B	W31.25, W57.25	11.08	R, FW, vertical		GJN		3	-	20%	100%		

Area inside sandwich deck was checked before closing. Weld defects are stated in NDT reports.

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Section	Welding no.	Date	Type of weld	Welder/ Operator ID	WIC	UT	MT/PT	VT	Registered doc.	Comments
P18B	W31.26, W57.26	11.08	R, FW, vertical	GJN	3	-	20%	100%		
P18B	W31.27, W57.27	11.08	R, FW, vertical	GJN	3	-	20%	100%		
P18B	W31.28, W57.28	11.08	R, FW, vertical	GJN	3	-	20%	100%		
P18B	W31.29, W57.29	11.08	R, FW, vertical	GJN	3	-	20%	100%		
P18B	W31.30, W57.30	11.08	R, FW, vertical	GJN	3	-	20%	100%		
P18B	W32.2	11.08	R, filled vert. tr+long	GJN	4	50%	100%	100%		
P18B	W30.1	11.08	R, filled vert. tr+side	GJN	3	-	20%	100%		
P18B	W55.1, W55.2	11.08	BW, long, pl.	GJN	5	100%	100%	100%		
Bottom plate Welds										
P18B	W12.2	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.30	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.29	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.28	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.27	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.26	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.25	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.24	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.23	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.22	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.21	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.20	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.19	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.18	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.17	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W13.16	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W14.3, W14.4	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W15.3, W15.4	16.08	Laser Lap welds	GJN	2	-	10%	100%		
P18B	W16.3, W16.4	16.08	Laser Lap welds	GJN	2	-	10%	100%		

Section	Welding no.	Date	Type of weld	Welder/ Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Manually						
Beam Akse 1-2	W18,	4.07	LH, BW, bunnflens & bunnflens	MM		5	100%	100%	100%		
Beam Akse 1-2	W20, W21,	4.07	R, FW, bunnflens & Langsgaende stegstivere	MM		2	-	5%	100%		
Beam Akse 1-2	W22,	4.07	R, FW, Bunnflens & Tversteg Lager	MM	GJN	5	100%	100%	100%		
Beam Akse 1-2	W23.1, W23.2	4.07	R, FW, Tverrame + bunnflens	MM	GJN	3	-	20%	100%		
Beam Akse 1-2	W27.1, W27.2, W27.3, W27.4, W27.5, W27.6	4.07	R, FW, long+ bunnflens	MM	GJN	2	-	5%	100%		
Beam Akse 1-2	W42	4.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere	MM	GJN	5	100%	100%	100%		
Beam Akse 1-2	W19	4.07	R, FW, Bunnflens & Lagerbrakett	MM	GJN	3	-	20%	100%		
Beam Akse 1-2	W24	4.07	R, BW, Bunnflens & Tverbjelke flens	MM	GJN	3	20%	20%	100%		
Beam Akse 1-2	W26	4.07	R, FW, Bunnflens & Lagerfundament	MM	GJN	3	-	20%	100%		
Beam Akse 1-2	W34, W35	4.07	R, FW, Tverbjelke & Langsgaende stegstivere	MM	GJN	4	-	100%	100%		
Beam Akse 1-2	W36	4.07	R, FW, Tverbjelke & Tverbjelke flens	MM	GJN	2	-	5%	100%		
Beam Akse 1-2	W43, W44, W45	4.07	R, FW, Tverrame steg & Langsgaende stegstiver	MM	GJN	3	-	20%	100%		
Beam Akse 1-2	W46	4.07	R, FWvert. endeplate & Langsgaende stegstiver	MM	GJN	4	-	100%	100%		
Beam Akse 1-2	W69.1	6.07	M, BW Bunnflens & Bunnflens	MM	MM	5	100%	100%	100%		
Beam Akse 1-2	W69.2	6.07	M, BW Bunnflens & Bunnflens	MM	MM	5	100%	100%	100%		

Section	Welding no.	Date	Type of weld	Welder/ Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
Beam Akse 1-2	W69.3	6.07	M, BW, Bumfflens & Bumfflens									
Beam Akse 1-2	W69.4	6.07	M, BW, Bumfflens & Bumfflens									
Beam Akse 1-2	W42.1	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.2	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.3	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.4	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.5	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.6	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.7	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W42.8	6.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere									
Beam Akse 1-2	W53.1	18.07	M, BW, Langsgaende Flens & Tverramme Flens				Laskowski Rafal	3	20%	20%	100%	
Beam Akse 1-2	W53.2	18.07	M, BW, Langsgaende Flens & Tverramme Flens				Laskowski Rafal	3	20%	20%	100%	
Beam Akse 1-2	W53.3	18.07	M, BW, Langsgaende Flens & Tverramme Flens				Laskowski Rafal	3	20%	20%	100%	
Beam Akse 1-2	W53.4	18.07	M, BW, Langsgaende Flens & Tverramme Flens				Laskowski Rafal	3	20%	20%	100%	
Beam Akse 1-2	W53.5	18.07	M, BW, Langsgaende Flens & Tverramme Flens				Laskowski Rafal	3	20%	20%	100%	
Beam Akse 1-2	W53.6	18.07	M, BW, Langsgaende Flens & Tverramme Flens				Laskowski Rafal	3	20%	20%	100%	
Beam Akse 1-2	W52.1	27.07	M, Langsgaende Profil & Tverramme Steg				Knasinski Mariu	3	-	20%	100%	
Beam Akse 1-2	W52.2	27.07	M, Langsgaende Profil & Tverramme Steg				Knasinski Mariu	3	-	20%	100%	
Beam Akse 1-2	W52.3	27.07	M, Langsgaende Profil & Tverramme Steg				Knasinski Mariu	3	-	20%	100%	
Beam Akse 1-2	W52.4	27.07	M, Langsgaende Profil & Tverramme Steg				Knasinski Mariu	3	-	20%	100%	
Beam Akse 1-2	W52.5	27.07	M, Langsgaende Profil & Tverramme Steg				Knasinski Mariu	3	-	20%	100%	
Beam Akse 1-2	W52.6	27.07	M, Langsgaende Profil & Tverramme Steg				Knasinski Mariu	3	-	20%	100%	
Beam Akse 1-2	W71.1	27.07	M, T full pen, Bumfflens, Tversteg				Knasinski Mariu	5	-	100%	100%	
Beam Akse 2-3	W18,	3.07	LH, BW, bumfflens & bumfflens	MM								
Beam Akse 2-3	W20, W21,	3.07	R, FW, bumfflens & Langsgaende stegstivere	MM								
Beam Akse 2-3	W22, /71	3.07	R, FW, Bumfflens & Tversteg Lager	MM	GJN							
Beam Akse 2-3	W23.1, W23.2	3.07	R, FW, Tverramme + bumfflens	MM	GJN							
Beam Akse 2-3	W27.1, W27.2, W27.3, W27.4, W27.5, W27.6	3.07	R, FW, long+ bumfflens	MM	GJN							
Beam Akse 2-3	W42	3.07	R, BW, Langsgaende stegstivere & Langsgaende stegstivere	MM	GJN							

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Section	Welding no.	Date	Type of weld	Welder/Operator ID			WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot	Manually						
Beam Akse 2-3	W19	3.07	R, FW, Bumflens & Lagerbrøkket	MM	GJN		3	-	20%	100%		
Beam Akse 2-3	W24	3.07	R, BW, Bumflens & Tverbjelke: Flens	MM	GJN		3	20%	20%	100%		
Beam Akse 2-3	W26	3.07	R, FW, Bumflens & Lagerfundament	MM	GJN		3	-	20%	100%		
Beam Akse 2-3	W34, W35	3.07	R, FW, Tverbjelke & Langsgående stegstivere	MM	GJN		4	-	100%	100%		
Beam Akse 2-3	W36	3.07	R, FW, Tverbjelke & Tverbjelke: flens	MM	GJN		2	-	5%	100%		
Beam Akse 2-3	W43, W44, W45	3.07	R, FW, Tverramme steg & Langsgående stegstiver	MM	GJN		3	-	20%	100%		
Beam Akse 2-3	W46	3.07	R, FWvert. endplate & Langsgående stegstiver	MM	GJN		4	-	100%	100%		
Beam Akse 2-3	W69.1 interior	5.07	M, BW Bumflens & Bumflens	MM	MM		5	100%	100%	100%		
Beam Akse 2-3	W69.2	5.07	M, BW Bumflens & Bumflens	MM	MM		5	100%	100%	100%		
Beam Akse 2-3	W69.3	5.07	M, BW Bumflens & Bumflens	MM	MM		5	100%	100%	100%		
Beam Akse 2-3	W69.4	5.07	M, BW Bumflens & Bumflens	MM	MM		5	100%	100%	100%		
Beam Akse 2-3	W42.1	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.2	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.3	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.4	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.5	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.6	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.7	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W42.8	5.07	R, BW, Langsgående stegstivere & Langsgående stegstivere		MM		5	100%	100%	100%		
Beam Akse 2-3	W53.1	14.07	M, BW, Langsgående Flens & Tverramme Flens			Kurowski Damić	3		20%	100%		
Beam Akse 2-3	W53.2	14.07	M, BW, Langsgående Flens & Tverramme Flens			Kurowski Damić	3		20%	100%		
Beam Akse 2-3	W53.3	14.07	M, BW, Langsgående Flens & Tverramme Flens			Kurowski Damić	3		20%	100%		
Beam Akse 2-3	W53.4	14.07	M, BW, Langsgående Flens & Tverramme Flens			Kurowski Damić	3		20%	100%		
Beam Akse 2-3	W53.5	14.07	M, BW, Langsgående Flens & Tverramme Flens			Kurowski Damić	3		20%	100%		
Beam Akse 2-3	W53.6	14.07	M, BW, Langsgående Flens & Tverramme Flens			Kurowski Damić	3		20%	100%		
Beam Akse 2-3	W52.1	14.07	M, Langsgående Profil & Tverramme Steg			Kurowski Damić	3	-	20%	100%		
Beam Akse 2-3	W52.2	11.08	M, Langsgående Profil & Tverramme Steg			Kurowski Damić	3	-	20%	100%		
Beam Akse 2-3	W52.3	11.08	M, Langsgående Profil & Tverramme Steg			Moczyński Tomaš	3	-	20%	100%		
Beam Akse 2-3	W52.4	11.08	M, Langsgående Profil & Tverramme Steg			Moczyński Tomaš	3	-	20%	100%		
Beam Akse 2-3	W52.5	11.08	M, Langsgående Profil & Tverramme Steg			Moczyński Tomaš	3	-	20%	100%		
Beam Akse 2-3	W52.6	11.08	M, Langsgående Profil & Tverramme Steg			Moczyński Tomaš	3	-	20%	100%		
Beam Akse 2-3	W71.1	11.08	M, T full pen, Bumflens, Tverrsleg			Moczyński Tomaš	5	-	100%	100%		

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Beam Akse 3-4	W18, W20, W21, W22, W23.1, W23.2, W27.1, W27.2, W27.3, W27.4, W27.5, W27.6	8.08	LH, BW, bunntflens & bunntflens	MM		5	100%	100%	100%
Beam Akse 3-4	W20, W21, W22, W23.1, W23.2	8.08	R, FW, bunntflens & Langsgaende stegstivere	MM		2	-	5%	100%
Beam Akse 3-4	W27.1, W27.2, W27.3, W27.4, W27.5, W27.6	8.08	R, FW, Bunntflens & Tversteg Lager	MM		5	100%	100%	100%
Beam Akse 3-4	W42	8.08	R, FW, Tverramme + bunntflens	MM		3	-	20%	100%
Beam Akse 3-4	W42	8.08	R, FW, lang+ bunntflens	MM		2	-	5%	100%
Beam Akse 3-4	W42	8.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere	MM		5	100%	100%	100%
Beam Akse 3-4	W19	8.08	R, FW, Bunntflens & Lagerbrakett	MM		3	-	20%	100%
Beam Akse 3-4	W24	8.08	R, BW, Bunntflens & Tverbjelke Flens	MM		3	20%	20%	100%
Beam Akse 3-4	W26	8.08	R, FW, Bunntflens & Lagerfundament	MM		3	-	20%	100%
Beam Akse 3-4	W34, W35	8.08	R, FW, Tverbjelke & Langsgaende stegstivere	MM		4	-	100%	100%
Beam Akse 3-4	W36	8.08	R, FW, Tverbjelke & Tverbjelke flens	MM		2	-	5%	100%
Beam Akse 3-4	W43, W44, W45	8.08	R, FW, Tverramme steg & Langsgaende stegstiver	MM		3	-	20%	100%
Beam Akse 3-4	W46	8.08	R, FWvert. endplate & Langsgaende stegstiver	MM		4	-	100%	100%
Beam Akse 3-4	W69.1	15.08	M, BW, Bunntflens & Bunntflens		Czarnecki JACE	5	100%	100%	100%
Beam Akse 3-4	W69.2	15.08	M, BW, Bunntflens & Bunntflens		Czarnecki JACE	5	100%	100%	100%
Beam Akse 3-4	W69.3	15.08	M, BW, Bunntflens & Bunntflens		Czarnecki JACE	5	100%	100%	100%
Beam Akse 3-4	W69.4	15.08	M, BW, Bunntflens & Bunntflens		Czarnecki JACE	5	100%	100%	100%
Beam Akse 3-4	W42.1	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.2	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.3	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.4	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.5	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.6	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.7	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W42.8	15.08	R, BW, Langsgaende stegstivere & Langsgaende stegstivere		MM	5	100%	100%	100%
Beam Akse 3-4	W53.1	15.08	M, BW, Langsgaende Flens & Tverramme Flens		Robert Smyrel	3		20%	100%
Beam Akse 3-4	W53.2	15.08	M, BW, Langsgaende Flens & Tverramme Flens		Robert Smyrel	3		20%	100%
Beam Akse 3-4	W53.3	15.08	M, BW, Langsgaende Flens & Tverramme Flens		Robert Smyrel	3		20%	100%
Beam Akse 3-4	W53.4	15.08	M, BW, Langsgaende Flens & Tverramme Flens		Robert Smyrel	3		20%	100%
Beam Akse 3-4	W53.5	15.08	M, BW, Langsgaende Flens & Tverramme Flens		Robert Smyrel	3		20%	100%
Beam Akse 3-4	W53.6	15.08	M, BW, Langsgaende Flens & Tverramme Flens		Robert Smyrel	3		20%	100%
Beam Akse 3-4	W52.1	16.08	M, Langsgaende Profil & Tverramme Steg		Czarnecki JACE	3	-	20%	100%
Beam Akse 3-4	W52.2	16.08	M, Langsgaende Profil & Tverramme Steg		Czarnecki JACE	3	-	20%	100%

UT, MT, VT reports, measurement and pressure test report



Beam Akse 3-4	W52.3	16.08	M. Langsgående Profil&Tverramme Stieg	MM	Czarnecki JAce	3	-	20%	100%
Beam Akse 3-4	W52.4	16.08	M. Langsgående Profil&Tverramme Stieg	MM	Czarnecki JAce	3	-	20%	100%
Beam Akse 3-4	W52.5	16.08	M. Langsgående Profil&Tverramme Stieg	MM	Czarnecki JAce	3	-	20%	100%
Beam Akse 3-4	W52.6	16.08	M. Langsgående Profil&Tverramme Stieg	MM	Czarnecki JAce	3	-	20%	100%
Beam Akse 3-4	W71.1	16.08	M. T full pen, Bunnflens, Tverstieg	MM	Czarnecki JAce	5	-	100%	100%

Section	Welding no.	Date	Type of weld	Weilder/ Operator ID		WIC	UT	MT/PT	VT	Registered doc.	Comments
				Laser	Robot						
Beam Akse 4-5	W18,	9.08	LH, BW, bunnflens & bunnflens	MM			100%	100%	100%		
Beam Akse 4-5	W20, W21,	9.08	R, FW, bunnflens & Langsgående stegsilvere	MM			-	5%	100%		
Beam Akse 4-5	W22,	9.08	R, FW, Bunnflens & Tverstieg Lager	MM	GJN		100%	100%	100%		
Beam Akse 4-5	W23.1, W23.2	9.08	R, FW, Tverramme + bunnflens	MM	GJN		-	20%	100%		
Beam Akse 4-5		9.08	R, FW, long+ bunnflens	MM	GJN		-	5%	100%		
Beam Akse 4-5	W19	9.08	R, FW, Bunnflens & Lagerbrakett	MM	GJN		-	20%	100%		
Beam Akse 4-5	W24	9.08	R, BW, Bunnflens & Tverbjelke flens	MM	GJN		20%	20%	100%		
Beam Akse 4-5	W26	9.08	R, FW, Bunnflens & Lagerfundament	MM	GJN		-	20%	100%		
Beam Akse 4-5	W34, W35	9.08	R, FW, Tverbjelke&Langsgående stegsilvere	MM	GJN		-	100%	100%		
Beam Akse 4-5	W36	9.08	R, FW, Tverbjelke & Tverbjelke flens	MM	GJN		-	5%	100%		
Beam Akse 4-5	W43, W44, W45	9.08	R, FW, Tverramme steg & Langsgående stegsilver	MM	GJN		-	20%	100%		UT, MT, VT reports, measurement and pressure test report
Beam Akse 4-5	W46	9.08	R, FWvert. endplate& Langsgående stegsilver	MM	GJN		-	100%	100%		
Beam Akse 4-5	W69.1	20.08	M, BW Bunnflens & Bunnflens		Michno Marcin		100%	100%	100%		
Beam Akse 4-5	W69.2	20.08	M, BW Bunnflens & Bunnflens		Michno Marcin		100%	100%	100%		
Beam Akse 4-5	W42.1	20.08	R, BW, Langsgående stegsilvere&Langsgående stegsilvere		Michno Marcin		100%	100%	100%		
Beam Akse 4-5	W42.2	20.08	R, BW, Langsgående stegsilvere&Langsgående stegsilvere		Michno Marcin		100%	100%	100%		
Beam Akse 4-5	W42.3	20.08	R, BW, Langsgående stegsilvere&Langsgående stegsilvere		Michno Marcin		100%	100%	100%		
Beam Akse 4-5	W42.4	20.08	R, BW, Langsgående stegsilvere&Langsgående stegsilvere		Michno Marcin		100%	100%	100%		



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-12</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P15A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

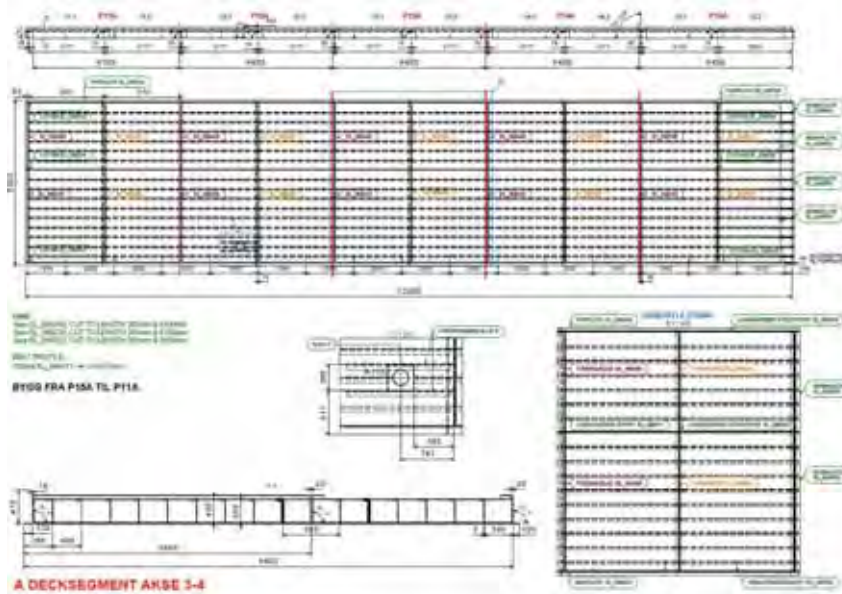
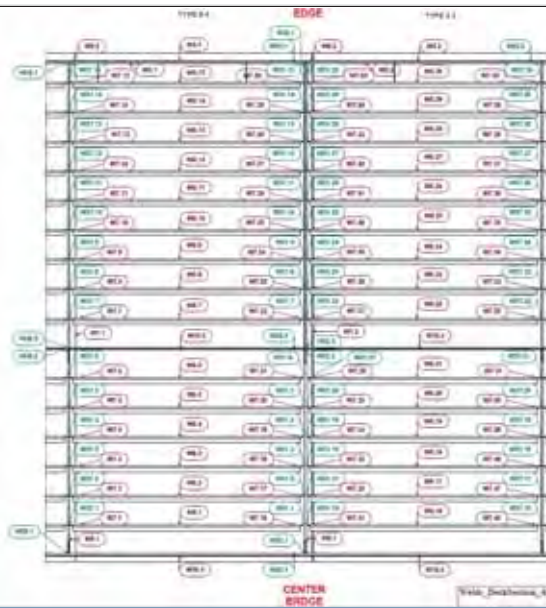
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-19

REPORT NO. / RAPPORT NR.  
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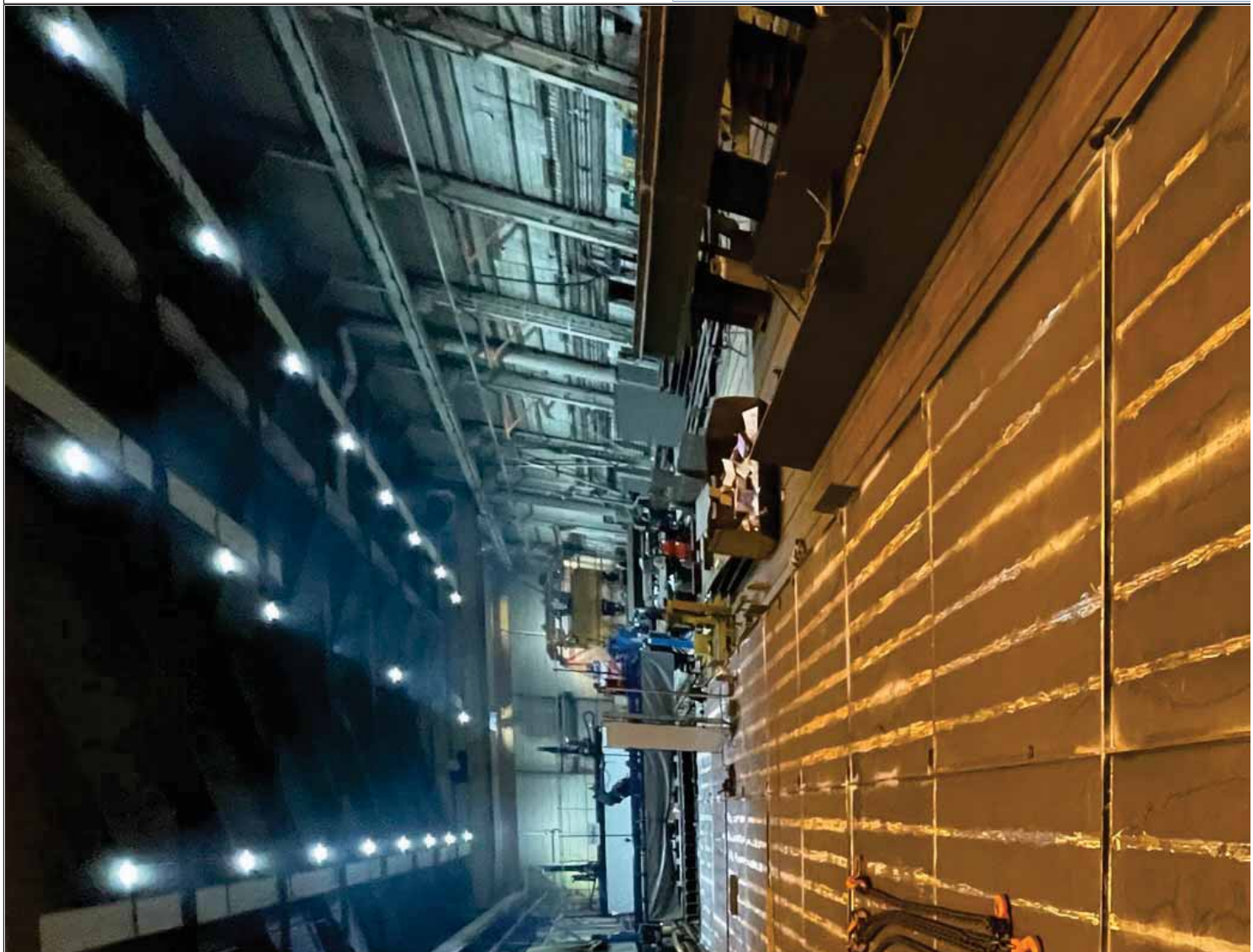
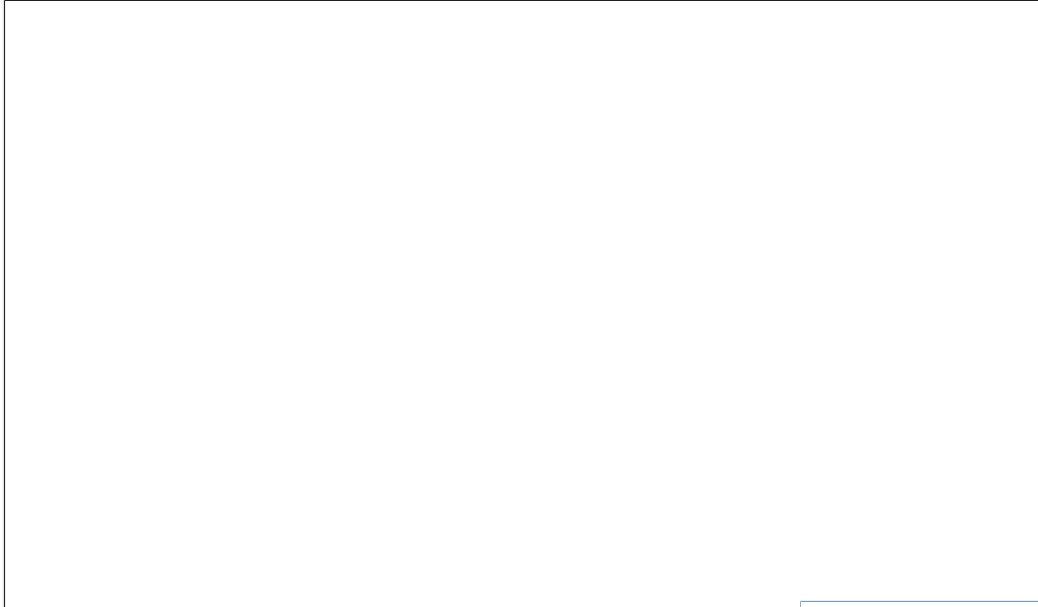


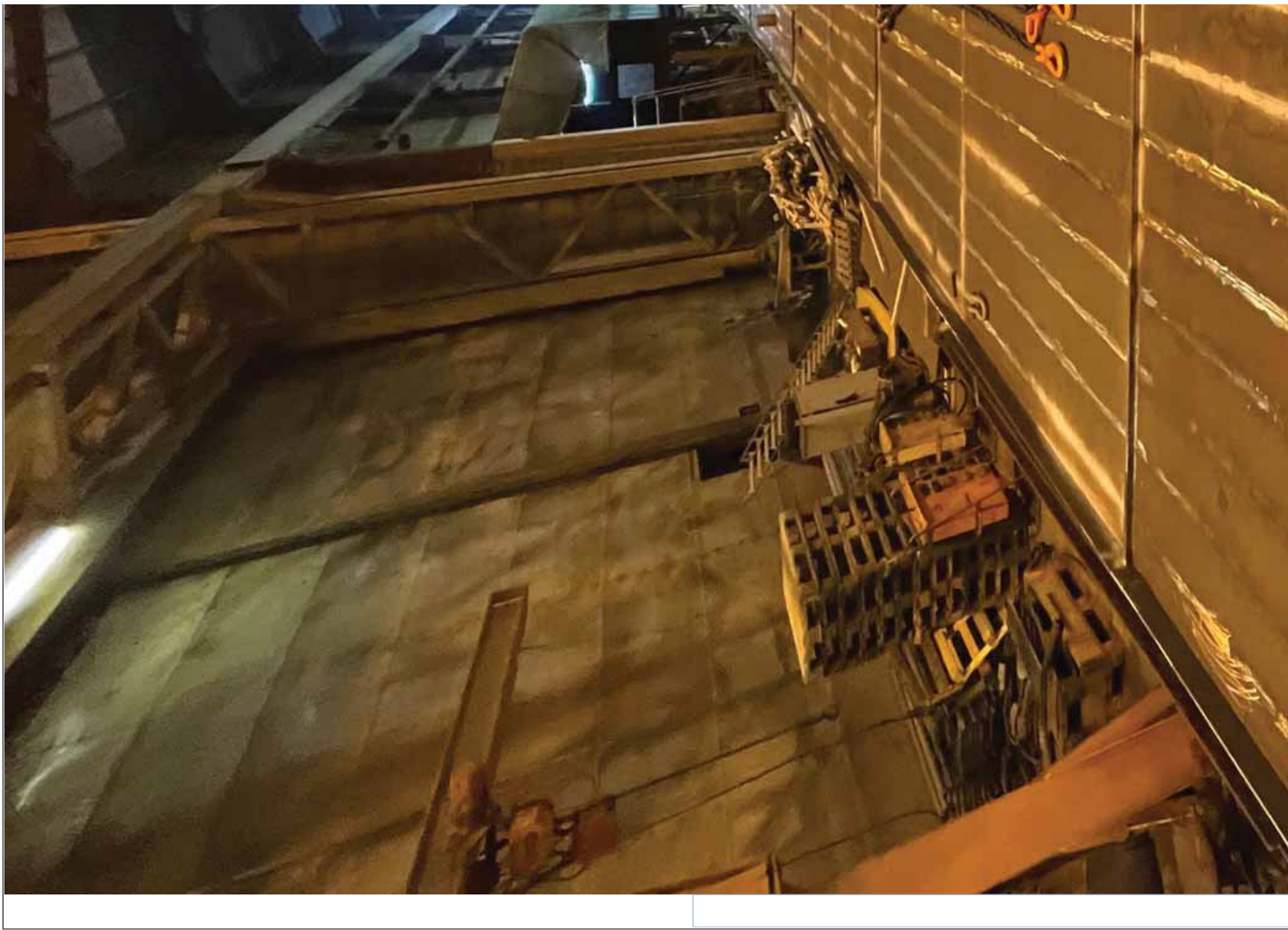




# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-12</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Doru Baci</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-13</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P14A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

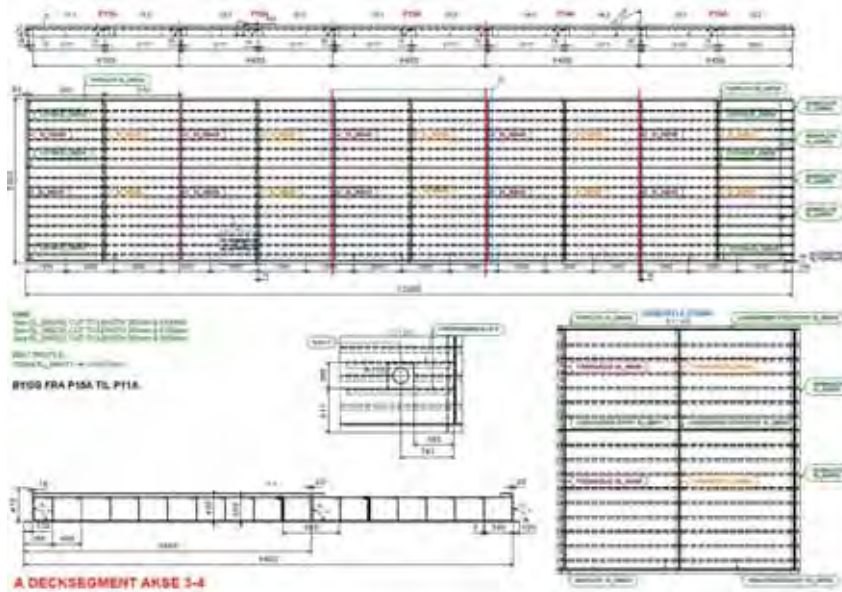
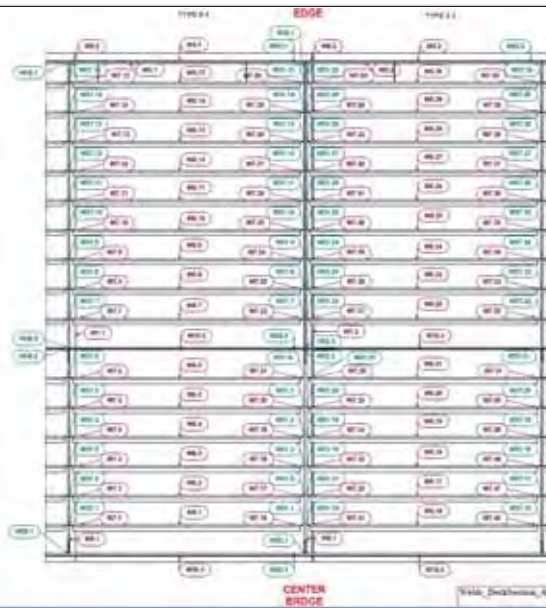
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-19

REPORT NO. / RAPPORT NR.  
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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-13</b>	PAGE / SIDE <b>3 of av 4</b>
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Welding no.	Date	Fillet on batch no.	ET Monthly	Wc	St	MT PT	VT
W1.1				1	100%	100%	100%
W1.2				1	100%	100%	100%
W1.3				1	100%	100%	100%
W1.4				1	100%	100%	100%
W1.5				1	100%	100%	100%
W1.6				1	100%	100%	100%
W1.7				1	100%	100%	100%
W1.8				1	100%	100%	100%
W1.9				1	100%	100%	100%
W1.10				1	100%	100%	100%
W1.11				1	100%	100%	100%
W1.12				1	100%	100%	100%
W1.13				1	100%	100%	100%
W1.14				1	100%	100%	100%
W1.15				1	100%	100%	100%
W1.16				1	100%	100%	100%
W1.17				1	100%	100%	100%
W1.18				1	100%	100%	100%
W1.19				1	100%	100%	100%
W1.20				1	100%	100%	100%
W1.21				1	100%	100%	100%
W1.22				1	100%	100%	100%
W1.23				1	100%	100%	100%
W1.24				1	100%	100%	100%
W1.25				1	100%	100%	100%
W1.26				1	100%	100%	100%
W1.27				1	100%	100%	100%
W1.28				1	100%	100%	100%
W1.29				1	100%	100%	100%
W1.30				1	100%	100%	100%
W1.31				1	100%	100%	100%
W1.32				1	100%	100%	100%
W1.33				1	100%	100%	100%
W1.34				1	100%	100%	100%
W1.35				1	100%	100%	100%
W1.36				1	100%	100%	100%
W1.37				1	100%	100%	100%
W1.38				1	100%	100%	100%
W1.39				1	100%	100%	100%
W1.40				1	100%	100%	100%
W1.41				1	100%	100%	100%
W1.42				1	100%	100%	100%
W1.43				1	100%	100%	100%
W1.44				1	100%	100%	100%
W1.45				1	100%	100%	100%
W1.46				1	100%	100%	100%
W1.47				1	100%	100%	100%
W1.48				1	100%	100%	100%
W1.49				1	100%	100%	100%
W1.50				1	100%	100%	100%
W1.51				1	100%	100%	100%
W1.52				1	100%	100%	100%
W1.53				1	100%	100%	100%
W1.54				1	100%	100%	100%
W1.55				1	100%	100%	100%
W1.56				1	100%	100%	100%
W1.57				1	100%	100%	100%
W1.58				1	100%	100%	100%
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W1.60				1	100%	100%	100%
W1.61				1	100%	100%	100%
W1.62				1	100%	100%	100%
W1.63				1	100%	100%	100%
W1.64				1	100%	100%	100%
W1.65				1	100%	100%	100%
W1.66				1	100%	100%	100%
W1.67				1	100%	100%	100%
W1.68				1	100%	100%	100%
W1.69				1	100%	100%	100%
W1.70				1	100%	100%	100%
W1.71				1	100%	100%	100%
W1.72				1	100%	100%	100%
W1.73				1	100%	100%	100%
W1.74				1	100%	100%	100%
W1.75				1	100%	100%	100%
W1.76				1	100%	100%	100%
W1.77				1	100%	100%	100%
W1.78				1	100%	100%	100%
W1.79				1	100%	100%	100%
W1.80				1	100%	100%	100%
W1.81				1	100%	100%	100%
W1.82				1	100%	100%	100%
W1.83				1	100%	100%	100%
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W1.93				1	100%	100%	100%
W1.94				1	100%	100%	100%
W1.95				1	100%	100%	100%
W1.96				1	100%	100%	100%
W1.97				1	100%	100%	100%
W1.98				1	100%	100%	100%
W1.99				1	100%	100%	100%
W1.100				1	100%	100%	100%

W11.1	W11.2	W11.3	W11.4	400100		1	100%	100%
W11.5	W11.6	W11.7	W11.8	400100		1	100%	100%
W11.9	W11.10	W11.11	W11.12	400100		1	100%	100%
W11.13	W11.14	W11.15	W11.16	400100		1	100%	100%
W11.17	W11.18	W11.19	W11.20	400100		1	100%	100%
W11.21	W11.22	W11.23	W11.24	400100		1	100%	100%
W11.25	W11.26	W11.27	W11.28	400100		1	100%	100%
W11.29	W11.30	W11.31	W11.32	400100		1	100%	100%
W11.33	W11.34	W11.35	W11.36	400100		1	100%	100%
W11.37	W11.38	W11.39	W11.40	400100		1	100%	100%
W11.41	W11.42	W11.43	W11.44	400100		1	100%	100%
W11.45	W11.46	W11.47	W11.48	400100		1	100%	100%
W11.49	W11.50	W11.51	W11.52	400100		1	100%	100%
W11.53	W11.54	W11.55	W11.56	400100		1	100%	100%
W11.57	W11.58	W11.59	W11.60	400100		1	100%	100%
W11.61	W11.62	W11.63	W11.64	400100		1	100%	100%
W11.65	W11.66	W11.67	W11.68	400100		1	100%	100%
W11.69	W11.70	W11.71	W11.72	400100		1	100%	100%
W11.73	W11.74	W11.75	W11.76	400100		1	100%	100%
W11.77	W11.78	W11.79	W11.80	400100		1	100%	100%
W11.81	W11.82	W11.83	W11.84	400100		1	100%	100%
W11.85	W11.86	W11.87	W11.88	400100		1	100%	100%
W11.89	W11.90	W11.91	W11.92	400100		1	100%	100%
W11.93	W11.94	W11.95	W11.96	400100		1	100%	100%
W11.97	W11.98	W11.99	W11.100	400100		1	100%	100%



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-13</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Doru Baci</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-14</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P13A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

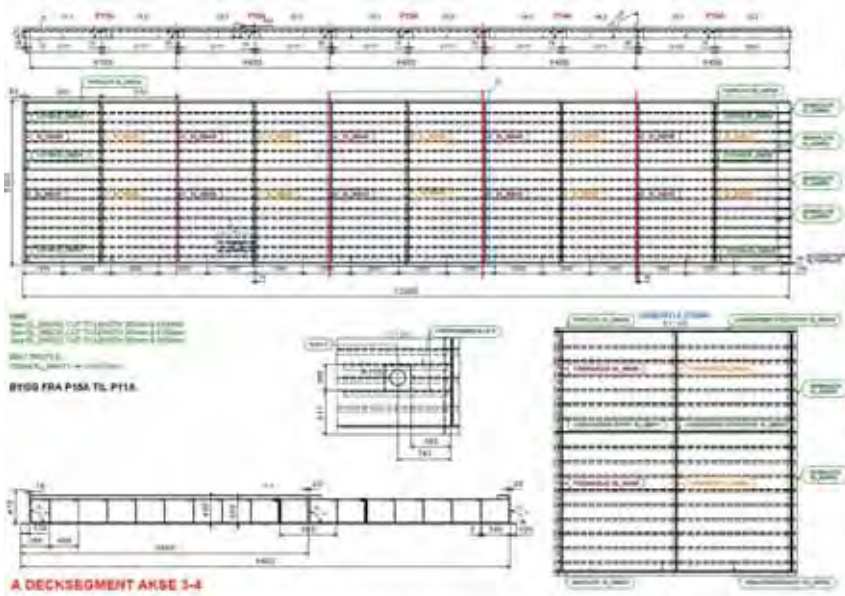
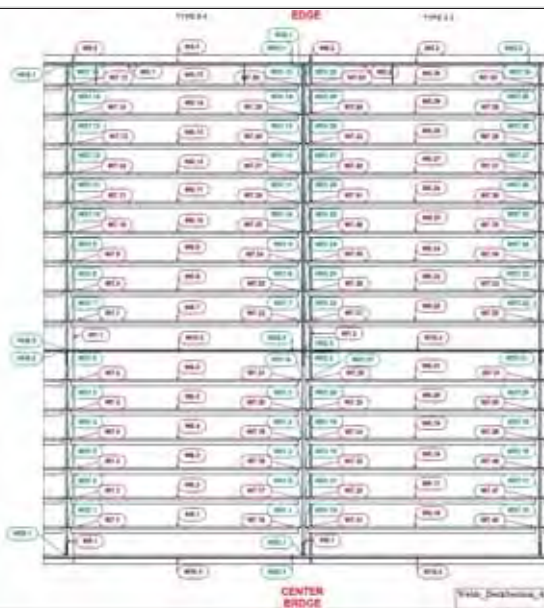
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-25

REPORT NO. / RAPPORT NR.  
10031-23-VT-14

PAGE / SIDE  
2 of/av 4







# Visual Control Visuell kontroll

CLIENT / KUNDE Prodtex industri as	CLIENT O.NO / KUNDE O.NR 20021 - Elverhøy	DATE OF TESTING / KONTROLLDATO 2023-05-25	REPORT NO. / RAPPORT NR. 10031-23-VT-14	PAGE / SIDE 3 of/av 4
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Welding no.	Date	Fillet on batch no.	EP Monthly	Wa.	St.	MTD.	Vt
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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-14</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Doru Baci</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-15</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P11A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

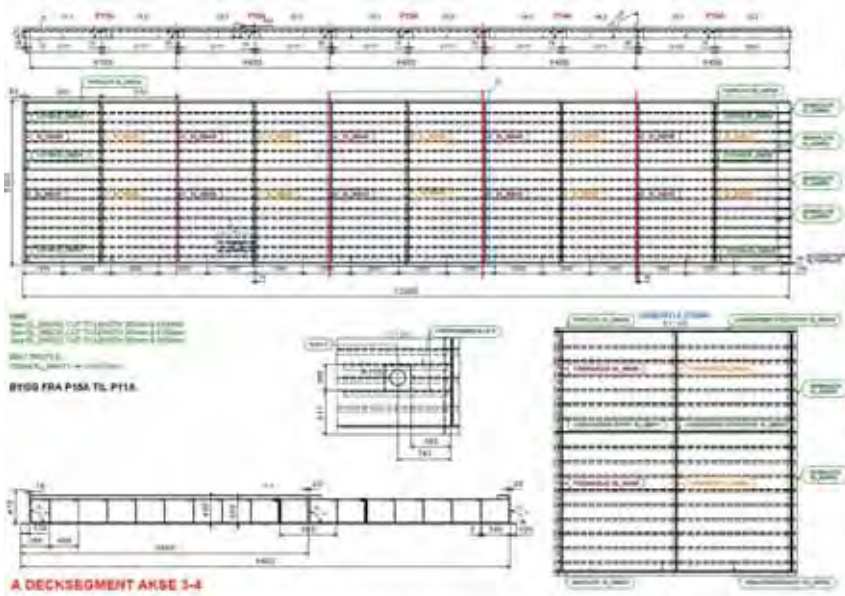
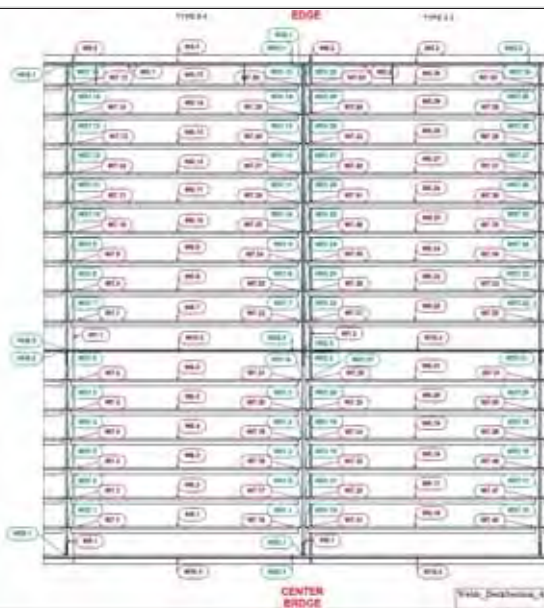
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-30

REPORT NO. / RAPPORT NR.  
10031-23-VT-15

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2 of/av 4









# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-15</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-16</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P12A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

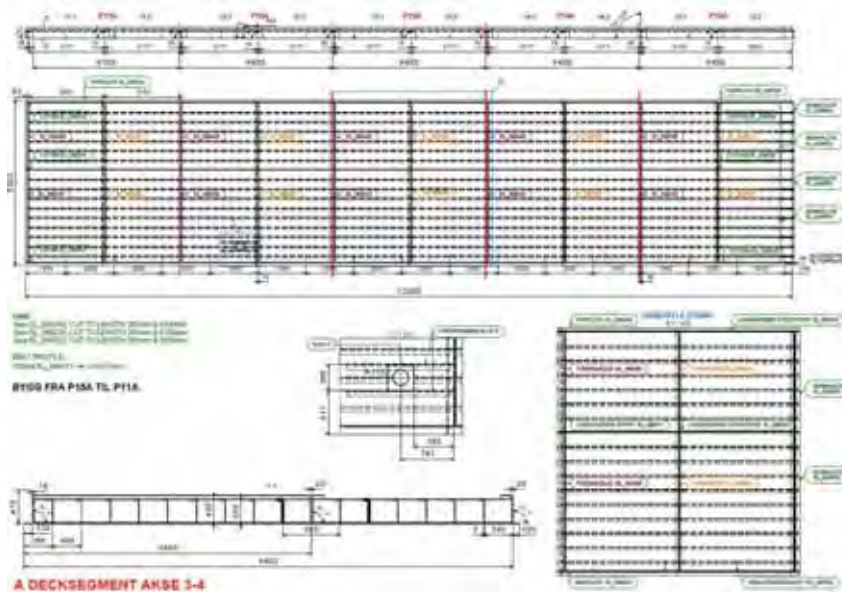
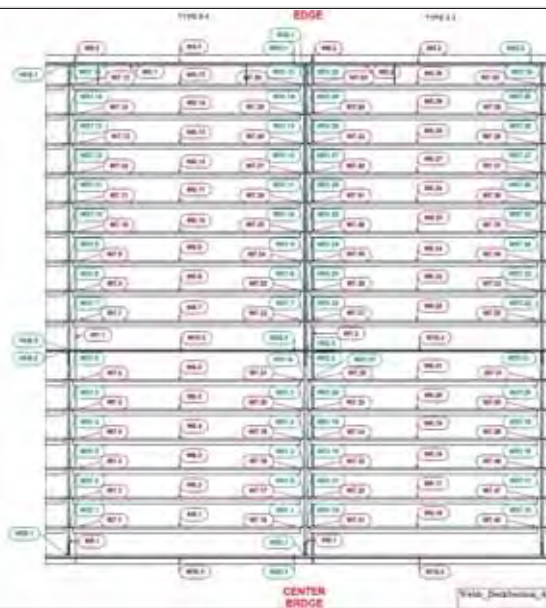
CLIENT / KUNDE  
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CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-30

REPORT NO. / RAPPORT NR.  
10031-23-VT-16

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# Visual Control Visuell kontroll

CLIENT / KUNDE Prodtext industri as	CLIENT O.NO / KUNDE O.NR 20021 - Elverhøy	DATE OF TESTING / KONTROLLDATO 2023-05-30	REPORT NO. / RAPPORT NR. 10031-23-VT-16	PAGE / SIDE 3 of/ av 4
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Welding no.	Date	Fillet on Batch no.	ET Monthly	Wc	St	MTPT	VT
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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-16</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-17</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of sluk weld and HAZ Deck section A (P7A) AKSE 2-3 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Weld nr. 83,84,85,86,87,88,89. No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

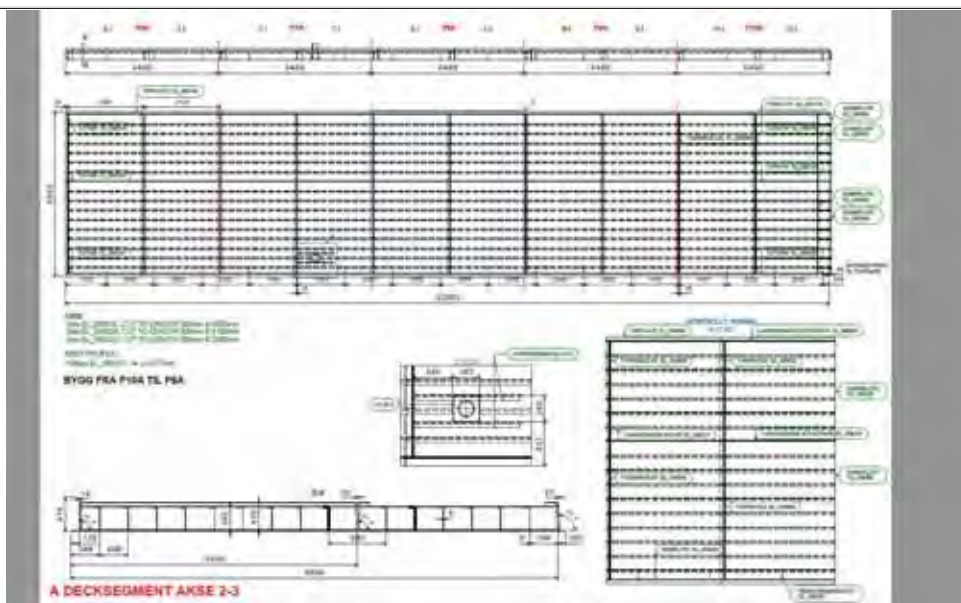
CLIENT / KUNDE  
**Prodtex industri as**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-06-02**

REPORT NO. / RAPPORT NR.  
**10031-23-VT-17**

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**2 of/av 3**







# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-17</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-17 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATØR / OPERATØR DATO:2023-07-17 <i>Doru Baci</i>



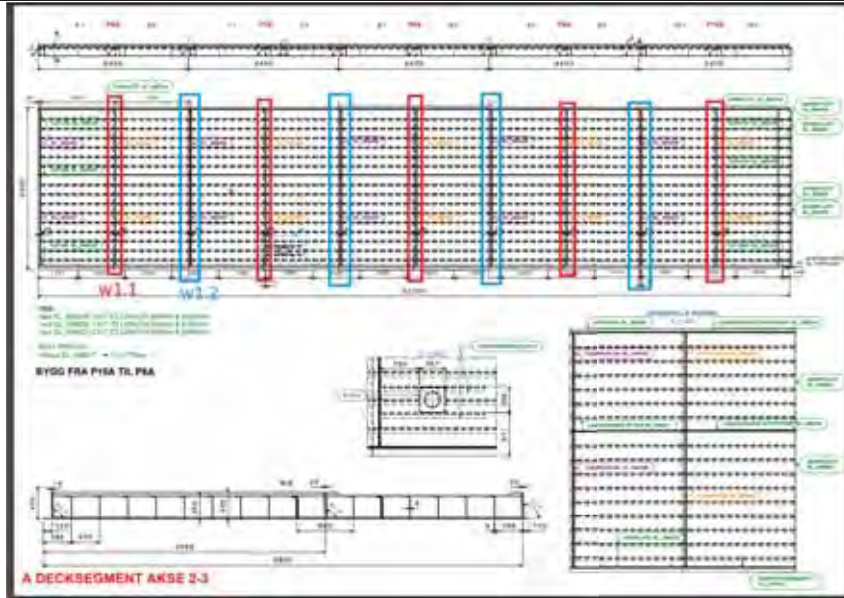
# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-18</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w1.1\w1.2 and HAZ at A decksegment AKSE 2-3 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking (VT).</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-18</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-19 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-06-19 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-24</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P18A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

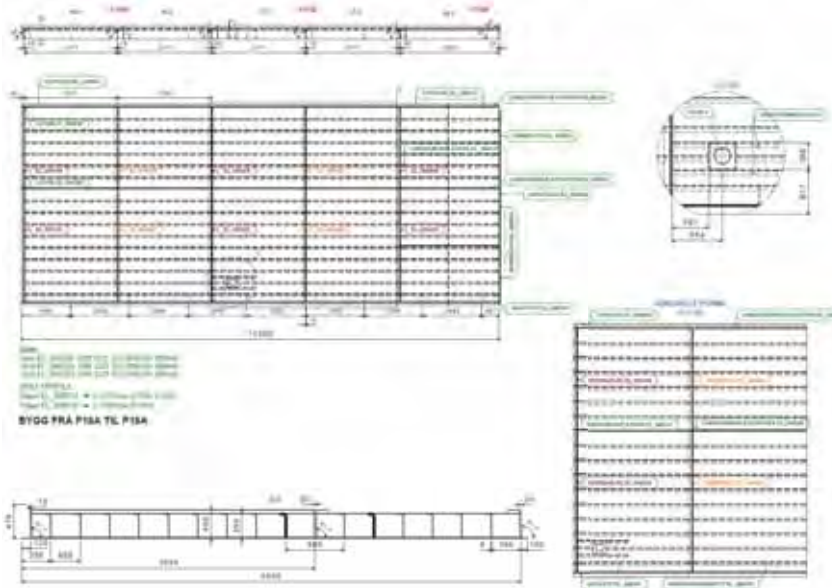
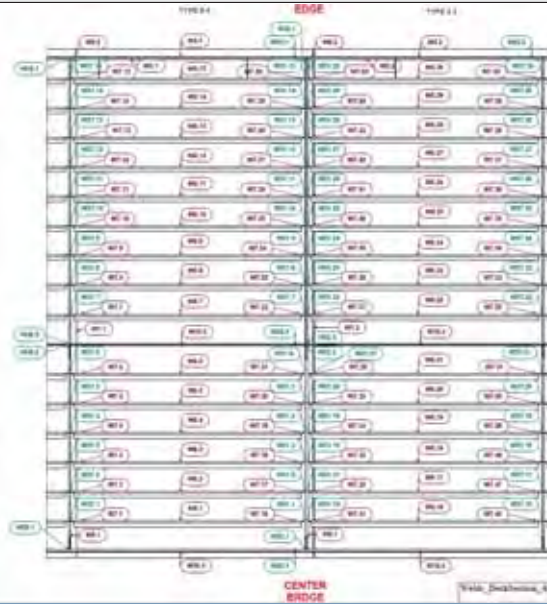
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-16

REPORT NO. / RAPPORT NR.  
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2 of/av 4





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-24</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Please to look up from two plates. Please refer to the tables below.

4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& bottom pl
W1.2	100%	100%	100%	LH, BW top& bottom pl
W4.1	-	100%	100%	R&LH, FW, side pl. h
W4.2	-	100%	100%	R&LH, FW t, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH&R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH&R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH&R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH&R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH&R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH&R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH&R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH&R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH&R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH&R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH&R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH&R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH&R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH&R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH&R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH&R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH&R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH&R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH&R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH&R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH&R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH&R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH&R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH&R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH&R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH&R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH&R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH&R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH&R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH&R, FW L profile
W8.1	-	20%	100%	R, Fillet, Tr - stop pl
W8.2	-	20%	100%	R, Fillet, Tr - stop pl
W9.1	-	20%	100%	LH, Fillet, Tr - stop pl
W9.2	-	20%	100%	LH, Fillet, Tr - stop pl

W9.3	-	20%	100%	LH, Fillet, Tr - stop pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr, side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr, long
W38.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-24</b>	PAGE / SIDE <b>4 of/av 4</b>
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W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-25</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P17A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

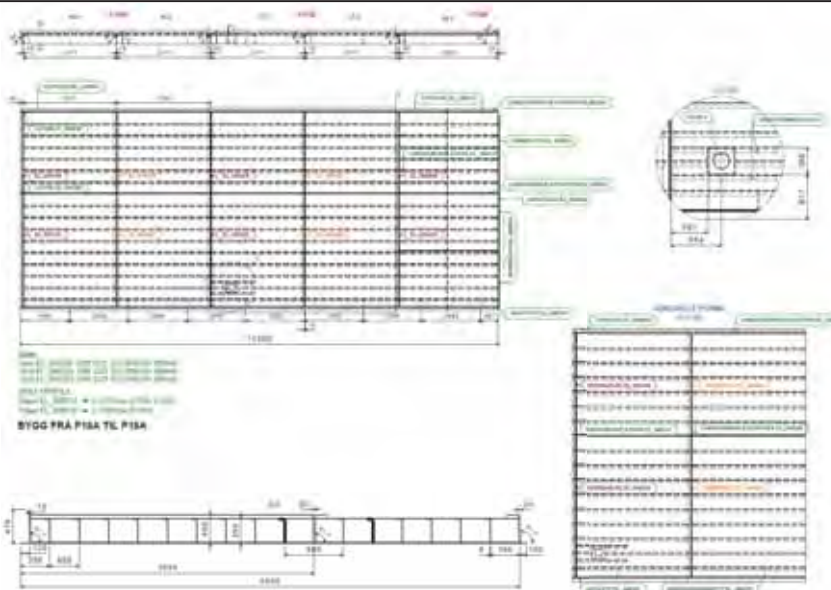
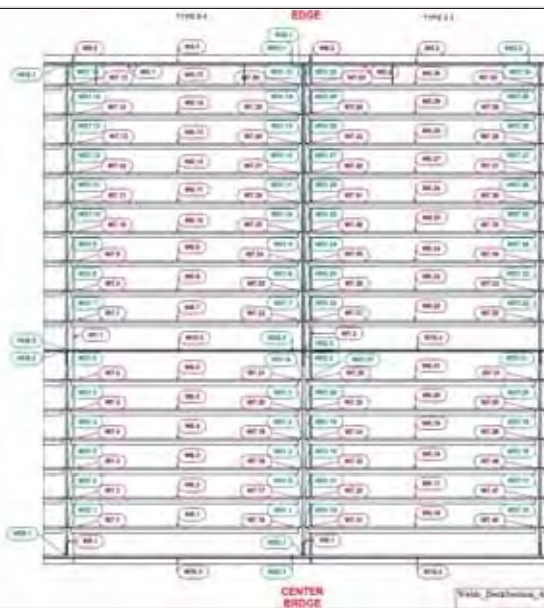
CLIENT / KUNDE  
Prodrex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-17

REPORT NO. / RAPPORT NR.  
10031-23-VT-25

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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-25</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Plate to bottom top from two plates. Plate 1 and Plate 2

4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B:

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& bottom pl
W1.2	100%	100%	100%	LH, BW top& bottom pl
W4.1	-	100%	100%	R&LH, FW, side pl. h
W4.2	-	100%	100%	R&LH, FW t, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH&R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH&R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH&R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH&R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH&R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH&R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH&R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH&R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH&R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH&R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH&R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH&R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH&R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH&R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH&R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH&R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH&R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH&R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH&R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH&R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH&R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH&R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH&R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH&R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH&R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH&R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH&R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH&R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH&R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH&R, FW L profile
W8.1	-	20%	100%	R, Fillet, Tr - stop pl
W8.2	-	20%	100%	R, Fillet, Tr - stop pl
W9.1	-	20%	100%	LH, Fillet, Tr - stop pl
W9.2	-	20%	100%	LH, Fillet, Tr - stop pl

W9.2	-	20%	100%	LH, Fillet, Tr - stop pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, trinside
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, trinside
W38.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-25</b>	PAGE / SIDE <b>4 of/av 4</b>
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W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-26</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P16A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

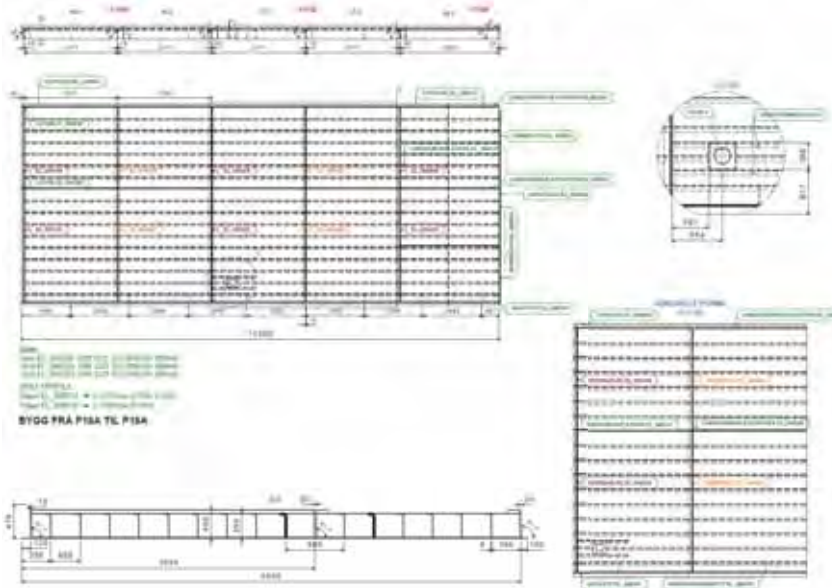
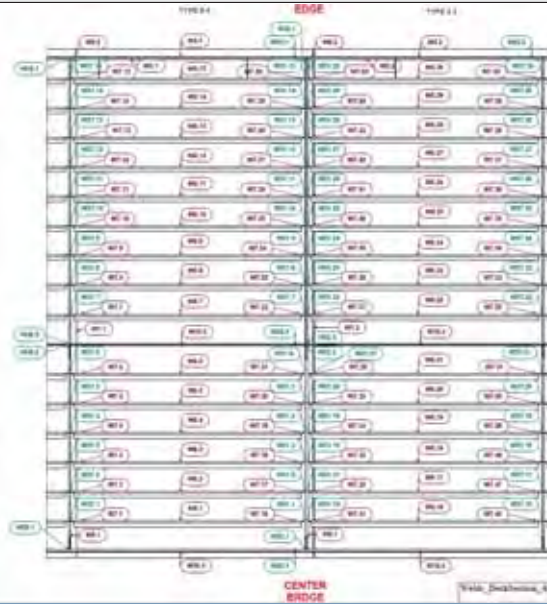
CLIENT / KUNDE  
Prodrex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-17

REPORT NO. / RAPPORT NR.  
10031-23-VT-26

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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-26</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Please to look up from two plates. Please to be checked according to the following tables for Side A and Side B.

4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2

For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& top pl
W1.2	100%	100%	100%	LH, BW top& top pl
W4.1	-	100%	100%	R+LH, FW, side pl. h
W4.2	-	100%	100%	R+LH, FW t, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH+R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH+R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH+R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH+R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH+R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH+R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH+R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH+R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH+R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH+R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH+R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH+R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH+R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH+R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH+R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH+R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH+R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH+R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH+R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH+R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH+R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH+R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH+R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH+R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH+R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH+R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH+R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH+R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH+R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH+R, FW L profile
W8.1	-	20%	100%	R, Fillet, Tr - stop pl
W8.2	-	20%	100%	R, Fillet, Tr - stop pl
W9.1	-	20%	100%	LH, Fillet, Tr - stop pl
W9.2	-	20%	100%	LH, Fillet, Tr - stop pl

W9.2	-	20%	100%	LH, Fillet, Tr - stop pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr+side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr+long
W38.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
<b>Bottom plate Welds</b>				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-26</b>	PAGE / SIDE <b>4 of/av 4</b>
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W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

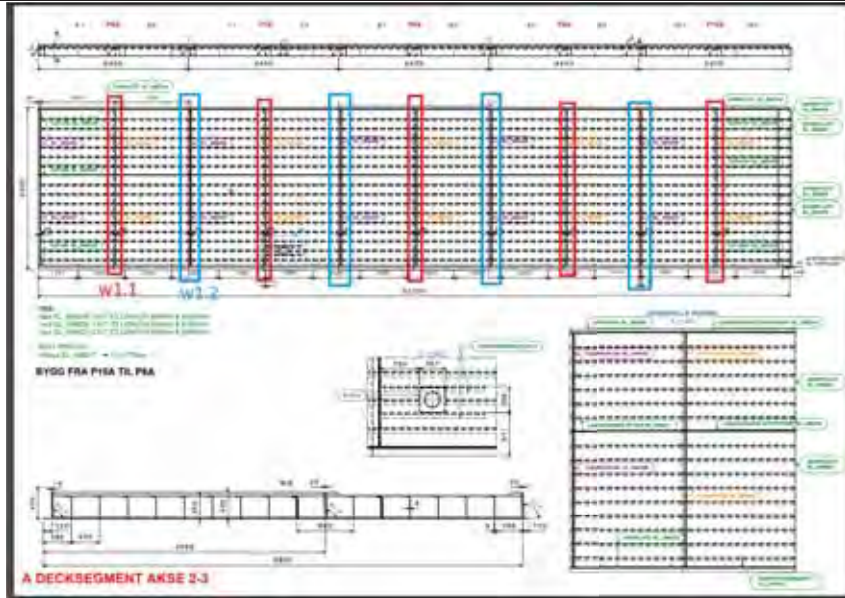
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DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w1.1\w1.2 and HAZ at A decksegment AKSE 2-3 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking (VT).</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-18</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-19 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-06-19 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-24</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P18A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

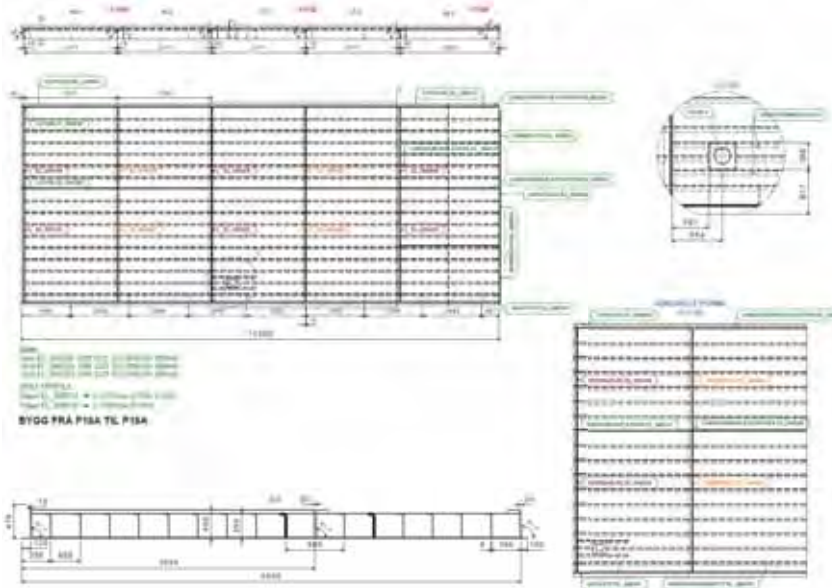
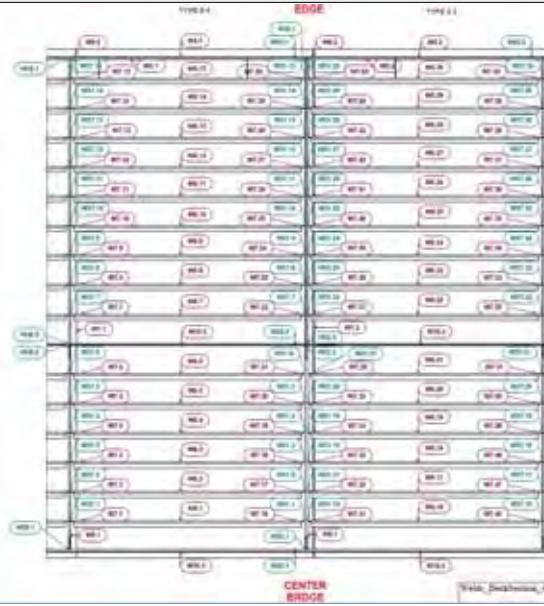
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-16

REPORT NO. / RAPPORT NR.  
10031-23-VT-24

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2 of/av 4





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-24</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Please to look up from two plates. Please to look up from two plates.

4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& top pl
W1.2	100%	100%	100%	LH, BW top& top pl
W4.1	-	100%	100%	R+LH, FW, side pl. h
W4.2	-	100%	100%	R+LH, FW t, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH+R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH+R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH+R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH+R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH+R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH+R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH+R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH+R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH+R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH+R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH+R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH+R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH+R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH+R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH+R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH+R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH+R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH+R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH+R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH+R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH+R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH+R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH+R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH+R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH+R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH+R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH+R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH+R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH+R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH+R, FW L profile
W8.1	-	20%	100%	R, Fillet, Tr - stop pl
W8.2	-	20%	100%	R, Fillet, Tr - stop pl
W9.1	-	20%	100%	LH, Fillet, Tr - stop pl
W9.2	-	20%	100%	LH, Fillet, Tr - stop pl

W9.2	-	20%	100%	LH, Fillet, Tr - stop pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr+side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr+long
W38.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-24</b>	PAGE / SIDE <b>4 of/av 4</b>
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W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Doru Baciu</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-25</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P17A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

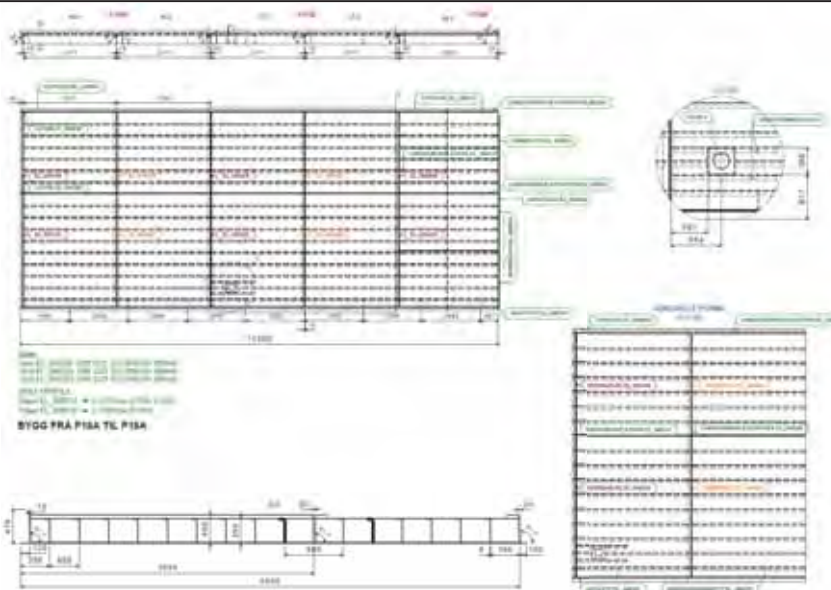
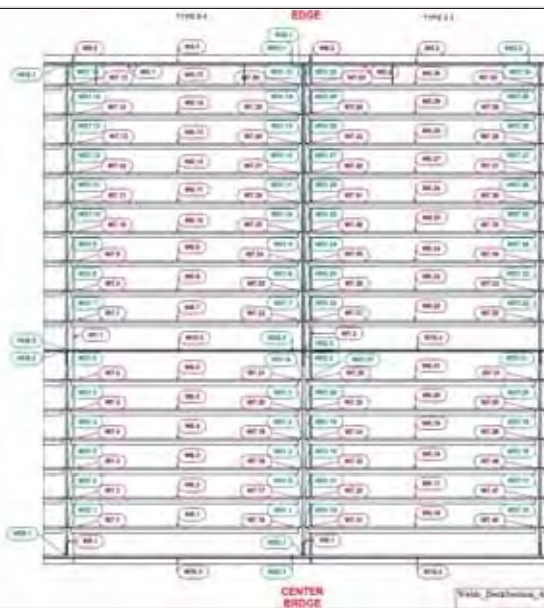
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-17

REPORT NO. / RAPPORT NR.  
10031-23-VT-25

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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-25</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Please to look up from two plates. Please to look up from two plates.

4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& top pl
W1.2	100%	100%	100%	LH, BW top& top pl
W4.1	-	100%	100%	R+LH, FW, side pl. h
W4.2	-	100%	100%	R+LH, FW t, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH+R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH+R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH+R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH+R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH+R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH+R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH+R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH+R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH+R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH+R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH+R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH+R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH+R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH+R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH+R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH+R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH+R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH+R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH+R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH+R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH+R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH+R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH+R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH+R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH+R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH+R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH+R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH+R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH+R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH+R, FW L profile
W8.1	-	20%	100%	R, Fillet, Tr -top pl
W8.2	-	20%	100%	R, Fillet, Tr -top pl
W9.1	-	20%	100%	LH, Fillet, Tr -top pl
W9.2	-	20%	100%	LH, Fillet, Tr -top pl

W9.2	-	20%	100%	LH, Fillet, Tr -top pl
W10.1	-	100%	100%	LH, Fillet, Long, pl
W10.2	-	100%	100%	LH, Fillet, Long, pl
W10.3	-	100%	100%	LH, Fillet, Long, pl
W10.4	-	100%	100%	LH, Fillet, Long, pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr+side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr+long
W38.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long, pl
W55.1, W55.2	100%	100%	100%	BW, side, pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-25</b>	PAGE / SIDE <b>4 of/av 4</b>
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W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciü (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciü (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Doru Baciü</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Doru Baciü</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-26</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P16A) AKSE 4-5</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b> <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

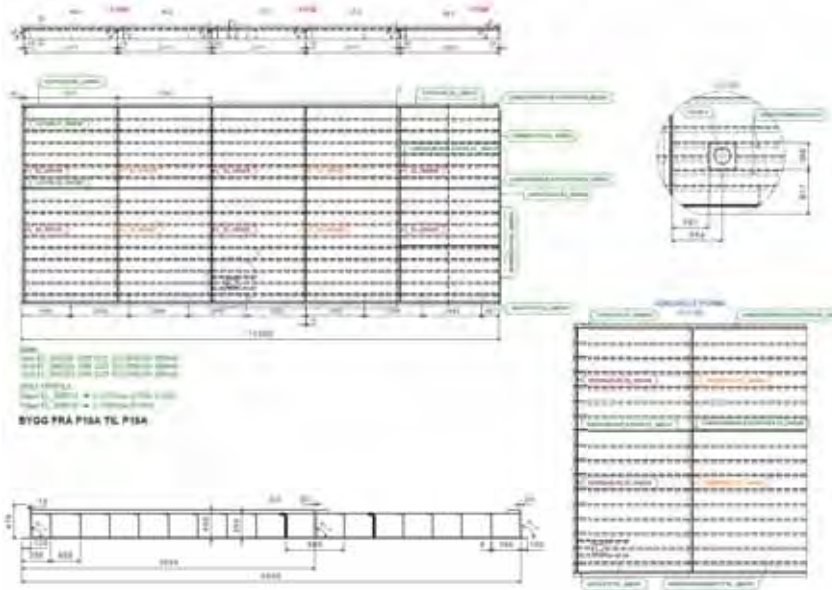
CLIENT / KUNDE  
Prodrex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-17

REPORT NO. / RAPPORT NR.  
10031-23-VT-26

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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-26</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Please to look up from two plates. Please refer to the tables below.

4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& bottom pl
W1.2	100%	100%	100%	LH, BW top& bottom pl
W4.1	-	100%	100%	R&LH, FW, side pl. h
W4.2	-	100%	100%	R&LH, FW t, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH&R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH&R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH&R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH&R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH&R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH&R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH&R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH&R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH&R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH&R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH&R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH&R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH&R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH&R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH&R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH&R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH&R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH&R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH&R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH&R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH&R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH&R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH&R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH&R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH&R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH&R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH&R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH&R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH&R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH&R, FW L profile
W8.1	-	20%	100%	R, Fillet, Tr - stop pl
W8.2	-	20%	100%	R, Fillet, Tr - stop pl
W9.1	-	20%	100%	LH, Fillet, Tr - stop pl
W9.2	-	20%	100%	LH, Fillet, Tr - stop pl

W9.3	-	20%	100%	LH, Fillet, Tr - stop pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr, side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr, long
W38.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-26</b>	PAGE / SIDE <b>4 of/av 4</b>
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W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Doru Baciu</i>



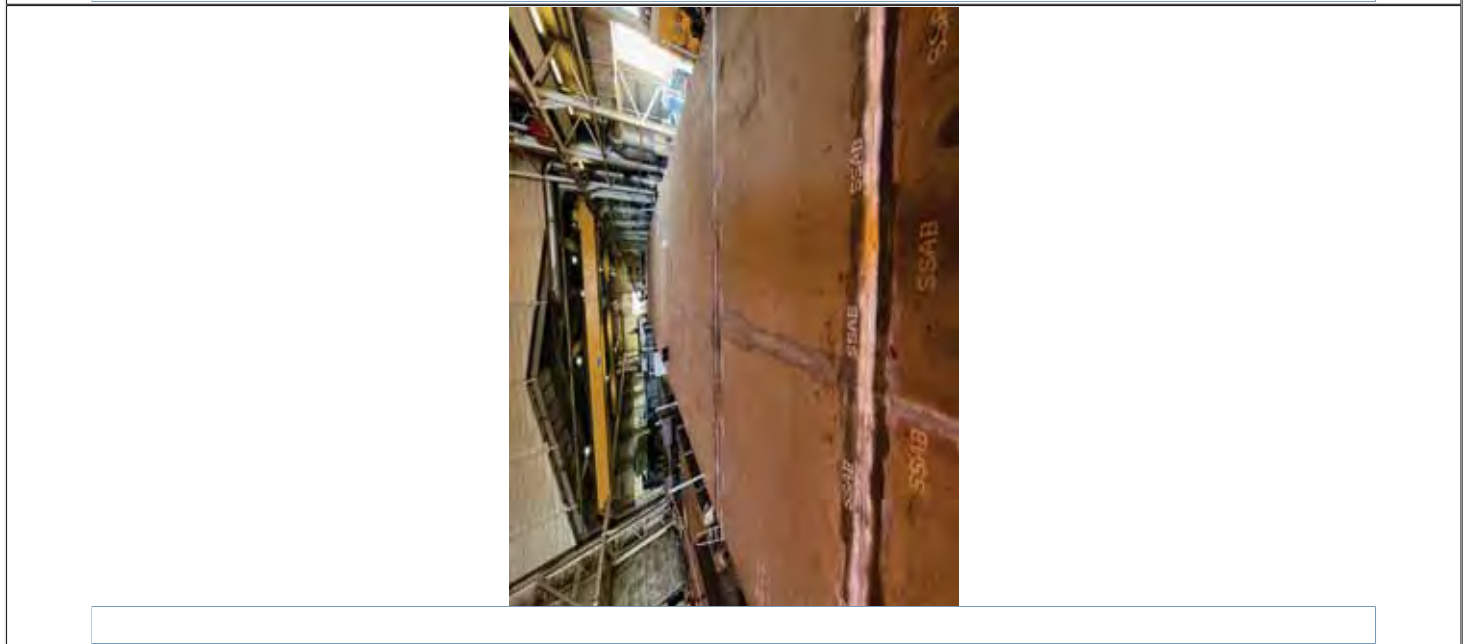
# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-05</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-28</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w1.1\w1.2 and HAZ at A decksegment AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking (VT).</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-05</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-28</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-17 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-07-17 <i>Doru Baci</i>



**Visual Control**  
**Visuell kontroll**

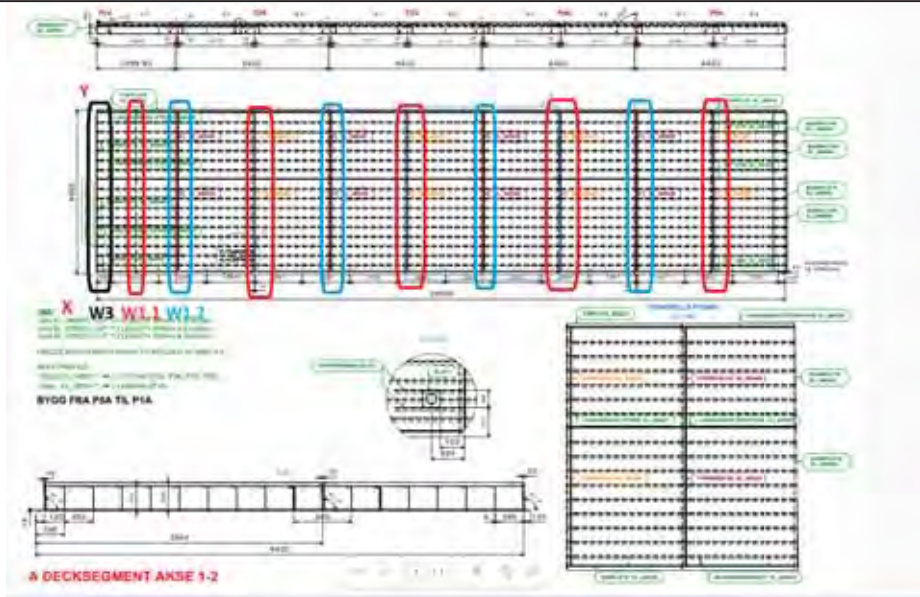
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DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w1.1\w1.2 and HAZ at A decksegment AKSE 1-2 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking .</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-30-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-09-15 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-09-15 <i>Doru Baci</i>



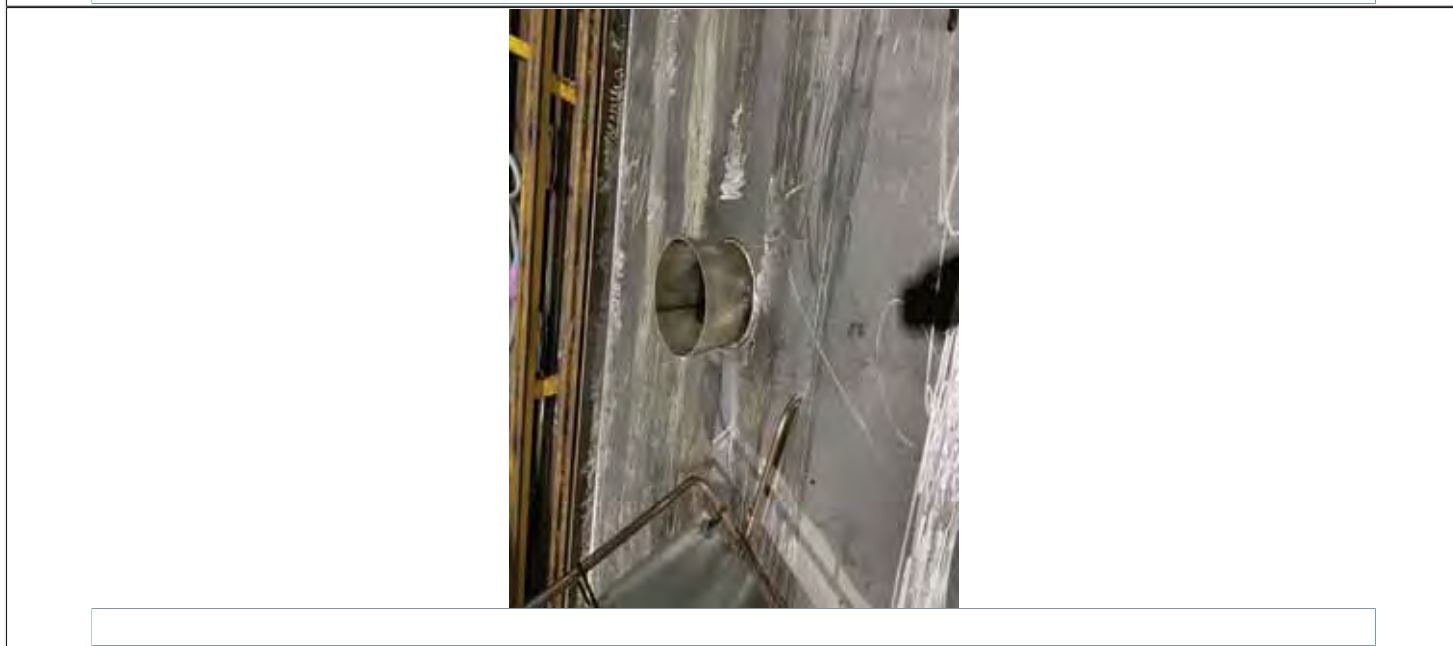
# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-32</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of sluk weld and HAZ Deck section A (P12A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Weld nr. 83,84,85,86,87,88,89. Fulfill requirements after repairs. No indications were found at the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-32</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-17 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-17 <i>Doru Baciu</i>



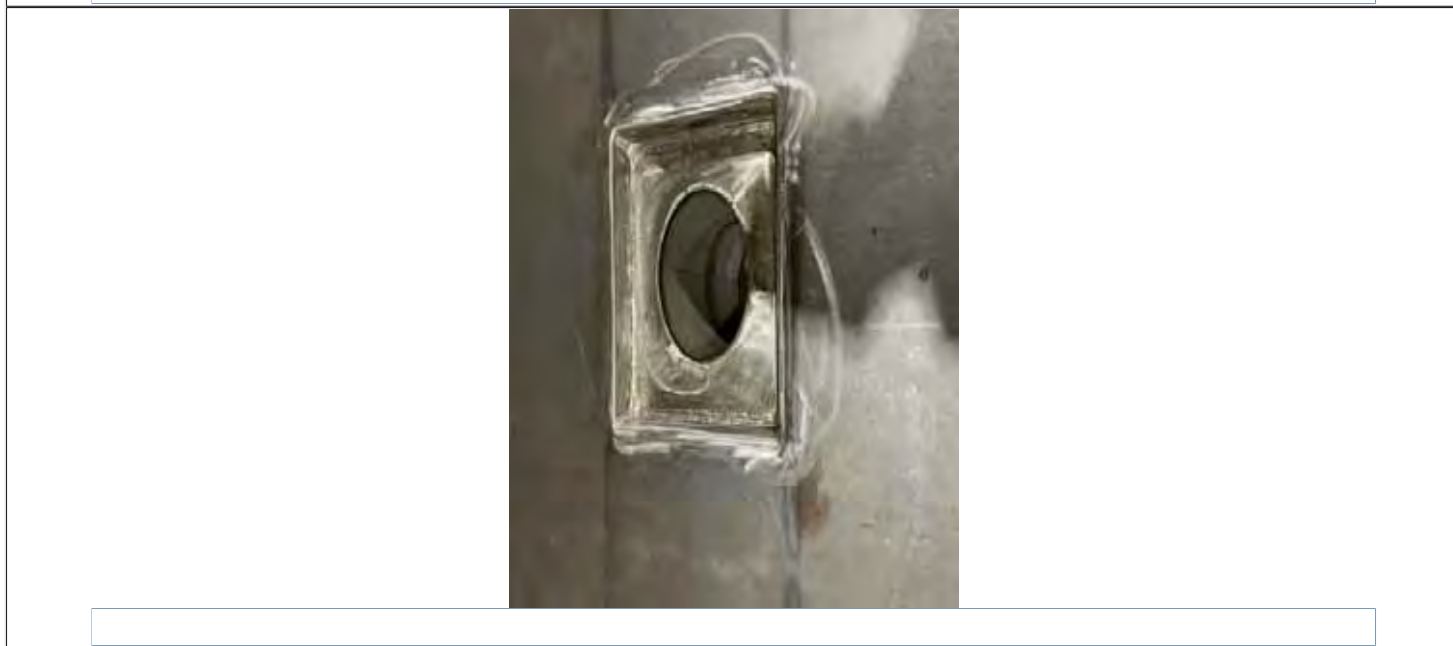
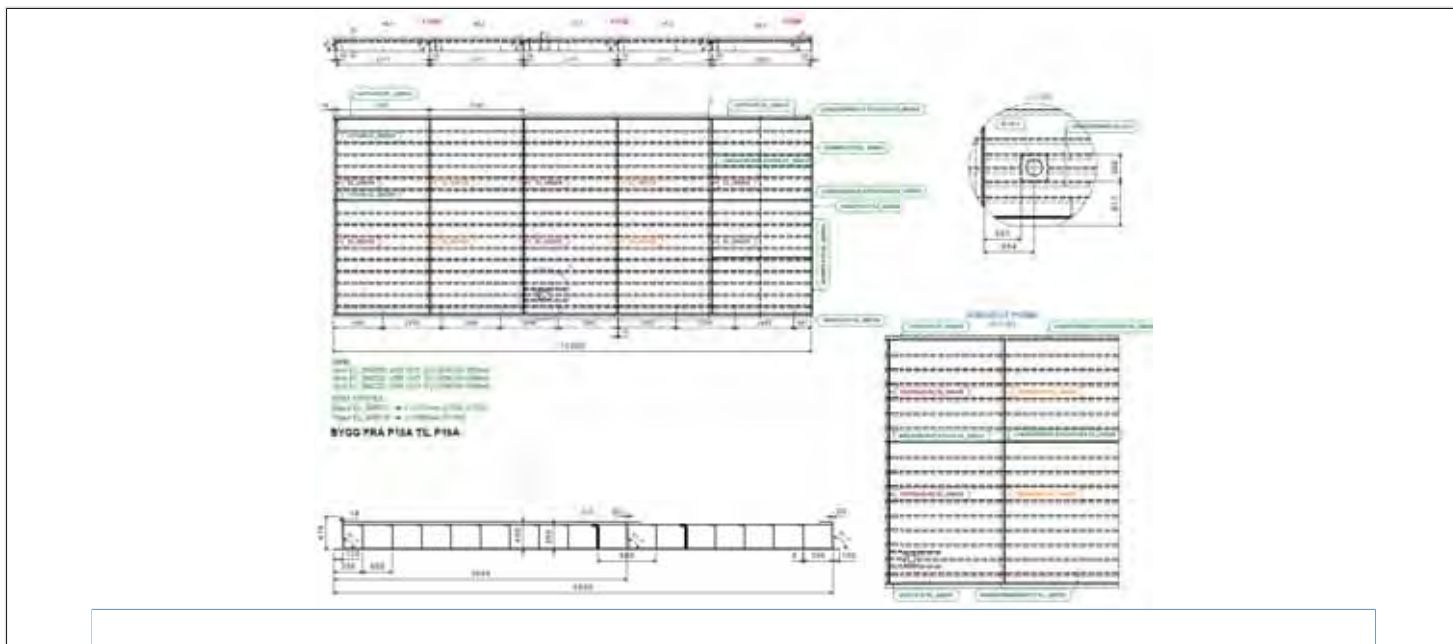
# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-10</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-33</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of sluk weld and HAZ Deck section A (P17A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Weld nr. 83,84,85,86,87,88,89. Fulfill requirements after repairs. No indications were found at the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-10</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-33</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-17 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-07-17 <i>Doru Baci</i>



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-34</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of sluk weld and HAZ Deck section A (P2A) AKSE 1-2 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Weld nr. 83,84,85,86,87,88,89. Fulfill requirements after repairs. No indications were found at the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

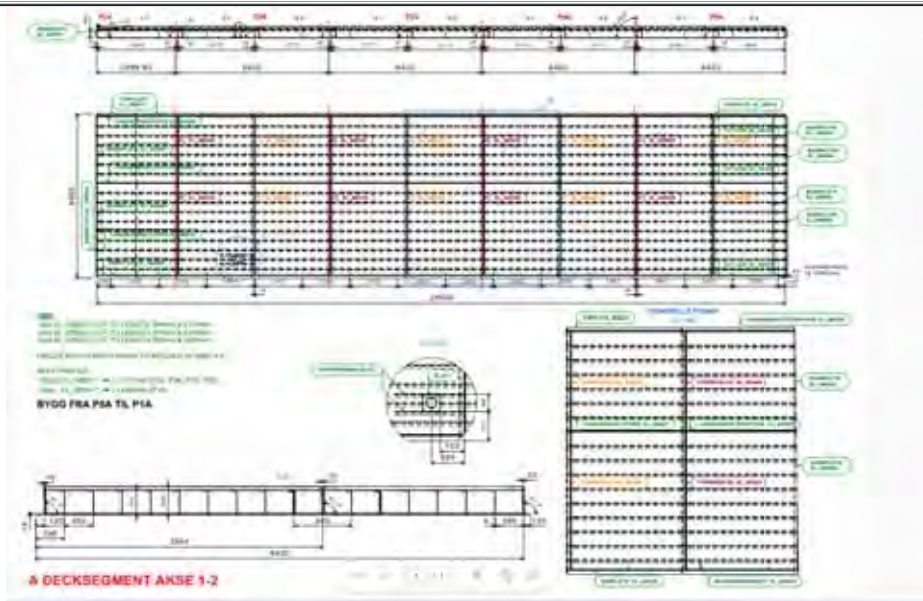
CLIENT / KUNDE  
Prodtex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhoy

DATE OF TESTING / KONTROLLDATO  
2023-07-17

REPORT NO. / RAPPORT NR.  
10031-23-VT-34

PAGE / SIDE  
2 of/av 2



NAME CERT. NO. / NAVN SERT. NR.  
()

N2 NAME CERT. NO. / N2 NAVN SERT. NR.  
Doru Baciu (2026-VT)

OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR.  
Doru Baciu (2026-VT)

APPROVED / GODKJENT DATO:

APPROVED / GODKJENT DATO:2023-07-17

OPERATOR / OPERATØR DATO:2023-07-17

Approved / Godkjent

*Doru Baciu*

*Doru Baciu*



**Visual Control**  
**Visuell kontroll**

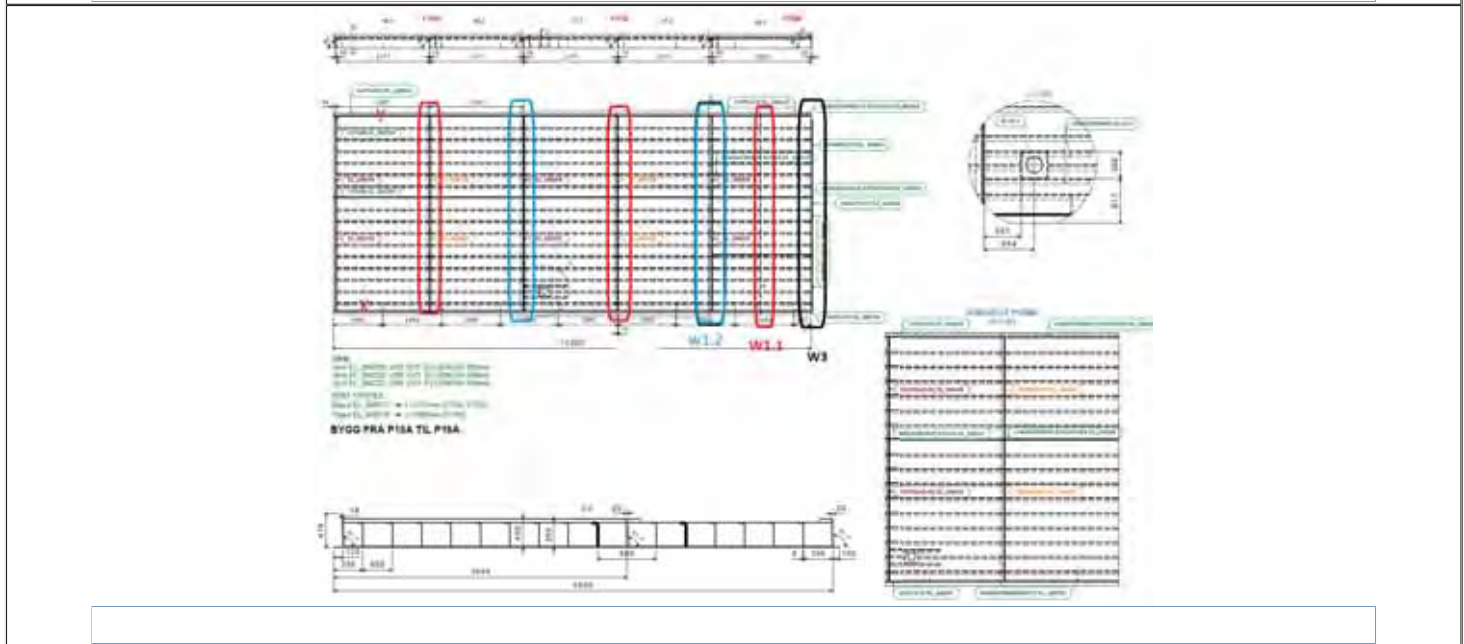
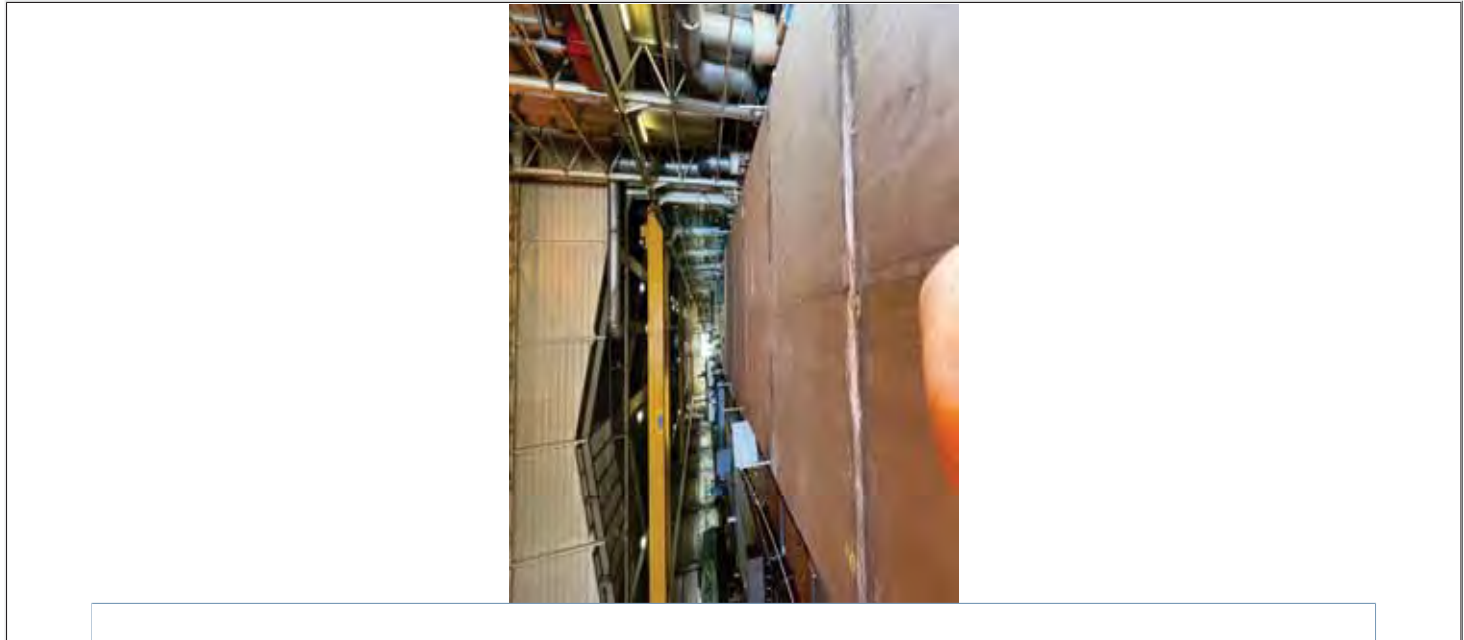
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DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w1.1/w1.2/w3 and HAZ at A deck segment AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking (VT).</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-56-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-09-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-09-15 <i>Doru Baciu</i>



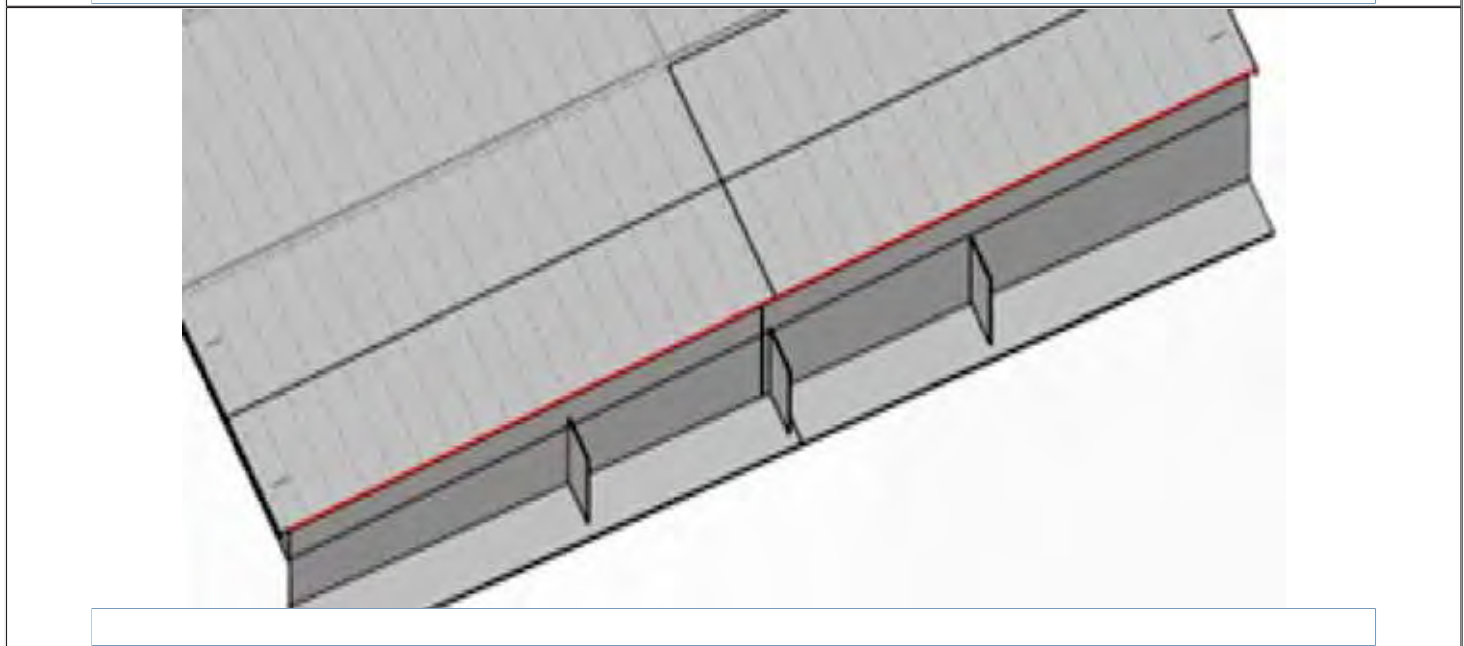
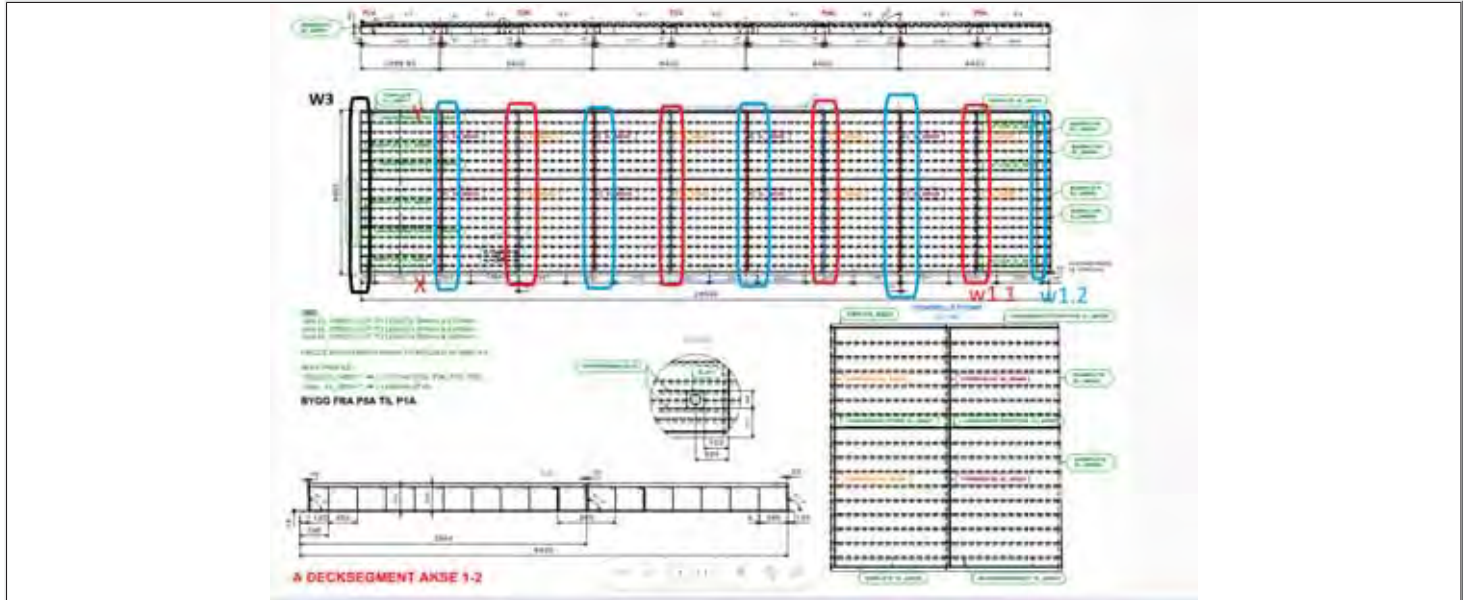
**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-57</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w3 and HAZ at A deck segment AKSE 1-2 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking (VT).</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-57</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-09-15 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-09-15 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

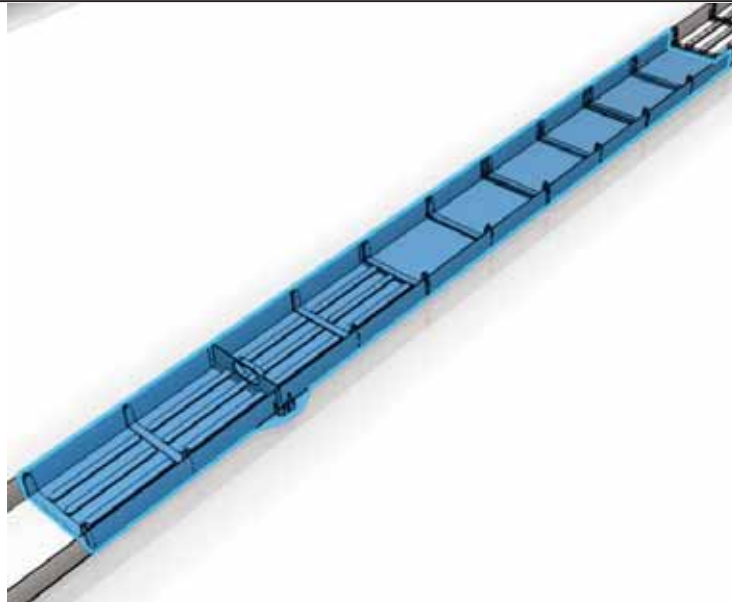
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DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ AKSE 3-4 A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-18</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-58</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiu (2533-VT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiu (2533-VT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

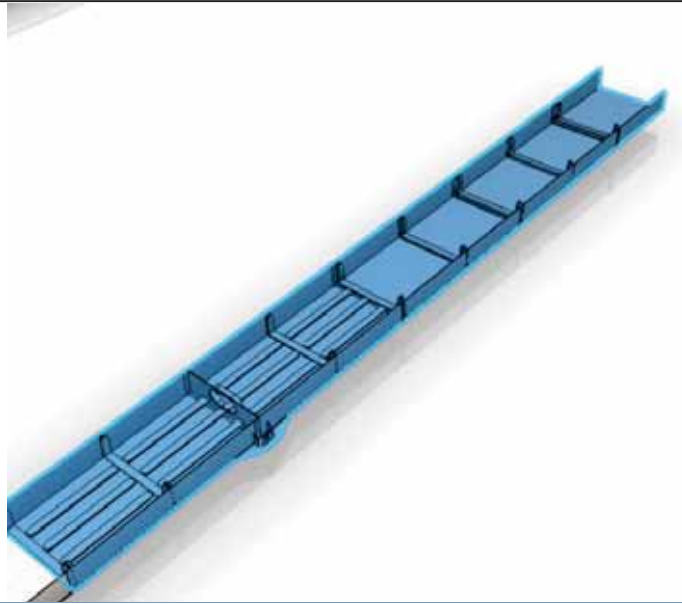
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-59</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ</b> <b>AKSE 1-2 A</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-59</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindiu (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindiu (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-21</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-60</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ</b> <b>AKSE 4-5 A</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				

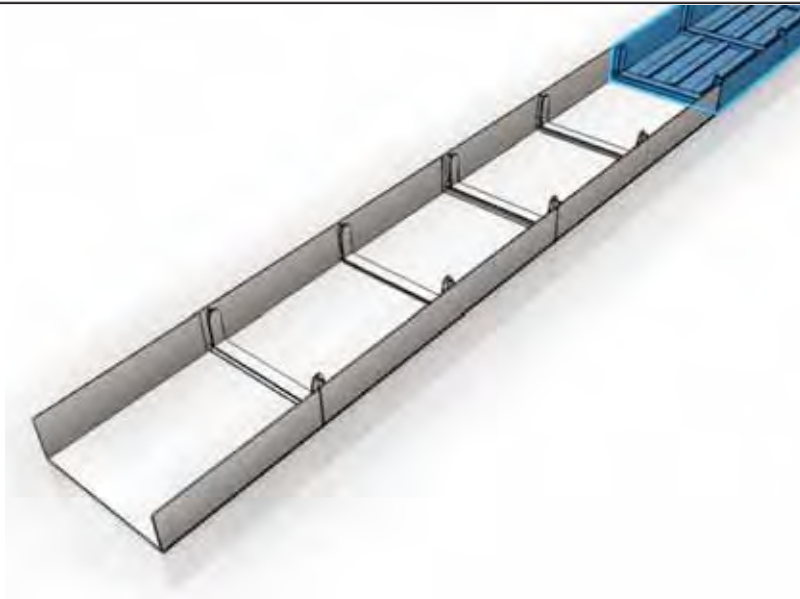




**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-21</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-60</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindiu (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindiu (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

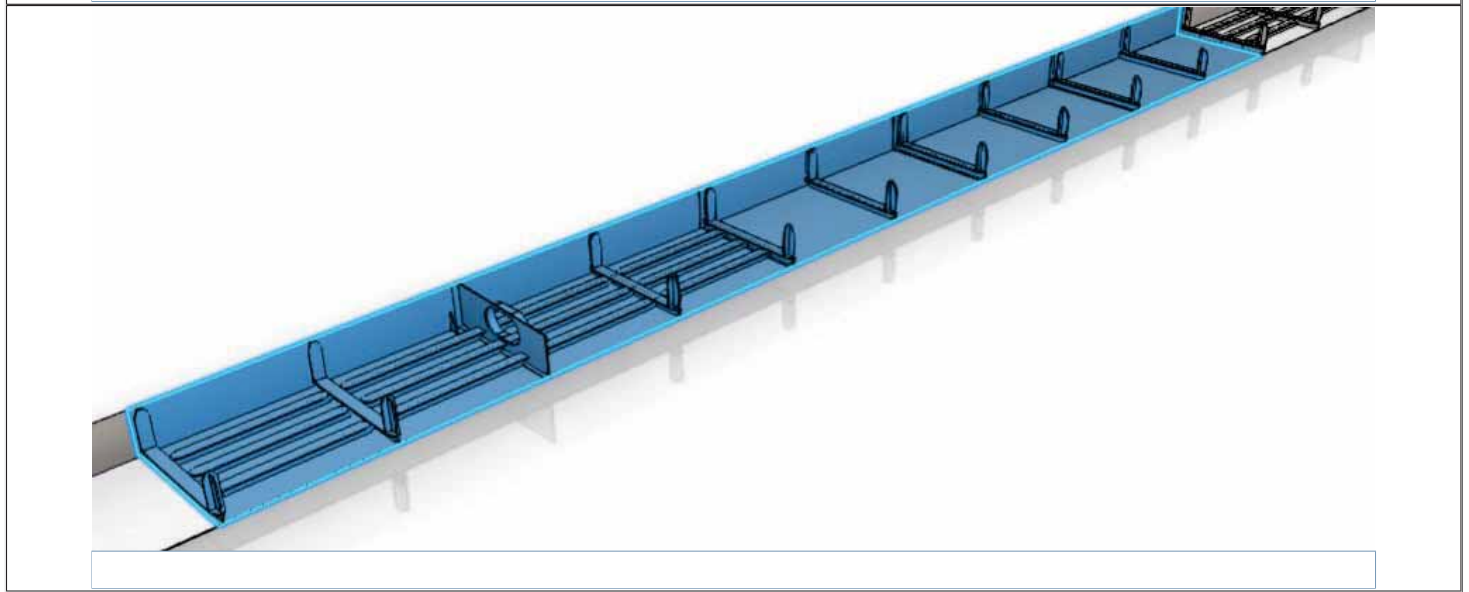
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-24</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-61</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ</b> <b>AKSE 2-3 B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-24</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-61</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%						
W23.2									
W27.1,									
W27.2,									
W27.3,	100%	5%	100%			W42.7	100%	100%	100%
W27.4,									
W27.5,									
W27.6									
W42	100%	100%	100%			W42.8	100%	100%	100%
W19	100%	20%	100%			W53.1		20%	100%
W47	100%	100%	100%			W53.2		20%	100%
W24	100%	20%	100%			W53.3		20%	100%
						W53.4		20%	100%
W34	20%	100%	100%			W53.5		20%	100%
W43,						W53.6		20%	100%
W44,		20%	100%						
W45,									
W50									
						W71.1	-	100%	100%



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindi (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindi (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindi</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindi</i>



**Visual Control**  
**Visuell kontroll**

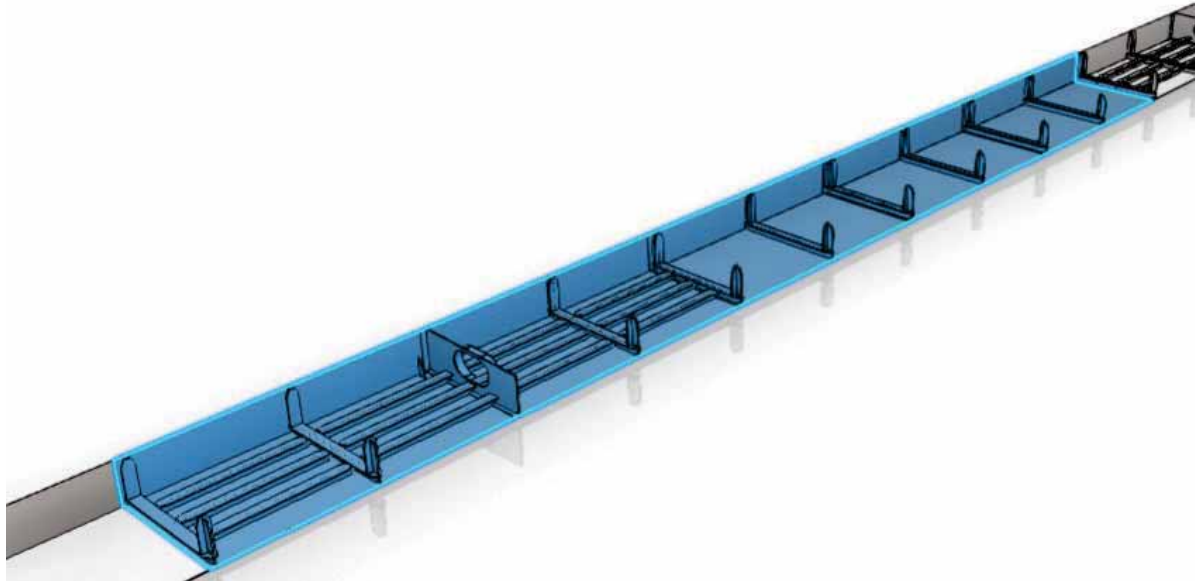
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-62</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ</b> <b>AKSE 3-4 B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-62</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%						
W23.2									
W27.1,						W42.7	100%	100%	100%
W27.2,									
W27.3,	100%	5%	100%						
W27.4,									
W27.5,									
W27.6									
W42	100%	100%	100%			W42.8	100%	100%	100%
W19	100%	20%	100%			W53.1		20%	100%
W47	100%	100%	100%			W53.2		20%	100%
W24	100%	20%	100%			W53.3		20%	100%
						W53.4		20%	100%
W34	20%	100%	100%			W53.5		20%	100%
W43,						W53.6		20%	100%
W44,		20%	100%						
W45,									
W50									
						W71.1	-	100%	100%



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindiu (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindiu (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

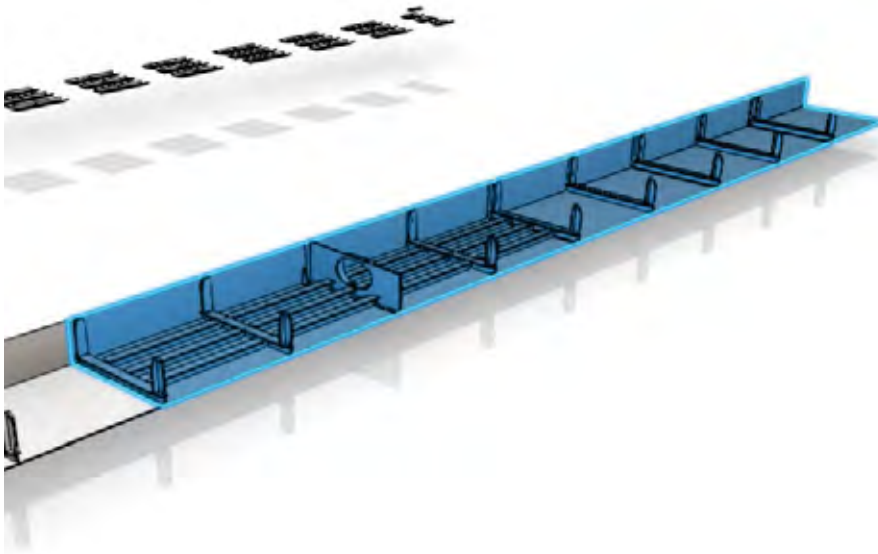
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-28</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-63</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ</b> <b>AKSE 1-2 B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-28</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-63</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindiu (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindiu (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-64</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld and HAZ</b> <b>AKSE 4-5 B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				

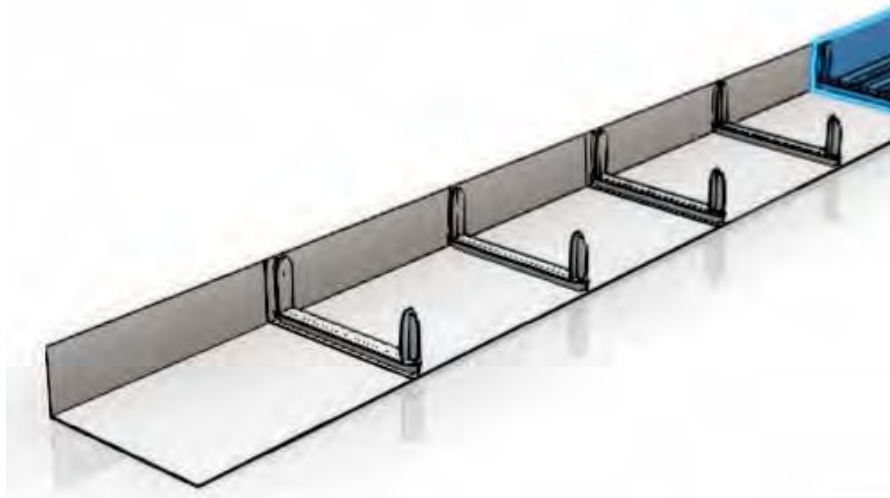




**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-64</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindiu (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindiu (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

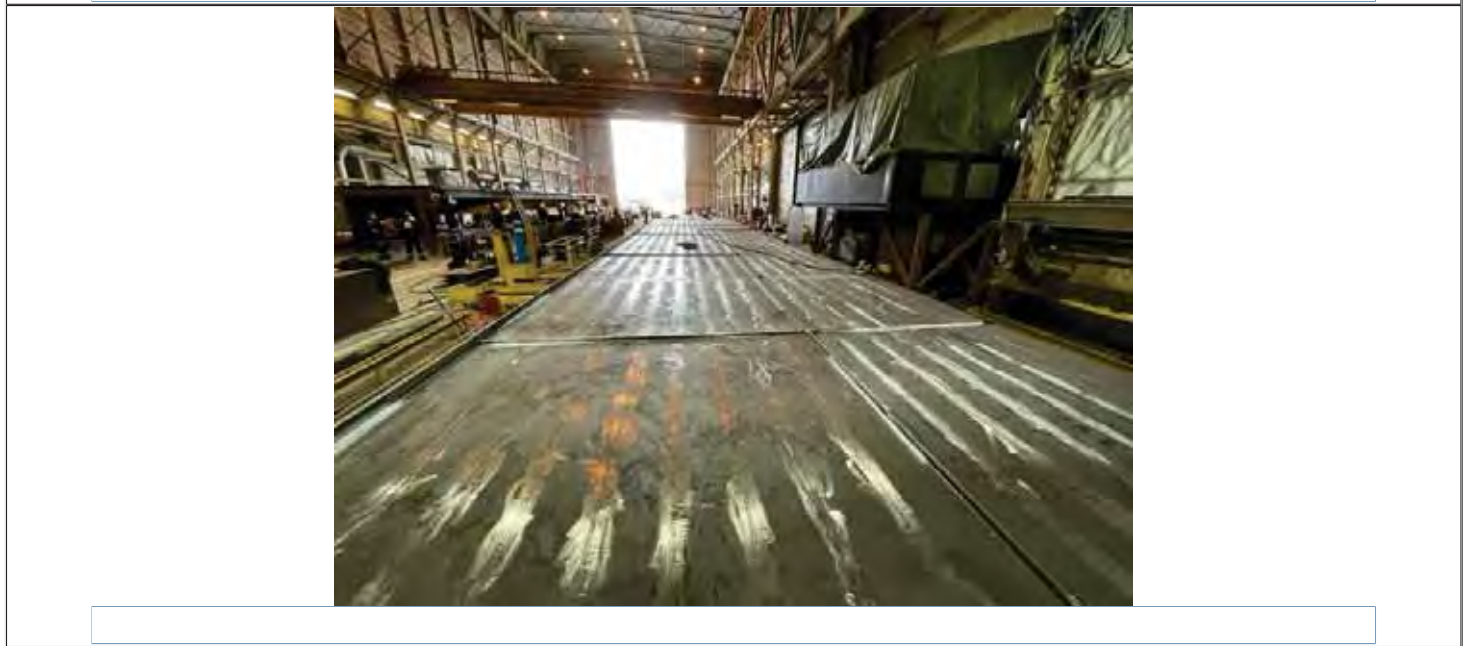
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-65</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w1.1/w1.2/w3 and HAZ at B deck segment AKSE 1-2 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-65</b>	PAGE / SIDE <b>2 of/av 2</b>
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**B DECKSEGMENT AKSE 1-3**



NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindiu (2533-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindiu (2533-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-16 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-16 <i>Ramona Bindiu</i>



**Visual Control**  
**Visuell kontroll**

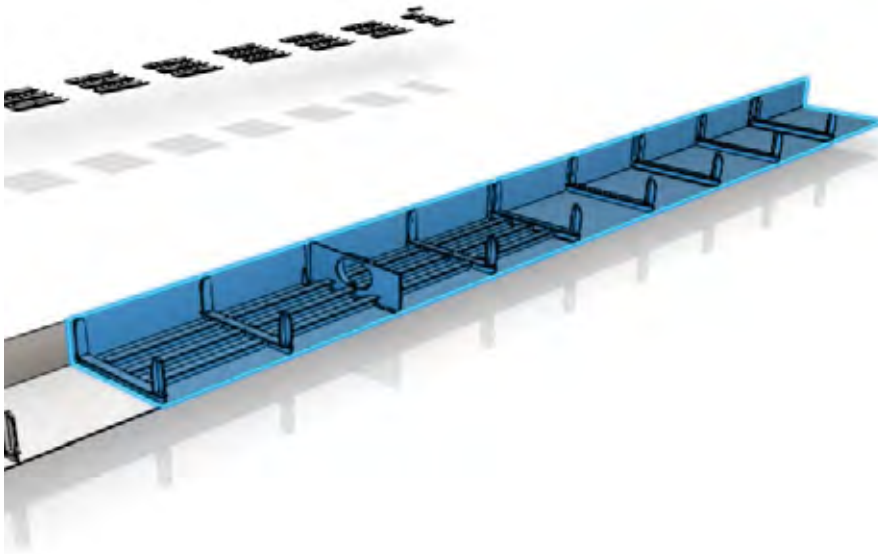
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-20</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-68</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, visual testing of weld, and HAZ AKSE 2-3 A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-20</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-68</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciú (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciú (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-17 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-10-17 <i>Doru Baciú</i>



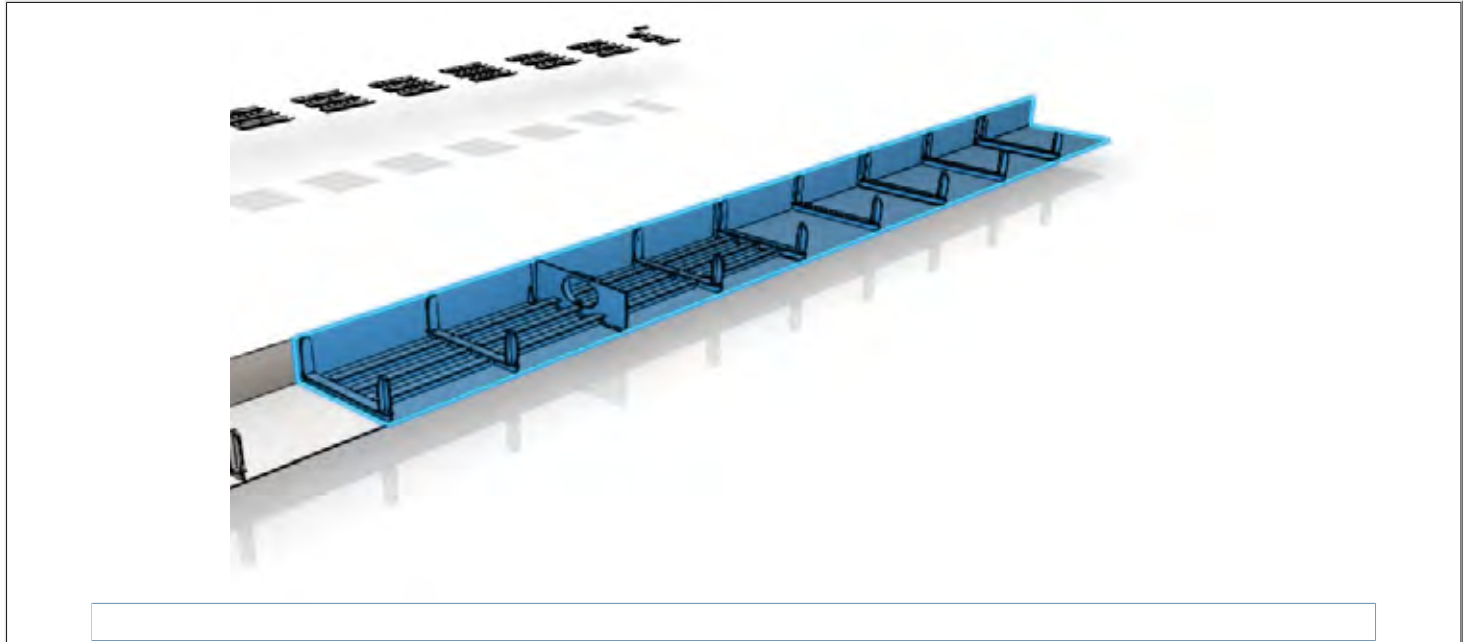
**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-69</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam: weld 42.1, 42.2, 52.1 to 52.6</b> <b>AKSE A 1-2, 2-3, 3-4, 4-5</b> <b>AKSE B 1-2, 2-3, 3-4, 4-5</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-69</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-17 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-10-17 <i>Doru Baci</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-71</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>AKSE 1-2 A-B with 2-3 A-B longitudinal W2 .</b> Details in pictures.				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-71</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (1459-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (1459-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-25 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-10-25 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-20</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-72</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>AKSE 1-2, 2-3, 3-4, 4-5 A, weld W41 .</b> Details in pictures.				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs fulfill the requirements.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-20</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-72</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (1459-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (1459-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-26 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-10-26 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-27</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-73</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>AKSE 2-3 A-B with 3-4 A-B longitudinal W2.</b> Details in pictures.				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-27</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-73</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-31 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-10-31 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-76</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>AKSE 3-4 A-B with 4-5 A-B longitudinal W2.</b> Details in pictures.				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-76</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-03 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-03 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-77</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>AKSE 1-2 A-B with 2-3 A-B transversal weld W2. AKSE 2-3 A-B with 3-4 A-B transversal weld W2. AKSE 3-4 A-B with 4-5 A-B transversal weld W2. Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Fulfill requirements after repairs.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-77</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-03 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-03 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-78</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of W93 weld and HAZ at AKSE 3-4 AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Fulfill requirements after repairs.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-78</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-03 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-03 <i>Popescu Lucian</i>



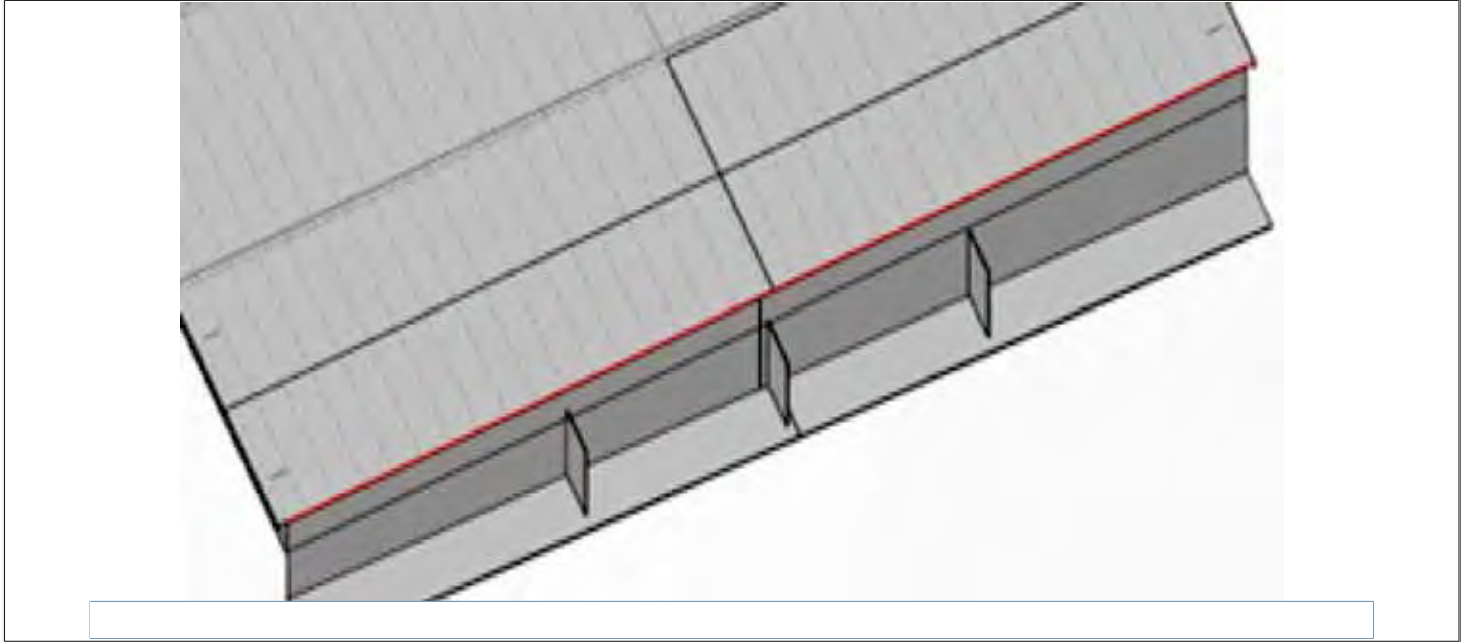
**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-79</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld w3 and HAZ at B deck segment AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking (VT).</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-79</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-08 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-08 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-81</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of W93 weld and HAZ at AKSE 1-2 AKSE 2-3 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Fulfill requirements after repairs.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-81</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-13 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-13 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

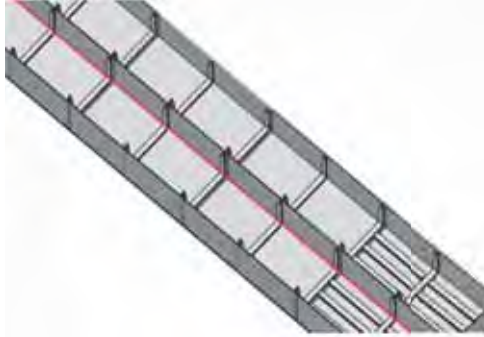
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-82</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>VT of W68 weld and HAZ at AKSE 1-2, 2-3, 3-4, 4-5. Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Fulfill requirements after repairs.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-82</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-13 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-13 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-06</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-83</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>AKSE 1-2, 2-3, 3-4, 4-5 B, weld W41 .</b> Details in pictures.				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs fulfill the requirements.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-06</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-83</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-85</b>	PAGE / SIDE <b>1 of/av 5</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P1-P5A) AKSE 1-2</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

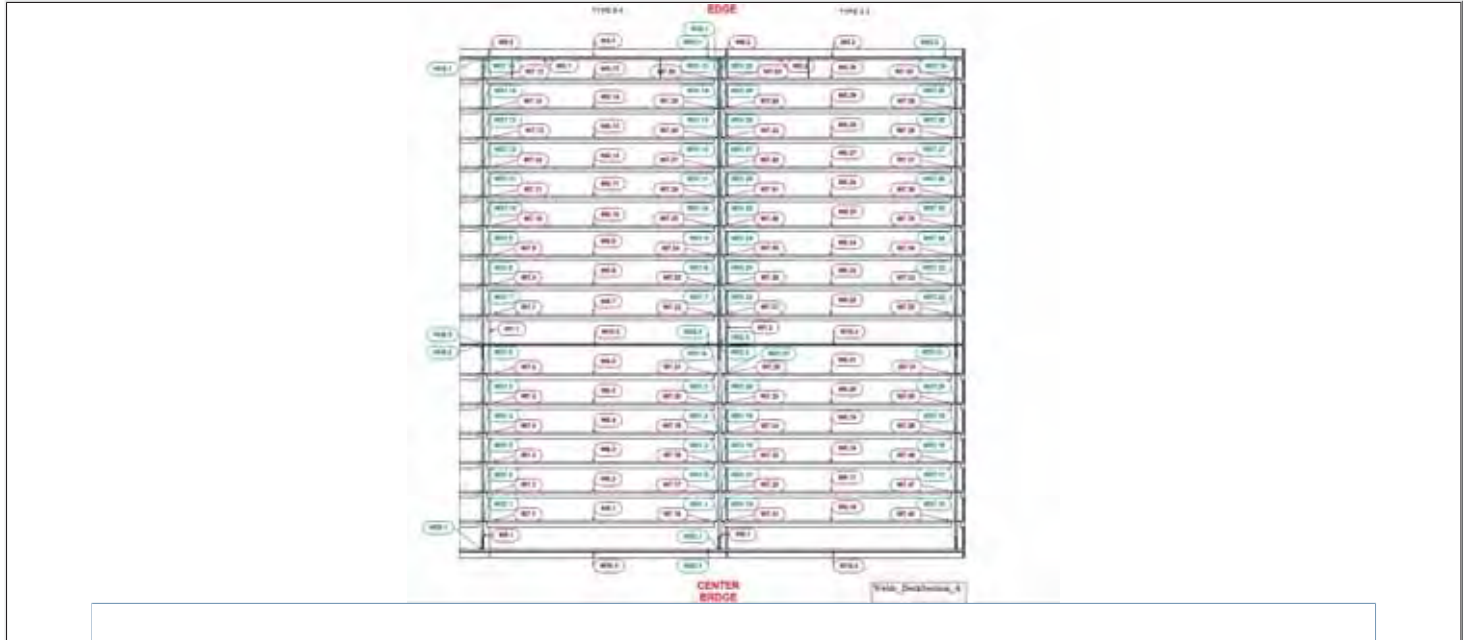
CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-15

REPORT NO. / RAPPORT NR.  
10031-23-VT-85

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2 of/av 5





# Visual Control Visuell kontroll

CLIENT / KUNDE  
Prodtext Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-15

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Weld Section Søst. / søst. nr.	WC	MT	BT/PT	VT	Weld Details			Height Høyde	Access Tilgjeng.	Comments
					Process	System	Thickness			
W1.1	1	100%	100%	100%	HT, FSW top to top	T	18	NOT report	QC	
W1.2	5	100%	100%	100%	HT, FSW top to top	V	18	NOT report	QC	
W1.3	8	100%	100%	100%	HT, FSW side to side	F	18	NOT report	QC	
W1.4	1	100%	100%	100%	HT, FSW side to side	T	18	NOT report	QC	
W1.5 (W1.1, W1.2)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.6 (W1.3, W1.4)	8	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.7 (W1.5, W1.6)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.8 (W1.7, W1.8)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.9 (W1.9, W1.10)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.10 (W1.11, W1.12)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.11 (W1.13, W1.14)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.12 (W1.15, W1.16)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.13 (W1.17, W1.18)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.14 (W1.19, W1.20)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.15 (W1.21, W1.22)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.16 (W1.23, W1.24)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.17 (W1.25, W1.26)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.18 (W1.27, W1.28)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.19 (W1.29, W1.30)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.20 (W1.31, W1.32)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.21 (W1.33, W1.34)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.22 (W1.35, W1.36)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.23 (W1.37, W1.38)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.24 (W1.39, W1.40)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	
W1.25 (W1.41, W1.42)	3	100%	100%	100%	HT, FSW profile	T	18	NOT report	QC	

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Reduced after 200% of  
time weld from 100%  
MT to 50%MT and after  
another 100% to 20%  
MT. If weld before

HT if weld before  
before the test will be  
not apply to 100%MT



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Item No.	Material / Description	Color	Texture	Finish	Orientation	Location	Test Method	Result
W148	W148.1, W148.2, W148.3	S	20%	100%	6, F148.1 - Høp st.	K	14-15	NOT report
W149	W149.1, W149.2, W149.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W150	W150.1, W150.2, W150.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W151	W151.1, W151.2, W151.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W152	W152.1, W152.2, W152.3	S	20%	100%	6, F148.1 - Høp st.	K	16-18	NOT report
W153	W153.1, W153.2, W153.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W154	W154.1, W154.2, W154.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W155	W155.1, W155.2, W155.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W156	W156.1, W156.2, W156.3	S	20%	100%	6, F148.1 - Høp st.	K	19-20	NOT report
W157	W157.1, W157.2, W157.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W158	W158.1, W158.2, W158.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W159	W159.1, W159.2, W159.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W160	W160.1, W160.2, W160.3	S	20%	100%	6, F148.1 - Høp st.	K	21-22	NOT report
W161	W161.1, W161.2, W161.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W162	W162.1, W162.2, W162.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W163	W163.1, W163.2, W163.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W164	W164.1, W164.2, W164.3	S	20%	100%	6, F148.1 - Høp st.	K	23-24	NOT report
W165	W165.1, W165.2, W165.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W166	W166.1, W166.2, W166.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W167	W167.1, W167.2, W167.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W168	W168.1, W168.2, W168.3	S	20%	100%	6, F148.1 - Høp st.	K	25-26	NOT report
W169	W169.1, W169.2, W169.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W170	W170.1, W170.2, W170.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W171	W171.1, W171.2, W171.3	S	20%	100%	6, F148.1 - Høp st.			NOT report




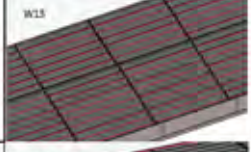
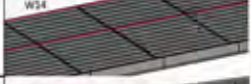


Item No.	Material / Description	Color	Texture	Finish	Orientation	Location	Test Method	Result
W172	W172.1, W172.2, W172.3	S	20%	100%	6, F148.1 - Høp st.	K	27-28	NOT report
W173	W173.1, W173.2, W173.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W174	W174.1, W174.2, W174.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W175	W175.1, W175.2, W175.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W176	W176.1, W176.2, W176.3	S	20%	100%	6, F148.1 - Høp st.	K	29-30	NOT report
W177	W177.1, W177.2, W177.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W178	W178.1, W178.2, W178.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W179	W179.1, W179.2, W179.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W180	W180.1, W180.2, W180.3	S	20%	100%	6, F148.1 - Høp st.	K	31-32	NOT report
W181	W181.1, W181.2, W181.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W182	W182.1, W182.2, W182.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W183	W183.1, W183.2, W183.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W184	W184.1, W184.2, W184.3	S	20%	100%	6, F148.1 - Høp st.	K	33-34	NOT report
W185	W185.1, W185.2, W185.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W186	W186.1, W186.2, W186.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W187	W187.1, W187.2, W187.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W188	W188.1, W188.2, W188.3	S	20%	100%	6, F148.1 - Høp st.	K	35-36	NOT report
W189	W189.1, W189.2, W189.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W190	W190.1, W190.2, W190.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W191	W191.1, W191.2, W191.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W192	W192.1, W192.2, W192.3	S	20%	100%	6, F148.1 - Høp st.	K	37-38	NOT report
W193	W193.1, W193.2, W193.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W194	W194.1, W194.2, W194.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W195	W195.1, W195.2, W195.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W196	W196.1, W196.2, W196.3	S	20%	100%	6, F148.1 - Høp st.	K	39-40	NOT report
W197	W197.1, W197.2, W197.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W198	W198.1, W198.2, W198.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W199	W199.1, W199.2, W199.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W200	W200.1, W200.2, W200.3	S	20%	100%	6, F148.1 - Høp st.	K	41-42	NOT report
W201	W201.1, W201.2, W201.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W202	W202.1, W202.2, W202.3	S	20%	100%	6, F148.1 - Høp st.			NOT report
W203	W203.1, W203.2, W203.3	S	20%	100%	6, F148.1 - Høp st.			NOT report





**Visual Control**  
**Visuell kontroll**

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Bottom plate Welds										
W12.1, W12.2	2	-	10%	100%	Laser lap welds	V2V	8-16	NDT report	QC	
W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23	2	-	10%	100%	Laser lap welds	-	8-8	NDT report	QC	
W14.1, W14.2, W14.3, W14.4, W14.5, W14.6	2	-	10%	100%	MIG Fillet weld	V2V	8-20	NDT report	QC	
W15.1, W15.2, W15.3, W15.4	3	-	20%	100%	MIG Fillet weld	V2V	8-30	NDT report	QC	
W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Fillet weld	V2V	8-16	NDT report	QC	

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Doru Baciu</i>





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-90</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P1-P5B) AKSE 1-2</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE  
Prodex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

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Slab / sheet Section	W/R	U-Z	MTX	XT	Weld	Registered	Range	Comments
W1-1	5	100%	100%	100%	U, RW top& top pt	Y	10-18	NOT report QC
W1-2	5	100%	100%	100%	U, RW top& top pt	Y	18-26	NOT report QC
W8-1	8	-	100%	100%	8, Fillet T1 +top pt			NOT report QC
W8-2	8	-	100%	100%	8, Fillet T1 +top pt			NOT report QC
W9-1	8	-	100%	100%	8, Fillet T1 +top pt			NOT report QC
W9-2	8	-	100%	100%	8, Fillet T1 +top pt			NOT report QC
W10-1	8	-	100%	100%	U, Fillet Long pt			NOT report QC
W10-2	8	-	100%	100%	U, Fillet Long pt			NOT report QC
W17.1, W17.2, W17.3, W17.4	3	-	100%	100%	3, FW, vertical			NOT report QC
W17.5, W17.6, W17.7, W17.8, W17.9, W17.10	3	-	100%	100%	3, FW, vertical			NOT report QC
W17.11, W17.12, W17.13, W17.14, W17.15, W17.16, W17.17	3	-	100%	100%	3, FW, vertical			NOT report QC
W17.18, W17.19, W17.20, W17.21, W17.22, W17.23, W17.24, W17.25, W17.26, W17.27, W17.28, W17.29, W17.30, W17.31, W17.32, W17.33, W17.34, W17.35, W17.36, W17.37, W17.38, W17.39, W17.40, W17.41, W17.42, W17.43, W17.44, W17.45, W17.46, W17.47, W17.48, W17.49, W17.50, W17.51, W17.52, W17.53, W17.54, W17.55, W17.56, W17.57, W17.58, W17.59, W17.60, W17.61, W17.62, W17.63, W17.64, W17.65, W17.66, W17.67, W17.68, W17.69, W17.70, W17.71, W17.72, W17.73, W17.74, W17.75, W17.76, W17.77, W17.78, W17.79, W17.80, W17.81, W17.82, W17.83, W17.84, W17.85, W17.86, W17.87, W17.88, W17.89, W17.90, W17.91, W17.92, W17.93, W17.94, W17.95, W17.96, W17.97, W17.98, W17.99, W17.100	3	-	100%	100%	3, FW, vertical			NOT report QC





Visual Control  
Visuell kontroll

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W12.1, W12.2, W12.3, W12.4, W12.5, W12.6, W12.7, W12.8, W12.9, W12.10, W12.11, W12.12, W12.13, W12.14, W12.15, W12.16, W12.17, W12.18, W12.19, W12.20, W12.21, W12.22, W12.23, W12.24, W12.25, W12.26, W12.27, W12.28, W12.29, W12.30, W12.31, W12.32, W12.33, W12.34, W12.35, W12.36, W12.37, W12.38, W12.39, W12.40, W12.41, W12.42, W12.43, W12.44, W12.45, W12.46, W12.47, W12.48, W12.49, W12.50, W12.51, W12.52, W12.53, W12.54, W12.55, W12.56, W12.57, W12.58, W12.59, W12.60, W12.61, W12.62, W12.63, W12.64, W12.65, W12.66, W12.67, W12.68, W12.69, W12.70, W12.71, W12.72, W12.73, W12.74, W12.75, W12.76, W12.77, W12.78, W12.79, W12.80, W12.81, W12.82, W12.83, W12.84, W12.85, W12.86, W12.87, W12.88, W12.89, W12.90, W12.91, W12.92, W12.93, W12.94, W12.95, W12.96, W12.97, W12.98, W12.99, W12.100	8	-	100%	100%	8, F.W, vertical	V10	8-20, 8-18	NDT report	QC		
W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30, W13.31, W13.32, W13.33, W13.34, W13.35, W13.36, W13.37, W13.38, W13.39, W13.40, W13.41, W13.42, W13.43, W13.44, W13.45, W13.46, W13.47, W13.48, W13.49, W13.50, W13.51, W13.52, W13.53, W13.54, W13.55, W13.56, W13.57, W13.58, W13.59, W13.60, W13.61, W13.62, W13.63, W13.64, W13.65, W13.66, W13.67, W13.68, W13.69, W13.70, W13.71, W13.72, W13.73, W13.74, W13.75, W13.76, W13.77, W13.78, W13.79, W13.80, W13.81, W13.82, W13.83, W13.84, W13.85, W13.86, W13.87, W13.88, W13.89, W13.90, W13.91, W13.92, W13.93, W13.94, W13.95, W13.96, W13.97, W13.98, W13.99, W13.100	4	100%	100%	100%	8, Flat vert. string			NDT report	QC		
W10.5, W10.6	3	-	10%	100%	8, fillet vert. triplate	8	8-15	NDT report	QC		
W14.1	5	100%	100%	100%	8W, long. pt	W	14-23	NDT report	QC		
W16.1, W16.2	5	-	100%	100%	8W, long. pt	V	16-16	NDT report	QC		
W19, W17	3	-	10%	100%	7W	T	19-16	NDT report	QC		

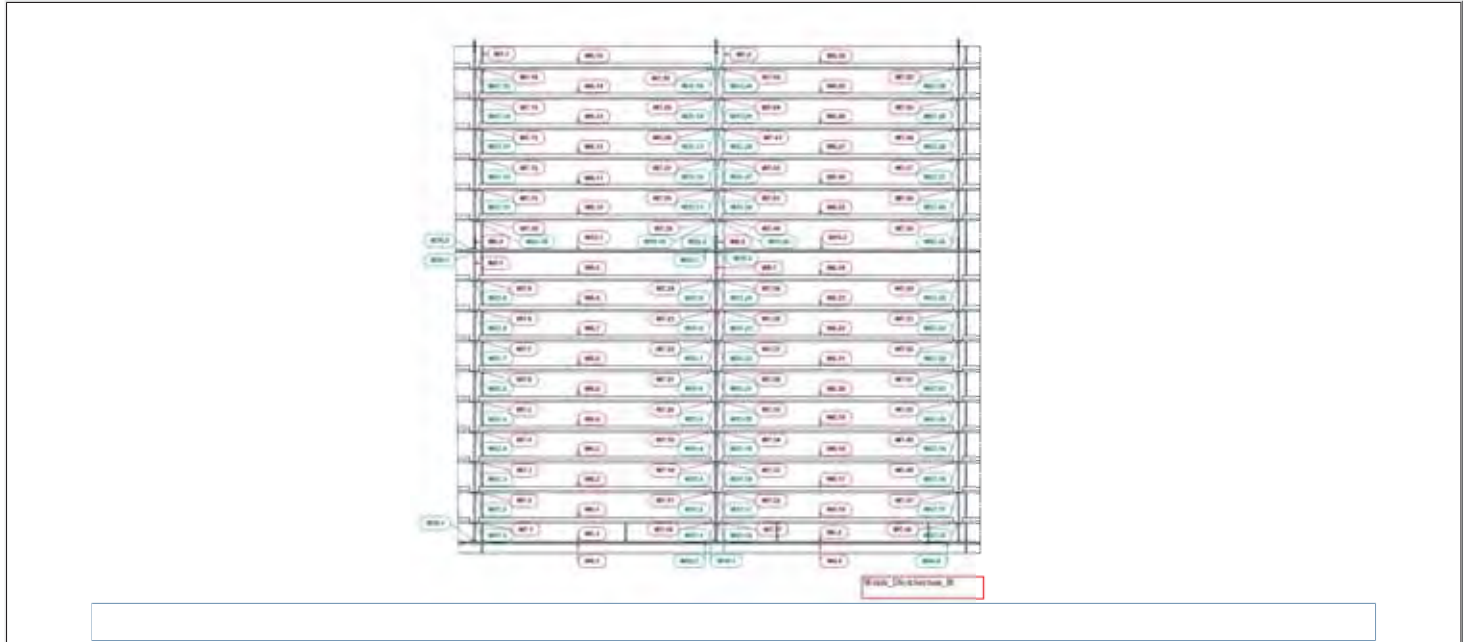
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Bottom plate Welds										
W13.1, W13.2	2	-	10%	100%	Laser Lap welds	10V	8-16	NDT report	QC	
W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30, W13.31, W13.32, W13.33, W13.34, W13.35, W13.36, W13.37, W13.38, W13.39, W13.40, W13.41, W13.42, W13.43, W13.44, W13.45, W13.46, W13.47, W13.48, W13.49, W13.50, W13.51, W13.52, W13.53, W13.54, W13.55, W13.56, W13.57, W13.58, W13.59, W13.60, W13.61, W13.62, W13.63, W13.64, W13.65, W13.66, W13.67, W13.68, W13.69, W13.70, W13.71, W13.72, W13.73, W13.74, W13.75, W13.76, W13.77, W13.78, W13.79, W13.80, W13.81, W13.82, W13.83, W13.84, W13.85, W13.86, W13.87, W13.88, W13.89, W13.90, W13.91, W13.92, W13.93, W13.94, W13.95, W13.96, W13.97, W13.98, W13.99, W13.100	2	-	10%	100%	Laser Lap welds		8-8	NDT report	QC	
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	MIG Fillet weld	12V	8-20	NDT report	QC	
W15.1, W15.2, W15.3, W15.4	3	-	10%	100%	MIG Fillet weld	10V	8-20	NDT report	QC	
W16.1, W16.2, W16.3, W16.4	3	-	10%	100%	MIG Fillet weld	10V	8-16	NDT report	QC	



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-90</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-91</b>	PAGE / SIDE <b>1 of/av 5</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P6-P10B) AKSE 2-3</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

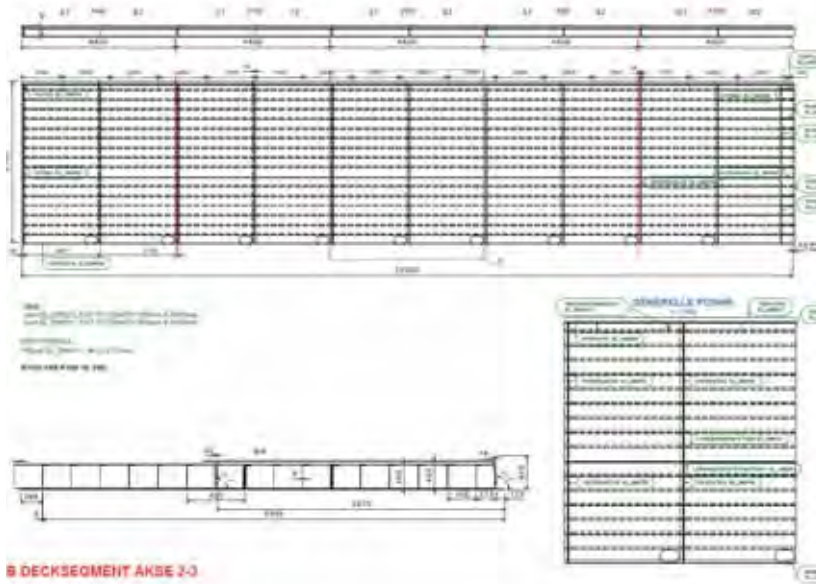
CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

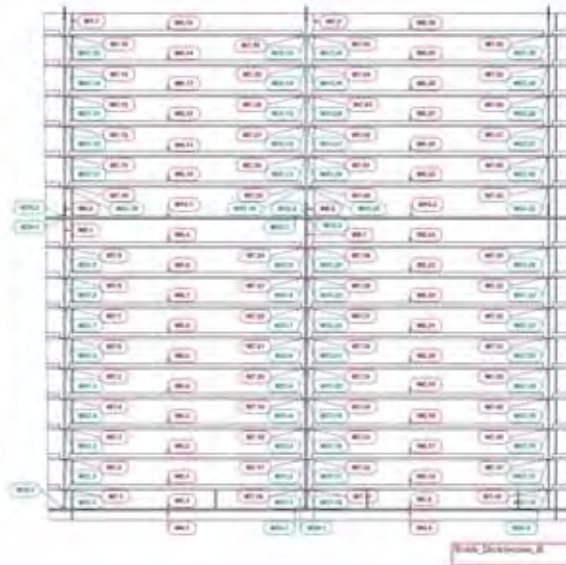
DATE OF TESTING / KONTROLLDATO  
2023-06-16

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B DECKSEGMENT AKSE 2-3



B DECKSEGMENT AKSE 2-3





# Visual Control Visuell kontroll

CLIENT / KUNDE  
Prodex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-16

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Side & dash Section weld no.	W/C	UT	MT/PT	VT	Weld Details			Registered doc.	Respons- ible	Comments
W1.1	5	100%	100%	100%	LH, RW top& top pl	Y	16-16	NOT report	QC	
W1.2	5	100%	100%	100%	LH, RW top& top pl	Y	16-16	NOT report	QC	
W1.3	5	-	100%	100%	LH, FW, side pl. h	T	16-16	NOT report	QC	
W1.4	5	-	100%	100%	LH, FW, side pl. h	T	16-16	NOT report	QC	
W1.5	5	-	100%	100%	R, FW, side pl. h	T	16-16	NOT report	QC	
W1.6	5	-	100%	100%	R, FW, side pl. h	T	16-16	NOT report	QC	
W2.1, W6.1, W7.16	5	-	20%	100%	LH+R, FW, L profile			NOT report	QC	Reducta after 200m of same weld from 100%
W2.2, W6.2, W7.17	5	-	20%	100%	LH+R, FW, L profile			NOT report	QC	MT to 50%MT and after another 100m to 20%
W2.3, W6.3, W7.18	5	-	20%	100%	LH+R, FW, L profile			NOT report	QC	MT, if weld failures
W2.4, W6.4, W7.19	5	-	20%	100%	LH+R, FW, L profile			NOT report	QC	
W2.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW, L profile			NOT report	QC	



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-91</b>	PAGE / SIDE <b>4 of/av 5</b>
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53	W2.11, W6.11, W7.25	3	20%	100%	LH+R, FW, L profile	T	E-10	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after another 100m to 20% MT. If weld failures occur, the test will be set again to 100% MT				
54	W2.12, W6.12, W7.27	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
55	W2.13, W6.13, W7.28	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
56	W2.14, W6.14, W7.29	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
57	W2.15, W6.15, W7.30	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
58	W2.16, W6.16, W7.31	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
59	W2.17, W6.17, W7.32	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
60	W2.18, W6.18, W7.33	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
61	W2.19, W6.19, W7.34	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
62	W2.20, W6.20, W7.35	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
63	W2.21, W6.21, W7.36	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
64	W2.22, W6.22, W7.37	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
65	W2.23, W6.23, W7.38	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
66	W2.24, W6.24, W7.39	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
67	W2.25, W6.25, W7.40	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
68	W2.26, W6.26, W7.41	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
69	W2.27, W6.27, W7.42	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
70	W2.28, W6.28, W7.43	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
71	W2.29, W6.29, W7.44	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
72	W2.30, W6.30, W7.45	5	20%	100%	LH+R, FW, L profile			NDT report	QC					
73	W6.1	3	20%	100%	R, Fillet, Tr. +top pl			K	16-20			NDT report	QC	

66	W9.2	3	20%	100%	R, Fillet, Tr. +top pl	K	16-20	NDT report	QC	
67										
68	W10.1	5	100%	100%	LH, Fillet, Long. pl.	T	16-20	NDT report	QC	
69	W10.2	5	100%	100%	LH, Fillet, Long. pl.			NDT report	QC	
70	W57.1, W31.1, W31.16, W57.16	3	20%	100%	R, FW, vertical	T	16-20	NDT report	QC	
71	W57.2, W31.2, W31.17, W57.17	3	20%	100%	R, FW, vertical			NDT report	QC	
72	W57.3, W31.3, W31.18, W57.18	3	20%	100%	R, FW, vertical			NDT report	QC	
73	W57.4, W31.4, W31.19, W57.19	3	20%	100%	R, FW, vertical			NDT report	QC	
74	W57.5, W31.5, W31.20, W57.20	3	20%	100%	R, FW, vertical			NDT report	QC	
75	W57.6, W31.6, W31.21	3	20%	100%	R, FW, vertical			NDT report	QC	

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# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-91</b>	PAGE / SIDE <b>5 of/av 5</b>
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Weld ID	QTY	Defect %	Accept %	Material	Orientation	Location	Result	QC
W57.3, W11.9, W11.24, W57.24	3	-	20%	100%	R, FW, vertical		NOT report	QC
W57.15, W11.10	1	-	20%	100%	R, FW, vertical		NOT report	QC
W57.16, W11.11	3	-	20%	100%	R, FW, vertical		NOT report	QC
W57.12, W11.12, W11.27, W11.27	3	-	20%	100%	R, FW, vertical		NOT report	QC
W57.13, W11.13	3	-	20%	100%	R, FW, vertical		NOT report	QC
W57.14, W11.14, W11.26, W11.26	3	-	20%	100%	R, FW, vertical		NOT report	QC
W57.15, W11.15, W11.25, W11.25	3	-	20%	100%	R, FW, vertical		NOT report	QC
W19.1, W19.2, W11.2	4	50%	100%	100%	R, fillet aert. breieng	K 30-20	NOT report	QC
W19.1, W19.1	1	-	20%	100%	R, fillet vert., fr-side	K 30-18	NOT report	QC
W42.1	5	100%	100%	100%	BW, long. pt.	V 20-20	NOT report	QC
W11.1, W11.1	5	-	100%	100%	BW, long. pt.	V 16-16	NOT report	QC

Suture plate Welds									
Weld ID	QTY	Defect %	Accept %	Material	Orientation	Location	Result	QC	
W11.1, W11.1	2	-	10%	100%	Layer lap welds	W11 8-18	NOT report	QC	
W11.1, W11.2, W11.3, W11.4, W11.5, W11.6, W11.7, W11.8, W11.9, W11.10, W11.11, W11.12, W11.13, W11.14, W11.15, W11.16, W11.17, W11.18, W11.19, W11.20, W11.21, W11.22, W11.23, W11.24, W11.25, W11.26, W11.27, W11.28, W11.29, W11.30, W11.31, W11.32	3	-	10%	100%	Layer lap welds	W11 8-18	NOT report	QC	
W11.1, W11.1, W11.1, W11.1	2	-	10%	100%	MIG fillet weld	W11 8-20	NOT report	QC	
W11.1, W11.1, W11.1, W11.1	1	-	20%	100%	MIG fillet weld	W11 8-20	NOT report	QC	

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-92</b>	PAGE / SIDE <b>1 of/av 5</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P11-P15B) AKSE 3-4</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

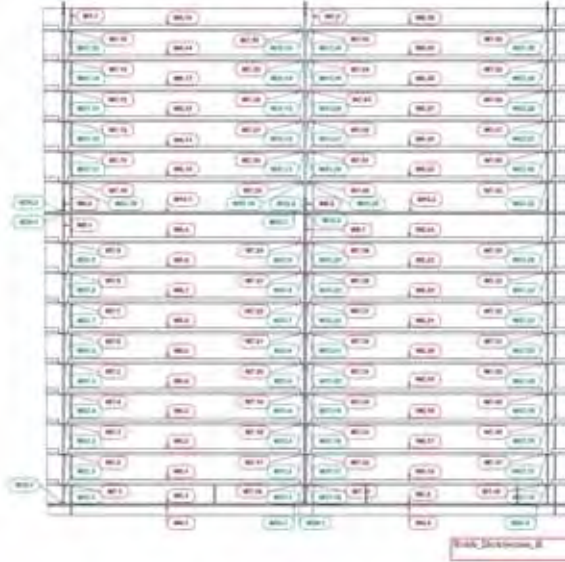
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-07-04**

REPORT NO. / RAPPORT NR.  
**10031-23-VT-92**

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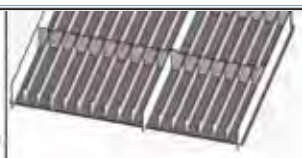




# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-92</b>	PAGE / SIDE <b>3 of/av 5</b>
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Side & dash Section weld no.	W/C	UT	MT/PT	VT	Weld Details			Registered doc.	Responsi- ble	Comments
W6.1	5	100%	100%	100%	LH, RW top& top pl	Y	16-16	NDT report	QC	
W6.2	5	100%	100%	100%	LH, RW top& top pl	Y	16-16	NDT report	QC	
W6.3	5	-	100%	100%	LH, FW, side pl. h	T	16-16	NDT report	QC	
W6.4	5	-	100%	100%	LH, FW, side pl. h	T	16-16	NDT report	QC	
W6.5	5	-	100%	100%	R, FW, side pl. h	T	16-16	NDT report	QC	
W6.6	5	-	100%	100%	R, FW, side pl. h	T	16-16	NDT report	QC	
W7.1, W6.7, W7.16	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	Reduced after 200m of same weld from 100%
W7.7, W6.2, W7.27	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	MT to 50%MT and after another 100m to 20%
W7.8, W6.3, W7.18	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	MT, if weld failures occur, the test will be set
W7.9, W6.4, W7.19	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	again to 100% MT
W7.5, W6.5, W7.20	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.15, W6.15, W7.30	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.16, W6.16, W7.31	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.17, W6.17, W7.32	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.18, W6.18, W7.33	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.19, W6.19, W7.34	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.20, W6.20, W7.35	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.21, W6.21, W7.36	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.22, W6.22, W7.37	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.23, W6.23, W7.38	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.24, W6.24, W7.39	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.25, W6.25, W7.40	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.26, W6.26, W7.41	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.27, W6.27, W7.42	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.28, W6.28, W7.43	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.29, W6.29, W7.44	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W7.30, W6.30, W7.45	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
W6.1	5	-	20%	100%	R, Fillet, Tr. +top pl	E	16-30	NDT report	QC	





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-92</b>	PAGE / SIDE <b>4 of/av 5</b>
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6	W9.2	3	—	20%	100%	R, Fillet, Tr. +top pl	K	16-16	NDT report	QC		
7												
8	W10.1	5	—	100%	100%	LH, Fillet, Long. pl.	T	16-20	NDT report	QC		
9	W10.2	5	—	100%	100%	LH, Fillet, Long. pl.			NDT report	QC		
10	W57.1, W31.1, W31.16, W57.16	3	—	20%	100%	R, FW, vertical			NDT report	QC		
11	W57.2, W31.2, W31.17, W57.17	3	—	20%	100%	R, FW, vertical			NDT report	QC		
12	W57.3, W31.3, W31.18, W57.18	3	—	20%	100%	R, FW, vertical			NDT report	QC		
13	W57.4, W31.4, W31.19, W57.19	3	—	20%	100%	R, FW, vertical			NDT report	QC		
14	W57.5, W31.5, W31.20, W57.20	3	—	20%	100%	R, FW, vertical			NDT report	QC		
15	W57.6, W31.6, W31.21, W57.21	3	—	20%	100%	R, FW, vertical			NDT report	QC		

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	W57.2, W31.2, W31.17, W57.17	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.19, W31.19, W31.22, W57.22	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.11, W31.11, W31.26, W57.26	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.12, W31.12, W31.27, W57.27	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.13, W31.13, W31.28, W57.28	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.14, W31.14, W31.29, W57.29	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.15, W31.15, W31.30, W57.30	3	—	20%	100%	R, FW, vertical			NDT report	QC		
	W57.1, W31.1, W31.2	4	50%	100%	100%	R, Fillet vert. tr+long	K	30-20	NDT report	QC		
	W57.1, W31.1	3	—	20%	100%	R, Fillet vert., tr+side	K	30-18	NDT report	QC		
	W57.1	5	100%	100%	100%	FW, long. pl.	V	20-20	NDT report	QC		
	W57.1, W31.1	5	—	100%	100%	FW, long. pl.	V	16-16	NDT report	QC		





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-92</b>	PAGE / SIDE <b>5 of/av 5</b>
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Kontrollplan (Visual)										
W11.1, W11.2	2	-	10%	100%	Laser lag-widde	W11	9-18	NOT report	OC	
W12.1, W12.2, W12.3, W12.4, W12.5, W12.6, W12.7, W12.8, W12.9, W12.10, W12.11, W12.12, W12.13, W12.14, W12.15, W12.16, W12.17, W12.18, W12.19, W12.20, W12.21, W12.22, W12.23, W12.24, W12.25, W12.26, W12.27, W12.28, W12.29, W12.30, W12.31, W12.32, W12.33, W12.34, W12.35, W12.36, W12.37, W12.38, W12.39, W12.40, W12.41, W12.42, W12.43, W12.44, W12.45, W12.46, W12.47, W12.48, W12.49, W12.50, W12.51, W12.52, W12.53, W12.54, W12.55, W12.56, W12.57, W12.58, W12.59, W12.60, W12.61, W12.62, W12.63, W12.64, W12.65, W12.66, W12.67, W12.68, W12.69, W12.70, W12.71, W12.72, W12.73, W12.74, W12.75, W12.76, W12.77, W12.78, W12.79, W12.80, W12.81, W12.82, W12.83, W12.84, W12.85, W12.86, W12.87, W12.88, W12.89, W12.90, W12.91, W12.92, W12.93, W12.94, W12.95, W12.96, W12.97, W12.98, W12.99, W12.100	2	-	10%	100%	Laser lag-widde	W12	8-8	NOT report	OC	
W13.1, W13.2, W13.3, W13.4	2	-	10%	100%	MHC Filter-widde	W13	9-20	NOT report	OC	
W15.1, W15.2, W15.3, W15.4	8	-	20%	100%	MHC Filter-widde	W15	9-20	NOT report	OC	



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-92</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Deck section A (P6-P10A) AKSE 2-3</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs fulfill requirements.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

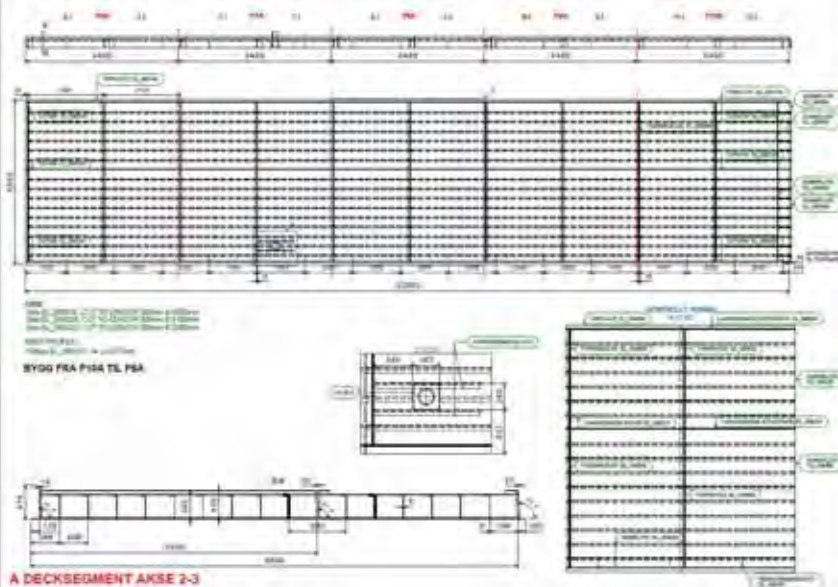
CLIENT / KUNDE  
Prodrex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-01

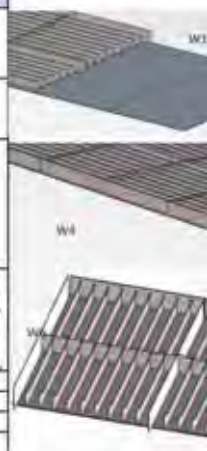
REPORT NO. / RAPPORT NR.  
10031-23-VT-92

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2 of/av 4



A DECKSEGMENT AKSE 2-3

Side A deck Section weld no.	WIC	UT	MT/PT	VT	Weld Details		Registered doc.	Responsible	Comments
W1.1	S	100%	100%	100%	LH, BW top& top pl	Y	1b	NDT report	QC
W1.2	S	100%	100%	100%	LH, BW top& top pl	Y	1b	NDT report	QC
W4.1	S	-	100%	100%	R+LH, FW, side pl. fr	T	1b	NDT report	QC
W4.2	S	-	100%	100%	R+LH, FW L, side pl. fr	T	1b	NDT report	QC
W7.1/W6.1, W7.16	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.2, W6.2, W7.17	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.3, W6.3, W7.18	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.4, W6.4, W7.19	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.5, W6.5, W7.20	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.6, W6.6, W7.21	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.7, W6.7, W7.22	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.8, W6.8, W7.23	S	-	20%	100%	LH+R, FW L profile			NDT report	QC
W7.9, W6.9, W7.24	S	-	20%	100%	LH+R, FW L profile			NDT report	QC









# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-92</b>	PAGE / SIDE <b>4 of/av 4</b>
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W57.15, W31.15, W31.30, W57.30 W39.1, W32.1	3	-	20%	100%	R, FW vertical			NDT report	QC
W39.2, W39.3, W32.2, W32.3	4	50%	100%	100%	R, fillet vert. tr+long	K	16-20	NDT report	QC
W38.1, W30.1	3	-	20%	100%	R, fillet vertical, side	K	16-16, 30-16	NDT report	QC
W42.1, W42.2	5	100%	100%	100%	BW, long. pl.	V	20-20	NDT report	QC
W55.1, W55.2	5	-	100%	100%	BW, side. pl.	V	16-16	NDT report	QC
W76, W77	2	-	10%	100%	FW	1	16-16	NDT report	QC
<b>Bottom plate Welds</b>									
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	1/2V	8-16	NDT report	QC

W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30	2	-	10%	100%	Laser Lap welds		8-8	NDT report	QC
W14.1, W14.2, W14.3, W14.4, W14.5, W14.6	2	-	10%	100%	MIG Fillet weld	1/2V	8-20	NDT report	QC
W15.1, W15.2, W15.3, W15.4	3	-	20%	100%	MIG Fillet weld	1/2V	8-30	NDT report	QC
W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Fillet weld	1/2V	8-16	NDT report	QC

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Doru Baci</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-93</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P1-P5B) AKSE 1-2</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-08-02

REPORT NO. / RAPPORT NR.  
10031-23-VT-93

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A grid diagram consisting of 10 columns and 15 rows. Each cell in the grid contains a small colored circle (red, green, or blue) and a small number. The grid is used for visual control or inspection. At the bottom right of the grid, there is a small red box containing the text "2023-08-02".



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-93</b>	PAGE / SIDE <b>3 of/av 3</b>
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W4.1	5	-	100%	100%	U, FW, side pl. h	T	16-16	NDT report	QC
W4.2	5	-	100%	100%	U, FW, side pl. f	I	19-19	NDT report	QC
W5.1	5	-	100%	100%	B, FW, side pl. h	T	16-16	NDT report	QC
W5.2	5	-	100%	100%	R, FW, side pl. h	I	16-16	NDT report	QC
W7.1, W7.11, W7.16	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.2, W7.3, W7.17	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.3, W7.3, W7.18	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.4, W7.4, W7.19	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.5, W7.5, W7.20	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.6, W7.6, W7.21	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.7, W7.7, W7.22	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.8, W7.8, W7.23	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.9, W7.9, W7.24	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.10, W7.10, W7.25	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.11, W7.11, W7.26	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.12, W7.12, W7.27	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.13, W7.13, W7.28	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.14, W7.14, W7.29	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.15, W7.15, W7.30	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.31, W7.31, W7.32	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.32, W7.32, W7.33	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.33, W7.33, W7.34	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.34, W7.34, W7.35	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.35, W7.35, W7.36	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.36, W7.36, W7.37	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.37, W7.37, W7.38	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.38, W7.38, W7.39	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.39, W7.39, W7.40	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.40, W7.40, W7.41	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.41, W7.41, W7.42	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.42, W7.42, W7.43	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.43, W7.43, W7.44	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.44, W7.44, W7.45	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC
W7.45, W7.45, W7.46	5	-	20%	100%	UH-R, FW, L profile			NDT report	QC

NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-94</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P6-P10B) AKSE 2-3</b> <b>Weld nr. 8.2, 9.1,16.1, 16.2,16.3,16.4, 76,77.</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				

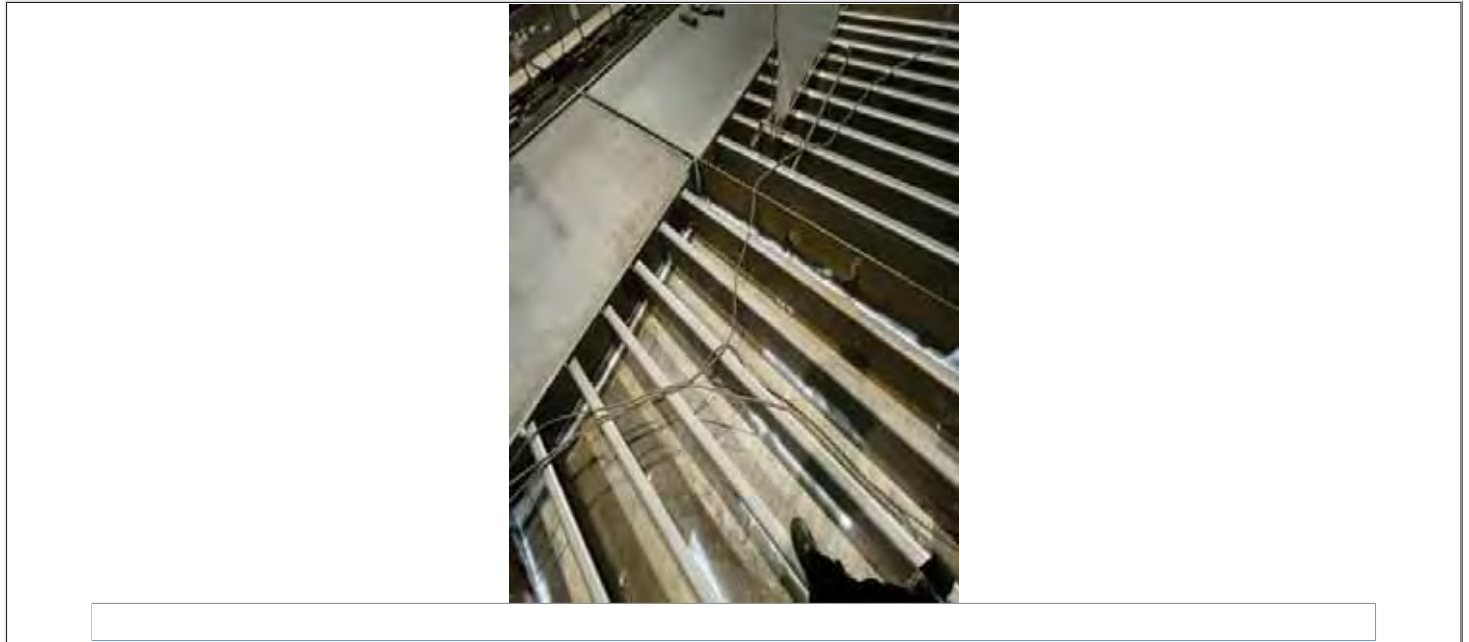






**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-94</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baci</i>





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-95</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P6-P10A) AKSE 2-3 weld nr. 9.1, 10.1. Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

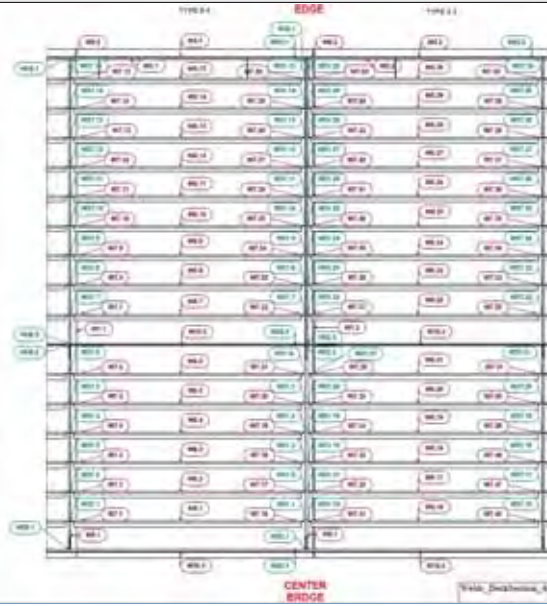
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-06-01**

REPORT NO. / RAPPORT NR.  
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**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-95</b>	PAGE / SIDE <b>3 of/av 3</b>
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6	W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	Reduced after 200m of same weld from 100% MT to 50%MT and after
7	W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
8	W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
9	W7.12, W6.12, W7.27	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
0	W7.13, W6.13, W7.28	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	
1	W7.14, W6.14, W7.29	5	-	20%	100%	LH+R, FW L profile	NDT report	QC	

7	W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW vertical	NDT report	QC
8	W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW vertical	NDT report	QC
9	W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW vertical	NDT report	QC

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baci</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-96</b>	PAGE / SIDE <b>1 of/av 1</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciú</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P11-P15A) AKSE 3-4 weld nr. 76,77. Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				
NAME CERT. NO. / NAVN SERT. NR. <b>()</b>	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Doru Baciú (2026-VT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Doru Baciú (2026-VT)</b>		
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciú</i>		



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P11-P15B) AKSE 3-4</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>2 of/av 4</b>
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8	W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
9	W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
0	W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
1	W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
2	W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-

373							K	16-30			
374	W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl			NDT report	QC	
375	W9.1	3	-	20%	100%	R, Fillet, Tr. +top pl			NDT report	QC	
							K	16-16			



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>3 of/av 4</b>
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385	W57.21										
386	W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW, vertical				NDT report	QC
387	W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW, vertical	V <sub>1/2</sub>	8-30, 8-16		NDT report	QC
5	W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Filet weld	1/2V	8-16		NDT report	QC



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>4 of/av 4</b>
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38	W76,W77	2	-	10%	100%	FW	T	16-16	NDT report	QC
39										
30	<b>Bottom plate Welds</b>									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciú (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciú (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciú</i>





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P11-P15B) AKSE 3-4</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>2 of/av 4</b>
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8	W7.6, W6.6, W7.21	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
9	W7.7, W6.7, W7.22	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
0	W7.8, W6.8, W7.23	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
1	W7.9, W6.9, W7.24	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
2	W7.10, W6.10, W7.25	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
3	W7.11, W6.11, W7.26	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	-
373							K	16-30			
374	W8.2	3	-	20%	100%	R, Fillet, Tr. +top pl			NDT report	QC	
375	W9.1	3	-	20%	100%	R, Fillet, Tr. +top pl			NDT report	QC	
							K	16-16			



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>3 of/av 4</b>
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385	W57.21										
386	W57.7, W31.7, W31.22, W57.22	3	-	20%	100%	R, FW, vertical				NDT report	QC
387	W57.8, W31.8, W31.23, W57.23	3	-	20%	100%	R, FW, vertical	V <sub>1/2</sub>	8-30, 8-16		NDT report	QC
5	W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Filet weld	1/2V	8-16		NDT report	QC



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-04</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-97</b>	PAGE / SIDE <b>4 of/av 4</b>
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38	W76,W77	2	-	10%	100%	FW	T	16-16	NDT report	QC
39										
30	<b>Bottom plate Welds</b>									



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciú (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciú (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciú</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-20</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-98</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section A (P16A to P18A) AKSE 4-5</b> <b>Weld nr: 76,77.</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

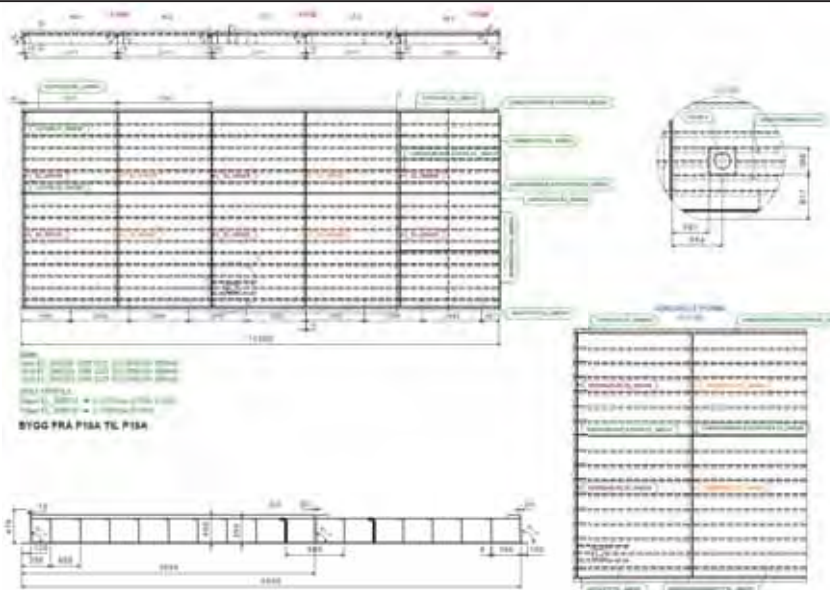
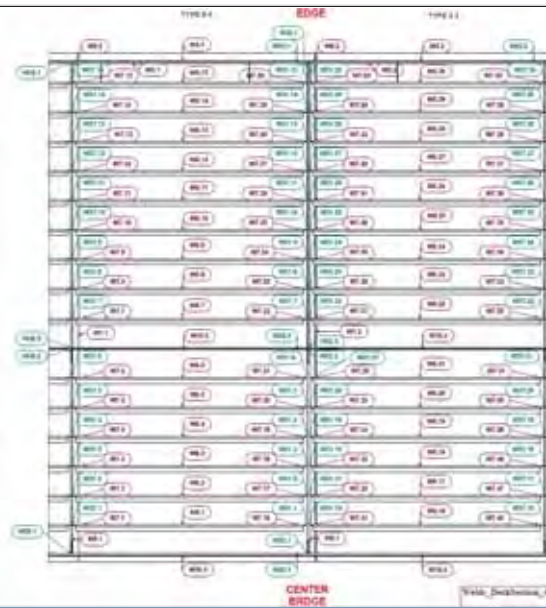
CLIENT / KUNDE  
Prodex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-20

REPORT NO. / RAPPORT NR.  
10031-23-VT-98

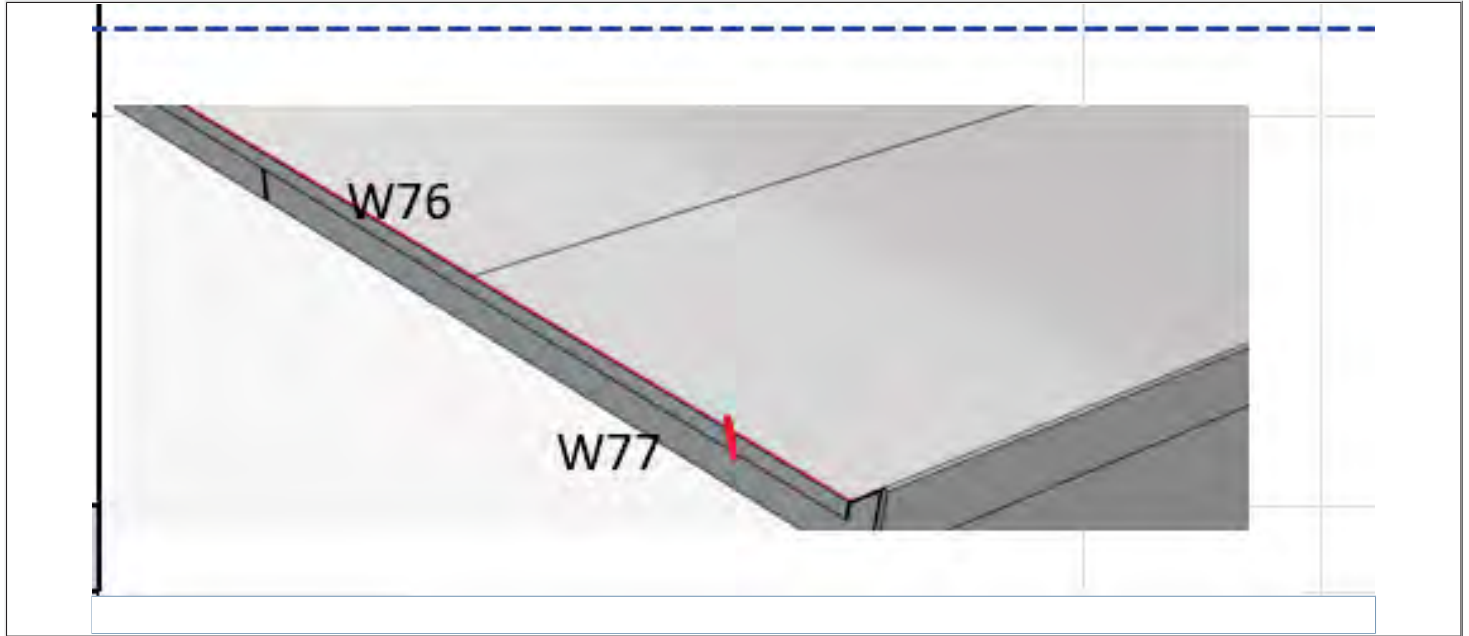
PAGE / SIDE  
2 of/av 3





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-20</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-98</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciú (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciú (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciú</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-99</b>	PAGE / SIDE <b>1 of/av 5</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baci</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Visual testing of weld and HAZ at Deck section B (P16- to P18B) AKSE 4-5</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>After repairs, fulfills requirements.</b>  <b>No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

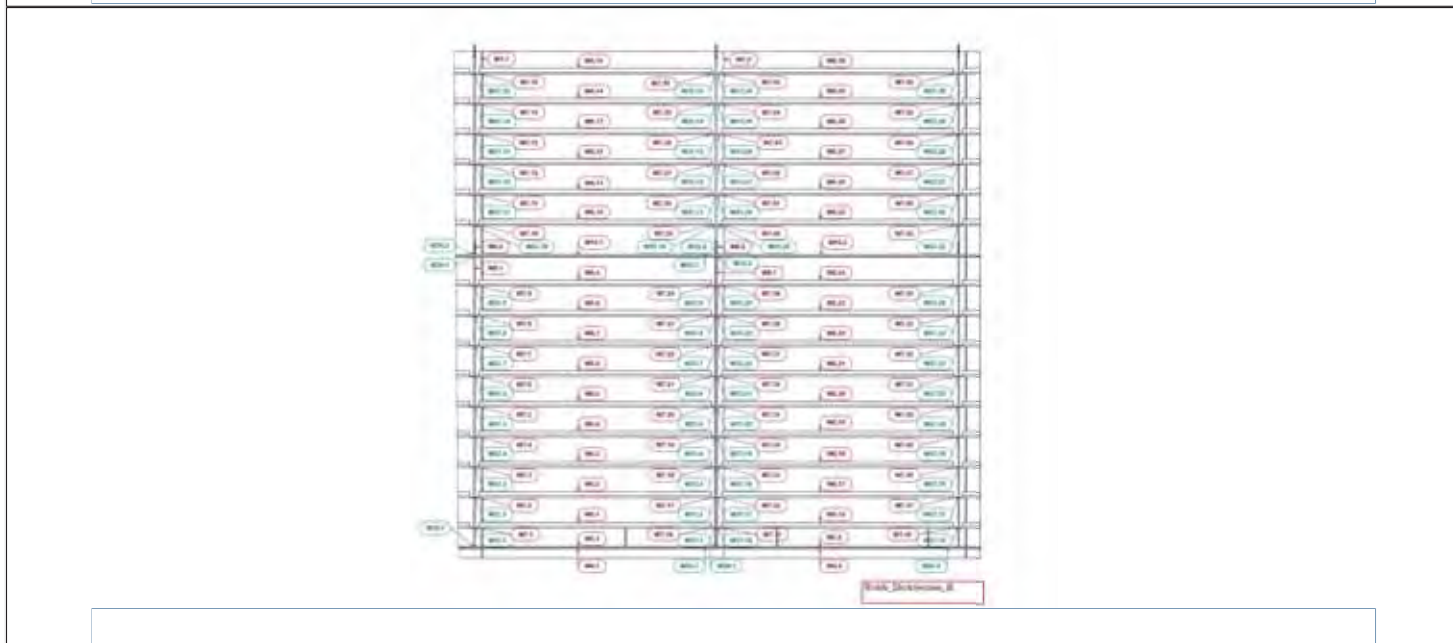
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-16**

REPORT NO. / RAPPORT NR.  
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**2 of/av 5**





# Visual Control Visuell kontroll

CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-16**

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**3 of/av 5**



[Empty box for notes]

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Order No.	QTY	UNIT	DESCRIPTION	Material	Equipment	Quantity	Comments
10001	1	PCB	1x PCB	10001	10001	1	
10002	1	PCB	1x PCB	10002	10002	1	
10003	1	PCB	1x PCB	10003	10003	1	
10004	1	PCB	1x PCB	10004	10004	1	
10005	1	PCB	1x PCB	10005	10005	1	
10006	1	PCB	1x PCB	10006	10006	1	
10007	1	PCB	1x PCB	10007	10007	1	
10008	1	PCB	1x PCB	10008	10008	1	
10009	1	PCB	1x PCB	10009	10009	1	
10010	1	PCB	1x PCB	10010	10010	1	
10011	1	PCB	1x PCB	10011	10011	1	
10012	1	PCB	1x PCB	10012	10012	1	
10013	1	PCB	1x PCB	10013	10013	1	
10014	1	PCB	1x PCB	10014	10014	1	
10015	1	PCB	1x PCB	10015	10015	1	
10016	1	PCB	1x PCB	10016	10016	1	
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# Visual Control Visuell kontroll

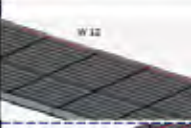
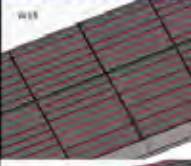
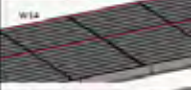


CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-99</b>	PAGE / SIDE <b>4 of/av 5</b>
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Ref.	Code	Material	Location	Inspector	Date	Result	Remarks	Image
95	W17.01	2024	2024	2024	2024	OK		
96	W17.02	2024	2024	2024	2024	OK		
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98	W17.04	2024	2024	2024	2024	OK		
99	W17.05	2024	2024	2024	2024	OK		
100	W17.06	2024	2024	2024	2024	OK		
101	W17.07	2024	2024	2024	2024	OK		
102	W17.08	2024	2024	2024	2024	OK		
103	W17.09	2024	2024	2024	2024	OK		
104	W17.10	2024	2024	2024	2024	OK		
105	W17.11	2024	2024	2024	2024	OK		
106	W17.12	2024	2024	2024	2024	OK		
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110	W17.16	2024	2024	2024	2024	OK		
111	W17.17	2024	2024	2024	2024	OK		
112	W17.18	2024	2024	2024	2024	OK		
113	W17.19	2024	2024	2024	2024	OK		
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117	W17.23	2024	2024	2024	2024	OK		
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129	W17.35	2024	2024	2024	2024	OK		
130	W17.36	2024	2024	2024	2024	OK		
131	W17.37	2024	2024	2024	2024	OK		
132	W17.38	2024	2024	2024	2024	OK		
133	W17.39	2024	2024	2024	2024	OK		
134	W17.40	2024	2024	2024	2024	OK		
135	W17.41	2024	2024	2024	2024	OK		
136	W17.42	2024	2024	2024	2024	OK		
137	W17.43	2024	2024	2024	2024	OK		
138	W17.44	2024	2024	2024	2024	OK		
139	W17.45	2024	2024	2024	2024	OK		
140	W17.46	2024	2024	2024	2024	OK		
141	W17.47	2024	2024	2024	2024	OK		
142	W17.48	2024	2024	2024	2024	OK		
143	W17.49	2024	2024	2024	2024	OK		
144	W17.50	2024	2024	2024	2024	OK		
145	W17.51	2024	2024	2024	2024	OK		
146	W17.52	2024	2024	2024	2024	OK		
147	W17.53	2024	2024	2024	2024	OK		
148	W17.54	2024	2024	2024	2024	OK		
149	W17.55	2024	2024	2024	2024	OK		
150	W17.56	2024	2024	2024	2024	OK		
151	W17.57	2024	2024	2024	2024	OK		
152	W17.58	2024	2024	2024	2024	OK		
153	W17.59	2024	2024	2024	2024	OK		
154	W17.60	2024	2024	2024	2024	OK		
155	W17.61	2024	2024	2024	2024	OK		
156	W17.62	2024	2024	2024	2024	OK		
157	W17.63	2024	2024	2024	2024	OK		
158	W17.64	2024	2024	2024	2024	OK		
159	W17.65	2024	2024	2024	2024	OK		
160	W17.66	2024	2024	2024	2024	OK		
161	W17.67	2024	2024	2024	2024	OK		
162	W17.68	2024	2024	2024	2024	OK		
163	W17.69	2024	2024	2024	2024	OK		
164	W17.70	2024	2024	2024	2024	OK		
165	W17.71	2024	2024	2024	2024	OK		
166	W17.72	2024	2024	2024	2024	OK		
167	W17.73	2024	2024	2024	2024	OK		
168	W17.74	2024	2024	2024	2024	OK		
169	W17.75	2024	2024	2024	2024	OK		
170	W17.76	2024	2024	2024	2024	OK		
171	W17.77	2024	2024	2024	2024	OK		
172	W17.78	2024	2024	2024	2024	OK		
173	W17.79	2024	2024	2024	2024	OK		
174	W17.80	2024	2024	2024	2024	OK		
175	W17.81	2024	2024	2024	2024	OK		
176	W17.82	2024	2024	2024	2024	OK		
177	W17.83	2024	2024	2024	2024	OK		
178	W17.84	2024	2024	2024	2024	OK		
179	W17.85	2024	2024	2024	2024	OK		
180	W17.86	2024	2024	2024	2024	OK		
181	W17.87	2024	2024	2024	2024	OK		
182	W17.88	2024	2024	2024	2024	OK		
183	W17.89	2024	2024	2024	2024	OK		
184	W17.90	2024	2024	2024	2024	OK		
185	W17.91	2024	2024	2024	2024	OK		
186	W17.92	2024	2024	2024	2024	OK		
187	W17.93	2024	2024	2024	2024	OK		
188	W17.94	2024	2024	2024	2024	OK		
189	W17.95	2024	2024	2024	2024	OK		
190	W17.96	2024	2024	2024	2024	OK		
191	W17.97	2024	2024	2024	2024	OK		
192	W17.98	2024	2024	2024	2024	OK		
193	W17.99	2024	2024	2024	2024	OK		
194	W17.100	2024	2024	2024	2024	OK		



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-16</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-99</b>	PAGE / SIDE <b>5 of/av 5</b>
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Bottom plate Welds										
952	W12.1, W12.2	2	100%	100%	Laser Lap welds	UV	S-16	NDT report	QC	
953	W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30	2	100%	100%	Laser Lap welds	UV	S-16	NDT report	QC	
954	W14.1, W14.2, W14.3, W14.4	2	100%	100%	MIG Fillet weld	XUV	S-20	NDT report	QC	
955	W15.1, W15.2, W15.3, W15.4	8	20%	100%	MIG Fillet weld	UV	S-16	NDT report	QC	
956	W16.1, W16.2, W16.3, W16.4	8	20%	100%	MIG Fillet weld	UV	S-16	NDT report	QC	

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2026-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2026-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATØR / OPERATØR DATO:2023-11-22 <i>Doru Baciu</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-100</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beams.</b> <b>AKSE 1-2, 2-3, 3-4, 4-5 A and B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

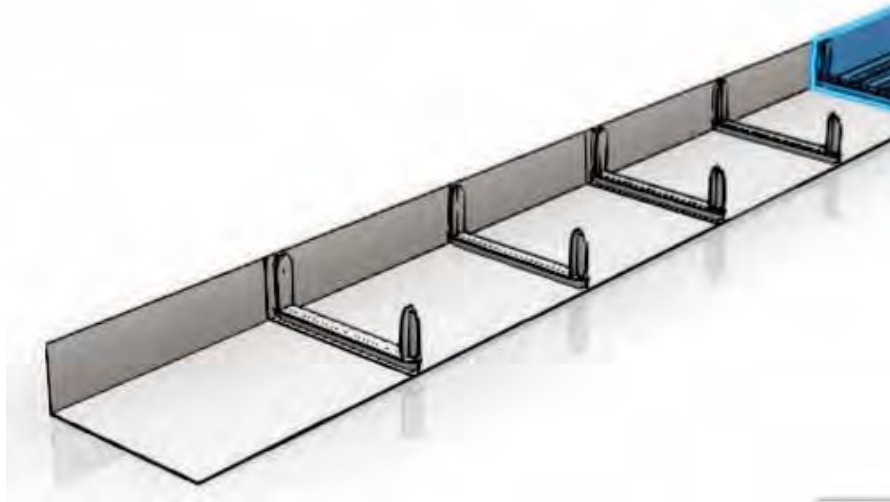
CLIENT / KUNDE  
Prodex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-11-14

REPORT NO. / RAPPORT NR.  
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weld no.	WIC	UT	MT/PT	VT	Weld Details		
W26	3	-	20%	100%	R, FW, Bunnflens & Lagerfundament	T	30-40
W35	4	-	100%	100%	R, FW, Tverbjelke&Langsgaende stegstivere	K	30-20
W46	4	-	100%	100%	R, FWvert. endeplate& Langsgående stegstiver	V	20-20
W69.1	5	100%	100%	100%	M, BW Bunnflens & Bunflens	X	30-30
W69.2	5	100%	100%	100%	M, BW Bunnflens & Bunflens		
W69.3	5	100%	100%	100%	M, BW Bunnflens & Bunflens		
W69.4	5	100%	100%	100%	M, BW Bunnflens & Bunflens		





**Visual Control**  
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CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-100</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-101</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of mounting support beams under AKSE 1-2, 2-3, 3-4, 4-5 A and B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

CLIENT / KUNDE  
**Prodtex Industri As**

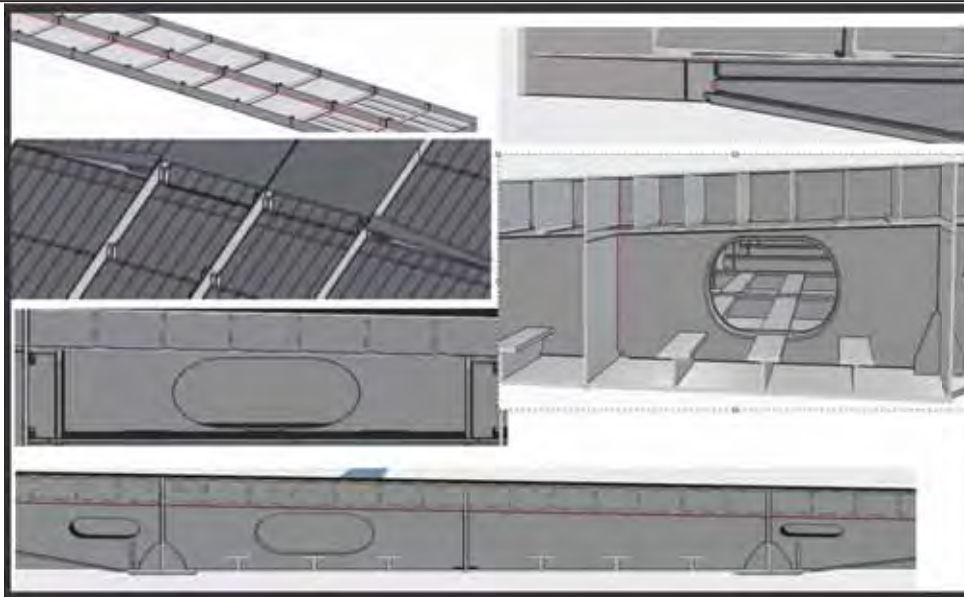
CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-11-13**

REPORT NO. / RAPPORT NR.  
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Weld no.	WAC	UT	MT/VT	VT	Weld Details			Height m/dm	Response	Comments
W25	5	100%	100%	100%	R, RW Burroflens & Endplate	5	30-20	NOT report	QC	
W48	2	-	78	100%	R, TW Burroflens &Langgarns integrasjon	8	30-20	NOT report	QC	
W17	2	-	78	100%	R, TW Burroflens &Langgarns integrasjon	8	30-20	NOT report	QC	
W28	3	10%	10%	100%	M, RW Tverrbjelke &Tverrstake	9	30-40	NOT report	QC	
W29	4	10%	100%	100%	M, RW Tverrbjelke &Tverrstake	9	30-30	NOT report	QC	
W38	3	10%	10%	100%	M, RW Tverrbjelke &Tverrstake	8	30-30	NOT report	QC	
W31	3	-	10%	100%	M, RW Tverrbjelke &Endplate	7	30-18	NOT report	QC	
W54	5	-	10%	100%	M, TW Tverrbjelke &Endplate	10V	18-30	NOT report	QC	
W39	8	10%	10%	100%	R, RW Burroflens &Tverrbjelke	10V	8-30	NOT report	QC	
W41	6	10%	10%	100%	M, RW Langgarns integrasjon & Langgarns	9	28-10	NOT report	QC	
W42	5	10%	10%	100%	wings	8	30-10	NOT report	QC	
W68	5	100%	100%	100%	Tverrstang (Støttestang & Bjelke) med Langgarns integrasjon	8	30-10	NOT report	QC	to be checked and checked on the report
W70	5	100%	100%	100%	M, RW Langgarns integrasjon &Langgarns	10V	20-10	NOT report	QC	Area omitted on drawing etc.
W22	2	-	10%	100%		10V	8-8	NOT report	QC	





**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-101</b>	PAGE / SIDE <b>3 of/av 4</b>
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**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-101</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-23 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-23 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

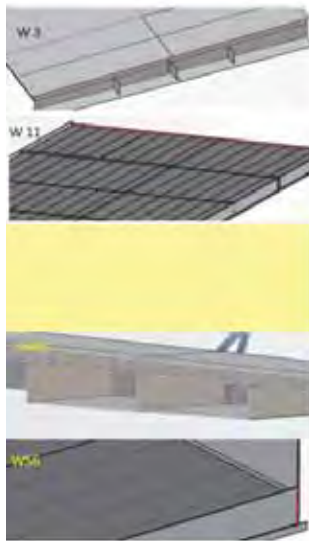
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-102</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of mounting end plate</b> <b>AKSE 1-2, 4-5 A and B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-102</b>	PAGE / SIDE <b>2 of/av 3</b>
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Weld no.	WIC	UT	MT/PT	VT	Weld Details			Registered doc.	Responsible	Comments
W3	5	100%	100%	100%	R, BW Topplate & Endeplate	1/2V	16-20	NDT report	QC	
W11	4	-	20%	100%	R, FW Bunnplate & Endeplate	1/2V	20-8	NDT report	QC	
W25	5	20%	100%	100%	R, BW Bunnflens & Endeplate	K	20-30	NDT report	QC	
W46	4	-	100%	100%	R, BW Bunnplate & Endeplate	1/2V	20-20	NDT report	QC	
W56	5	-	100%	100%	R, BW Sideplate & Endeplate	V	16-20	NDT report	QC	





# Visual Control Visuell kontroll

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-102</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-23 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-23 <i>Popescu Lucian</i>



**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-103</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of assembly.</b> <b>AKSE 1-2, 2-3, 3-4, 4-5 A and B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Visual Control Visuell kontroll

CLIENT / KUNDE  
**Prodtex Industri As**

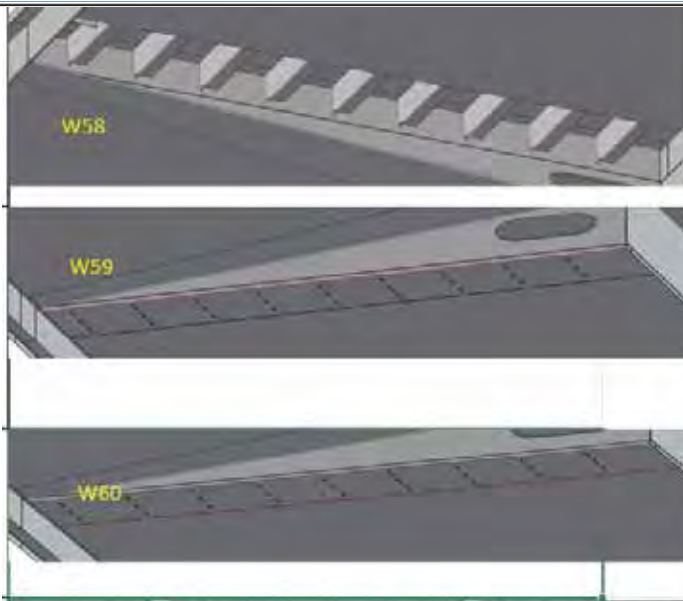
CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-11-01**

REPORT NO. / RAPPORT NR.  
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Widde nr.	Widde	M/TP	VT	Widde Detalle	Sted	8-8	8-10	8-12	8-14	8-16	8-18	8-20
W57	2	96	100%	M, komplett stiva								
W58	2	96	100%	M, 1/4, langgjenlekkingskåp sidenett								
W59	3	120	100%	M, 1/4, komplett sidenett								
W60	3	120	100%	M, 1/4, komplett sidenett								
W61	2	96	100%	M, 1/4, komplett sidenett								
W62	3	120	100%	M, 1/4, komplett sidenett								
W63	3	120	100%	M, 1/4, komplett sidenett								
W64	3	120	100%	M, 1/4, komplett sidenett								

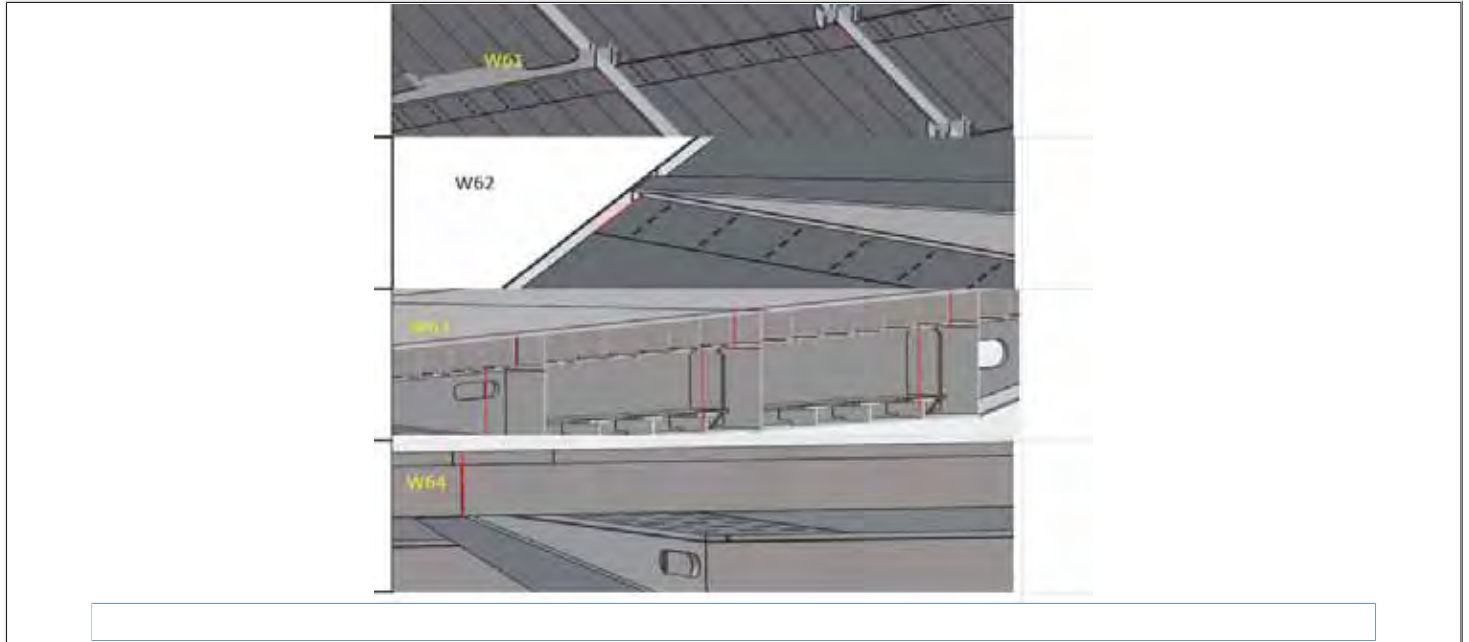






**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-103</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-23 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-23 <i>Popescu Lucian</i>



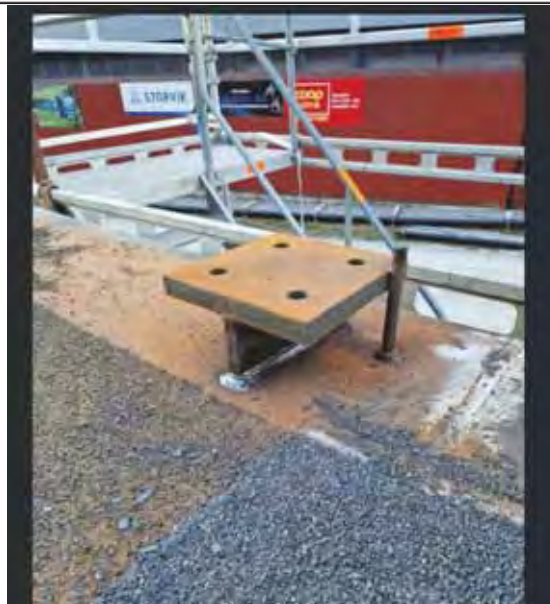
**Visual Control**  
**Visuell kontroll**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-06</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-105</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Railing doubler</b> <b>AKSE 1-2, 2-3, 3-4, 4-5 A and B</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P01 (VT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>EN ISO.5817 Lev B</b>	
COMMENTS / KOMMENTARER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



**Visual Control**  
**Visuell kontroll**

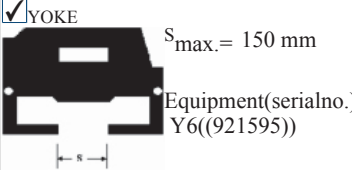
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-06</b>	REPORT NO. / RAPPORT NR. <b>10031-23-VT-105</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (2638-N2-VT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (2638-N2-VT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-28 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-28 <i>Popescu Lucian</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-12</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P15A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

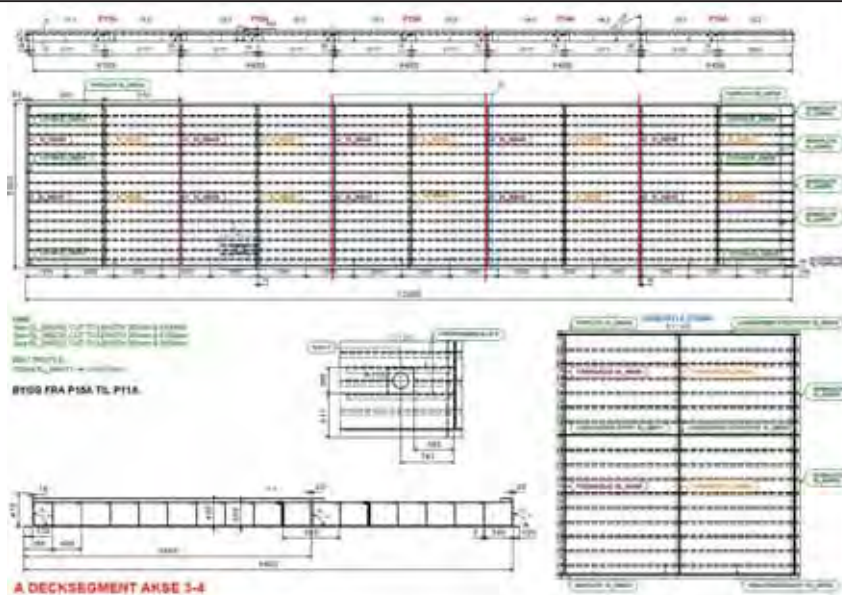
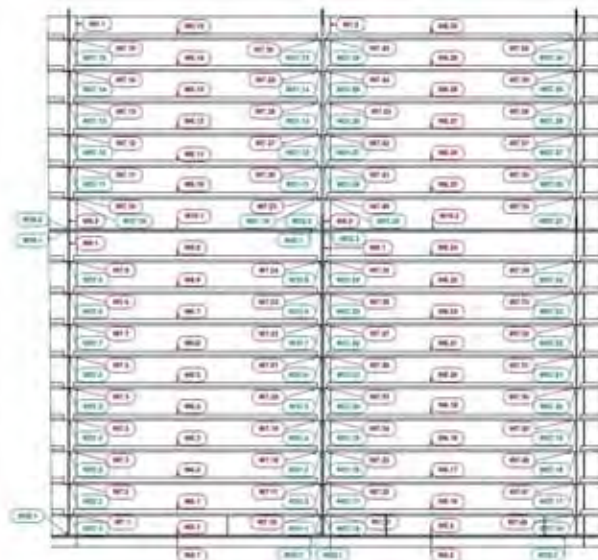
CLIENT / KUNDE  
Prodex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-19

REPORT NO. / RAPPORT NR.  
10031-23-MP-12

PAGE / SIDE  
2 of/av 4





# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROL DATO <b>2023-05-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-12</b>	PAGE / SIDE <b>3 of av 4</b>
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Welding no.	Date	Fillet on Batch no.	ET Magnetic	Wc	IT	MT PT	V1
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## Magnetic testing Magnetpulverprøving

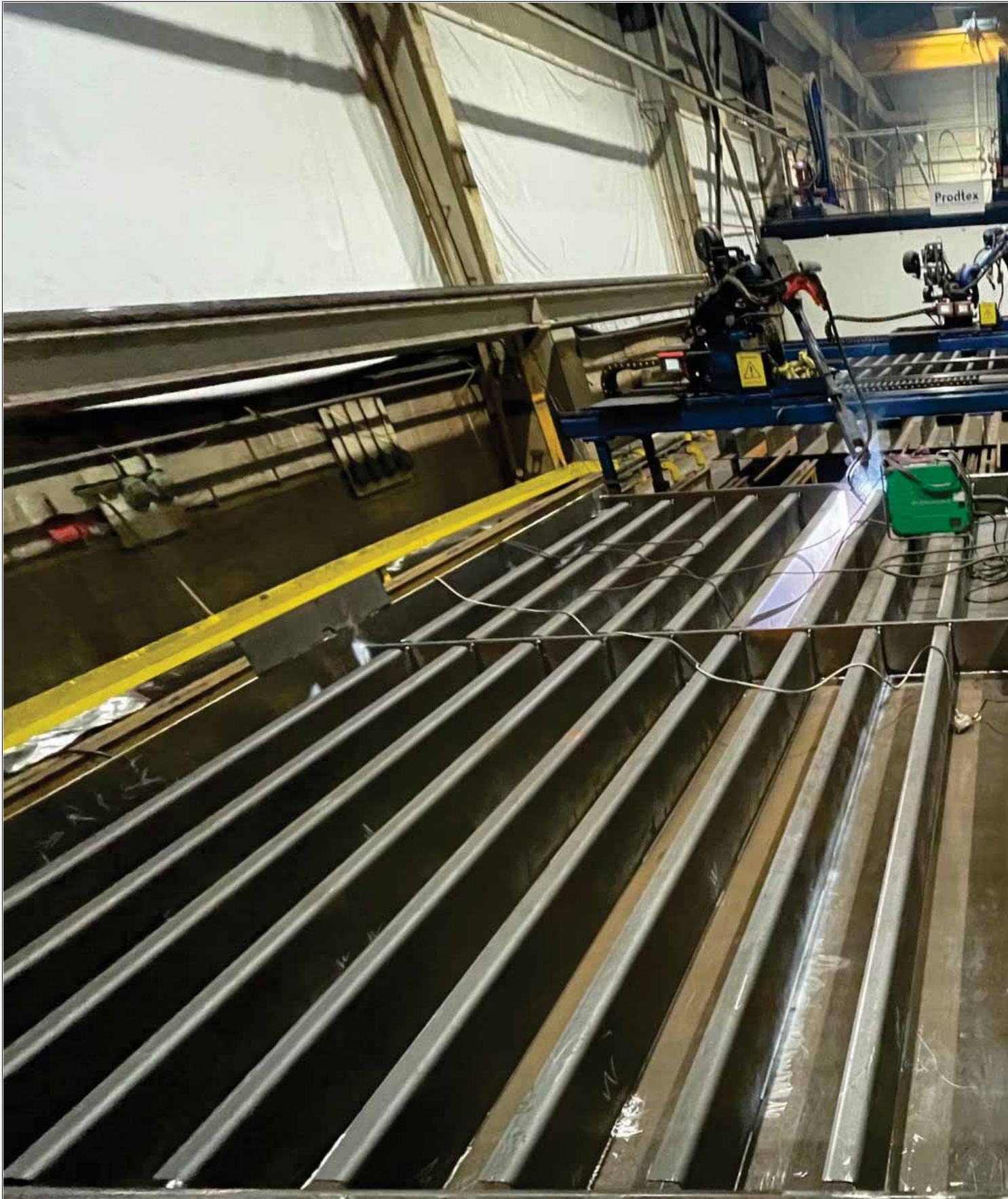
CLIENT / KUNDE  
Prodtex industri as

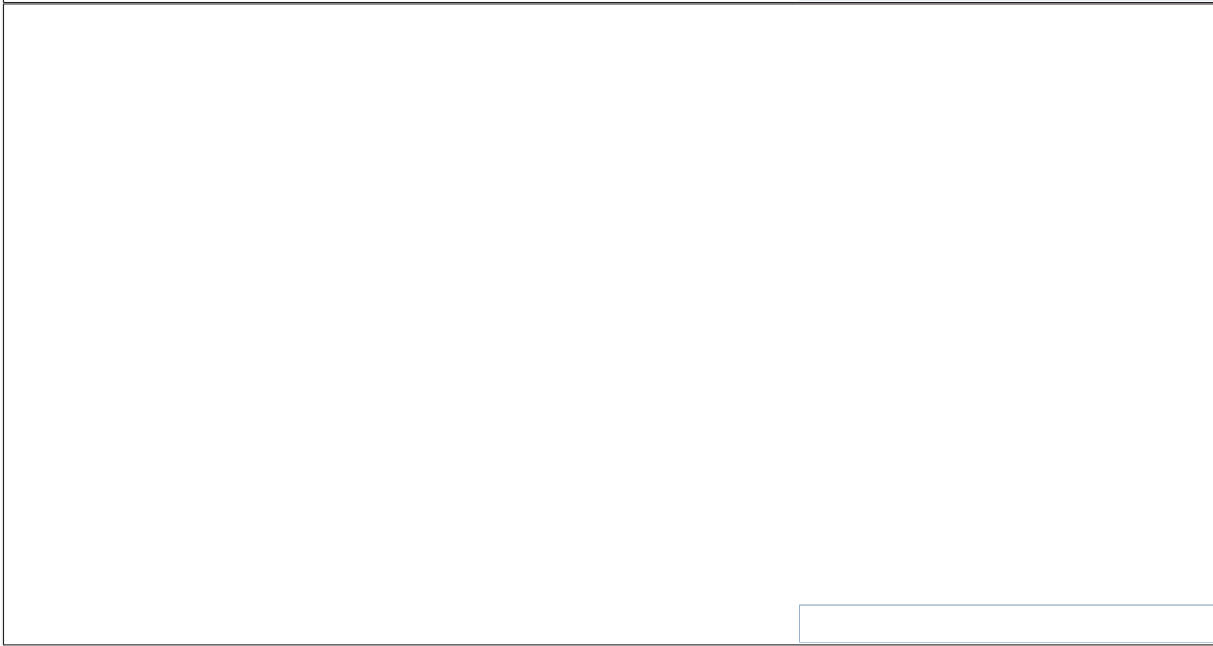
CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-19

REPORT NO. / RAPPORT NR.  
10031-23-MP-12

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4 of/av 4



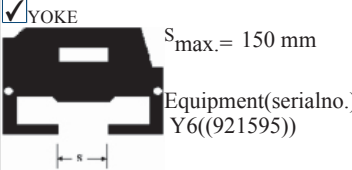


NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Mats K. Skjong</i>





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-13</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P14A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

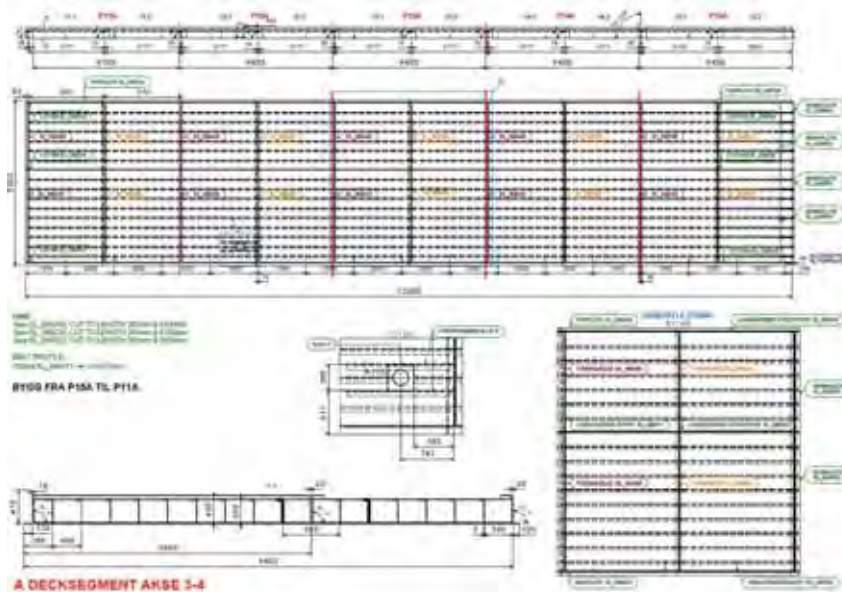
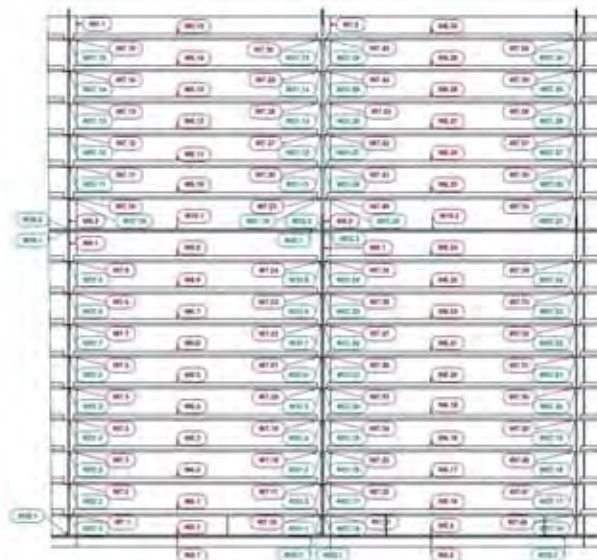
CLIENT / KUNDE  
Prodex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-22

REPORT NO. / RAPPORT NR.  
10031-23-MP-13

PAGE / SIDE  
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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-13</b>	PAGE / SIDE <b>3 of/av 4</b>
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## Magnetic testing Magnetpulverprøving

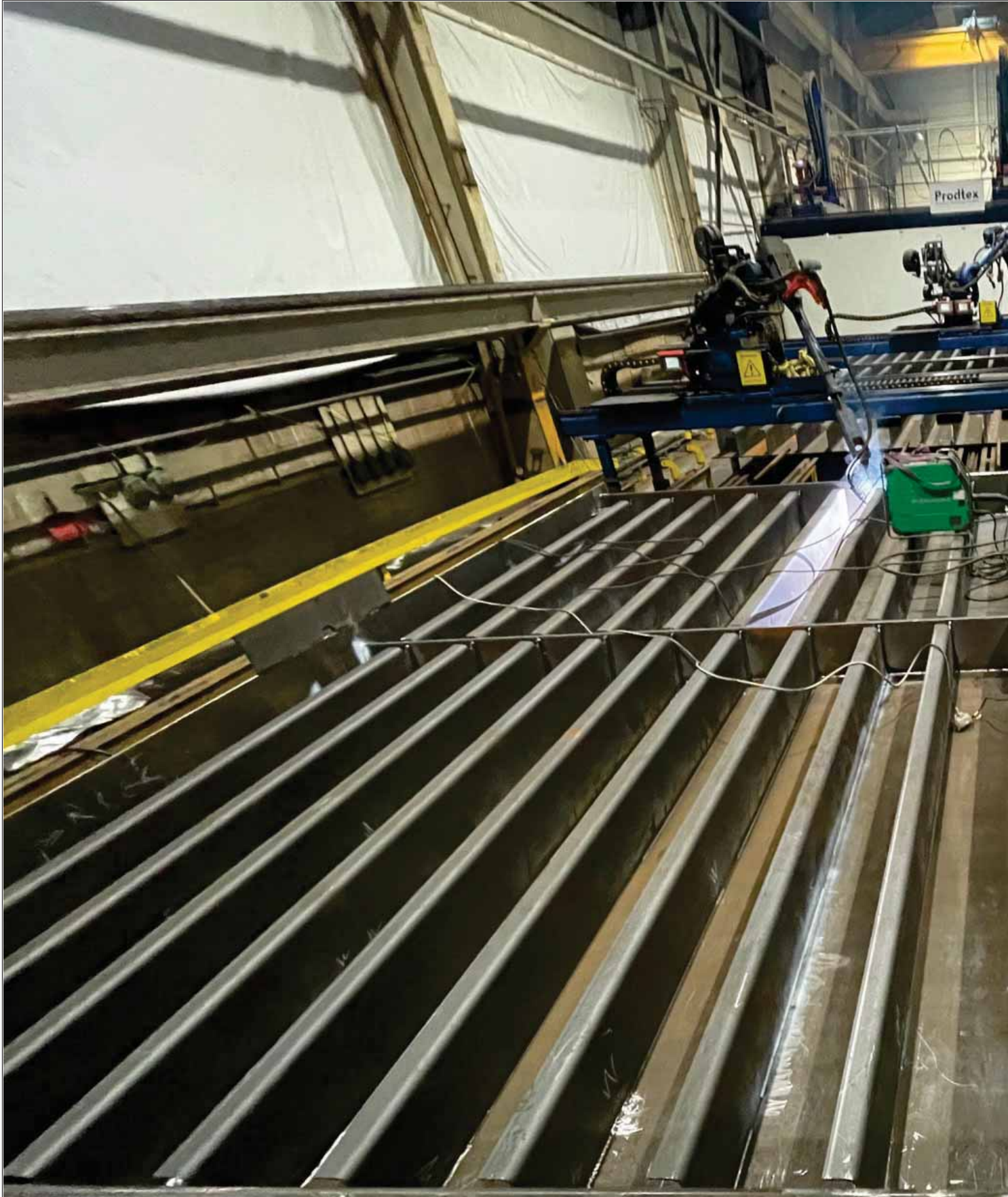
CLIENT / KUNDE  
Prodtex industri as

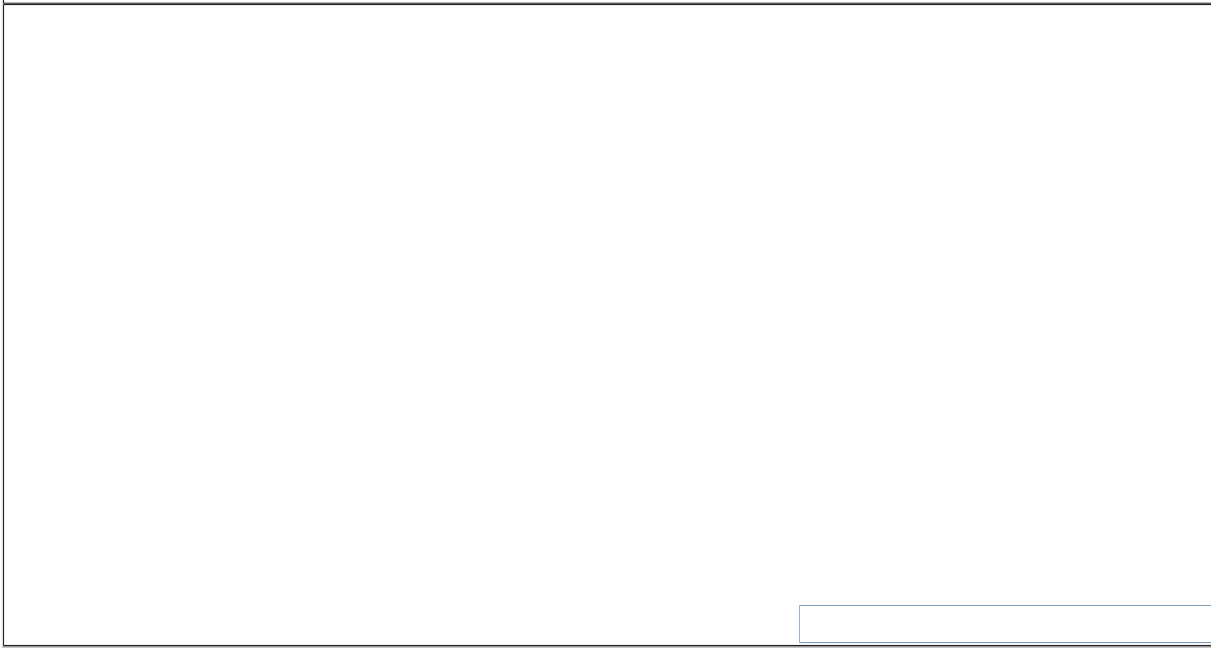
CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-22

REPORT NO. / RAPPORT NR.  
10031-23-MP-13

PAGE / SIDE  
4 of/av 4

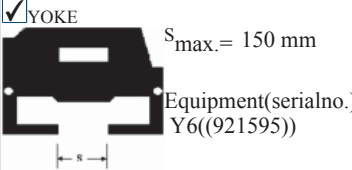




NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Mats K. Skjong</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-26</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-14</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P13A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>After repairs, fulfills requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetspulverprøving

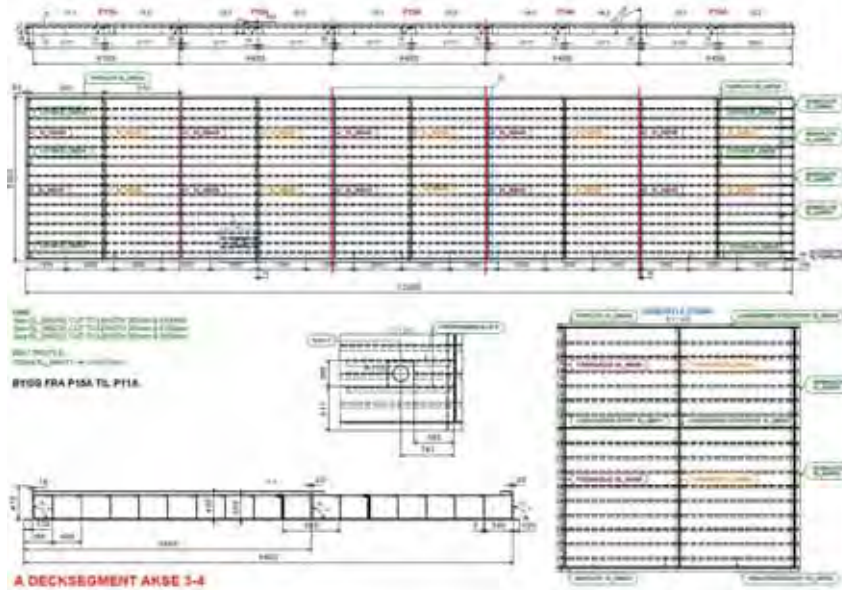
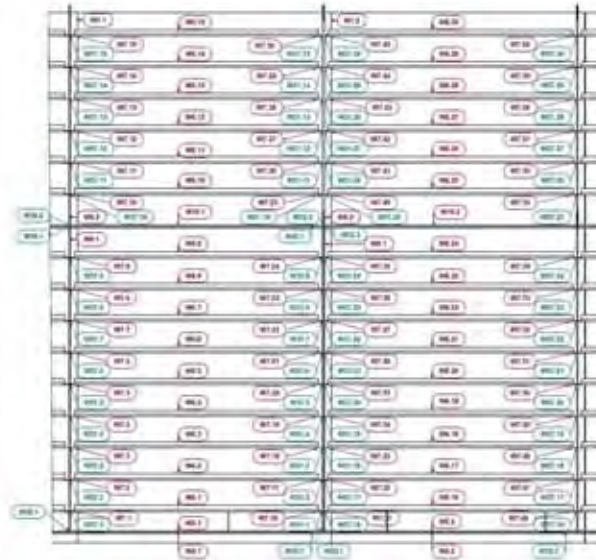
CLIENT / KUNDE  
Prodex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-26

REPORT NO. / RAPPORT NR.  
10031-23-MP-14

PAGE / SIDE  
2 of/av 4





# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-26</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-14</b>	PAGE / SIDE <b>3 of/av 4</b>
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## Magnetic testing Magnetspulverprøving

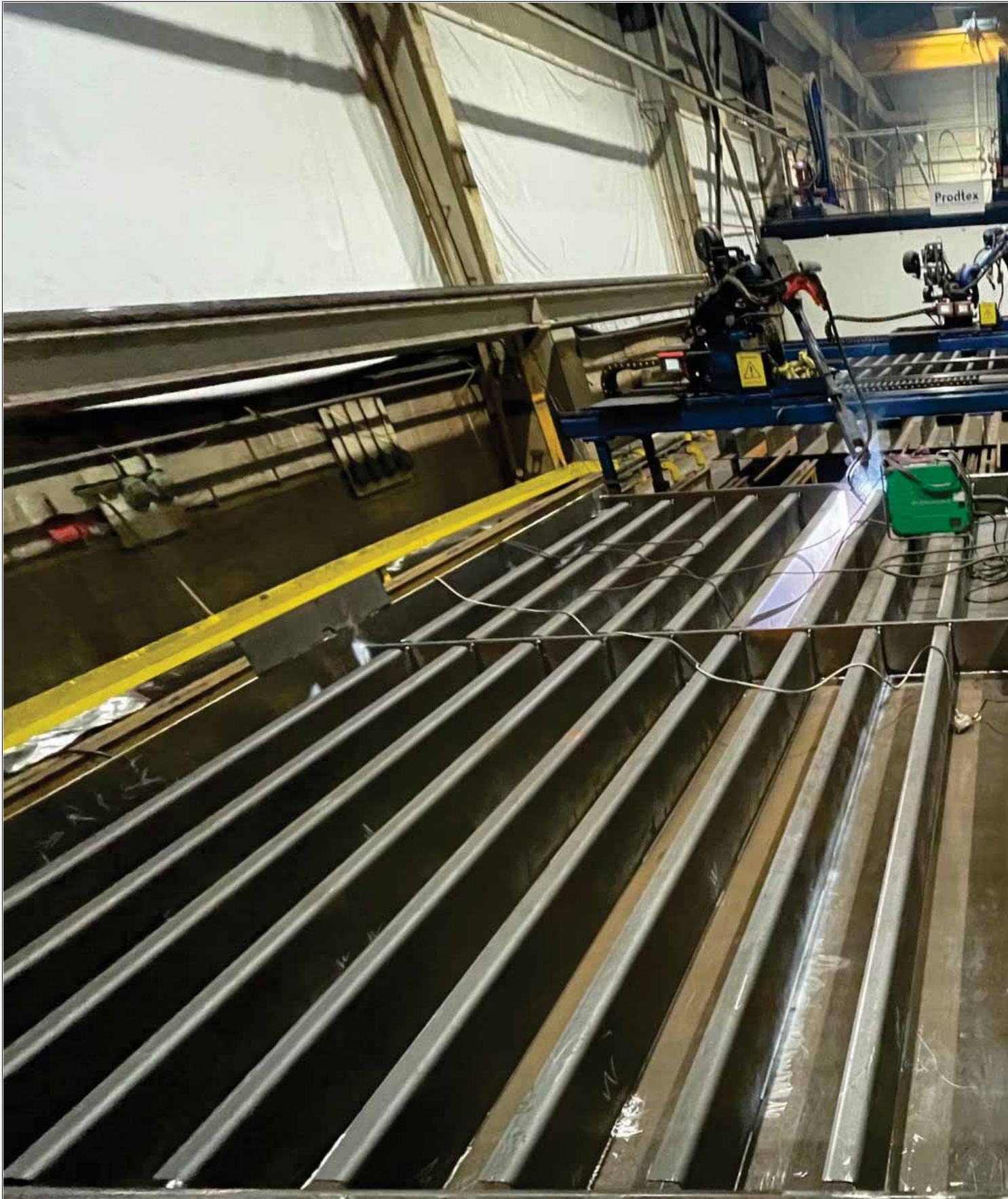
CLIENT / KUNDE  
Prodtex industri as

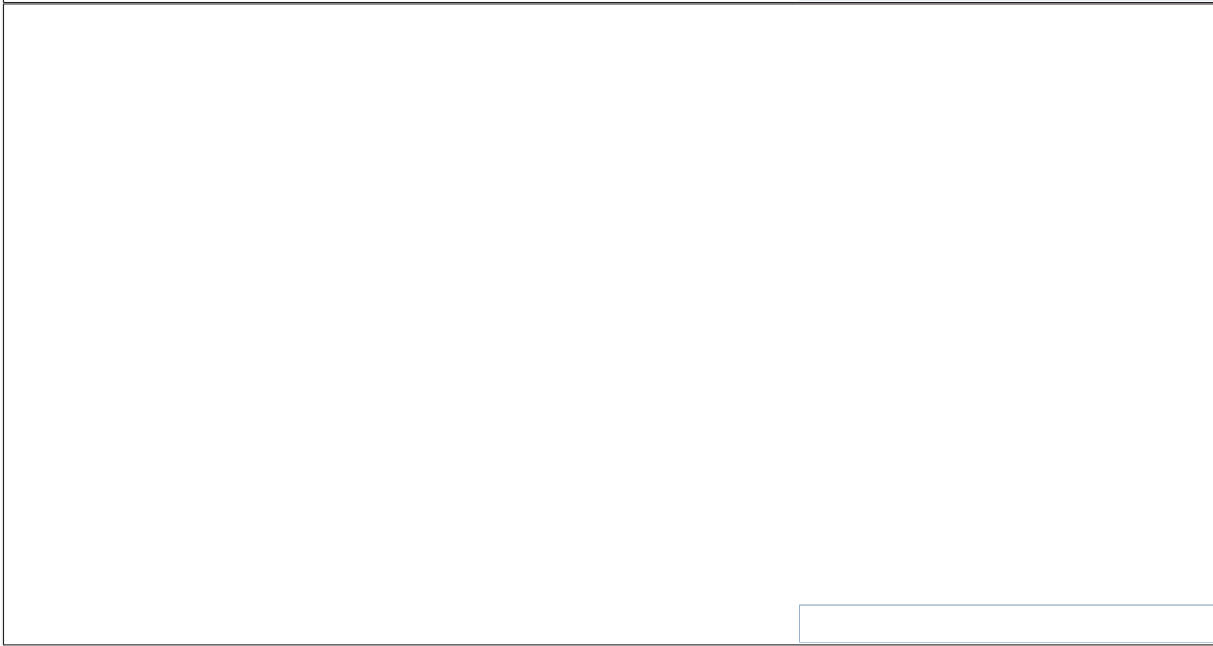
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20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-26

REPORT NO. / RAPPORT NR.  
10031-23-MP-14

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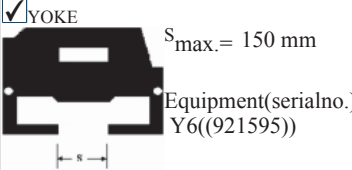




NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Mats K. Skjong</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-15</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P12A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetspulverprøving

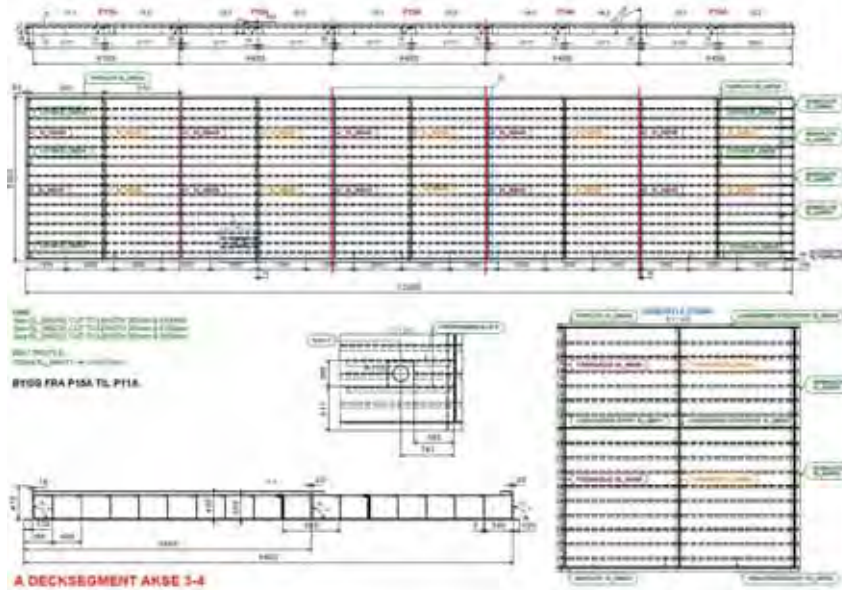
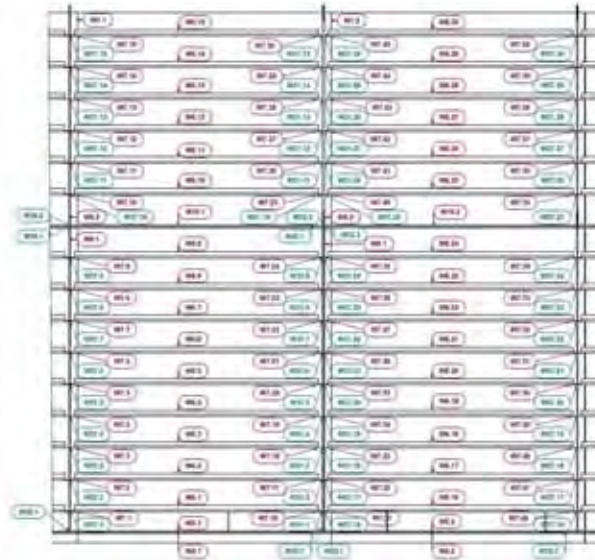
CLIENT / KUNDE  
Prodex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-30

REPORT NO. / RAPPORT NR.  
10031-23-MP-15

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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-15</b>	PAGE / SIDE <b>3 of av 4</b>
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Welding no.	Date	Fillet on Batch no.	ET Material	Wc	IT	MT Pt.	VT
W11				1	100%	100%	100%
W12				1	100%	100%	100%
W13				1	100%	100%	100%
W14				1	100%	100%	100%
W15				1	100%	100%	100%
W16				1	100%	100%	100%
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# Magnetic testing Magnetpulverprøving

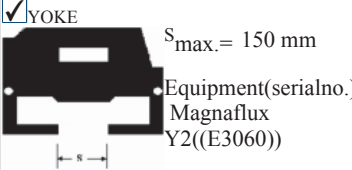
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

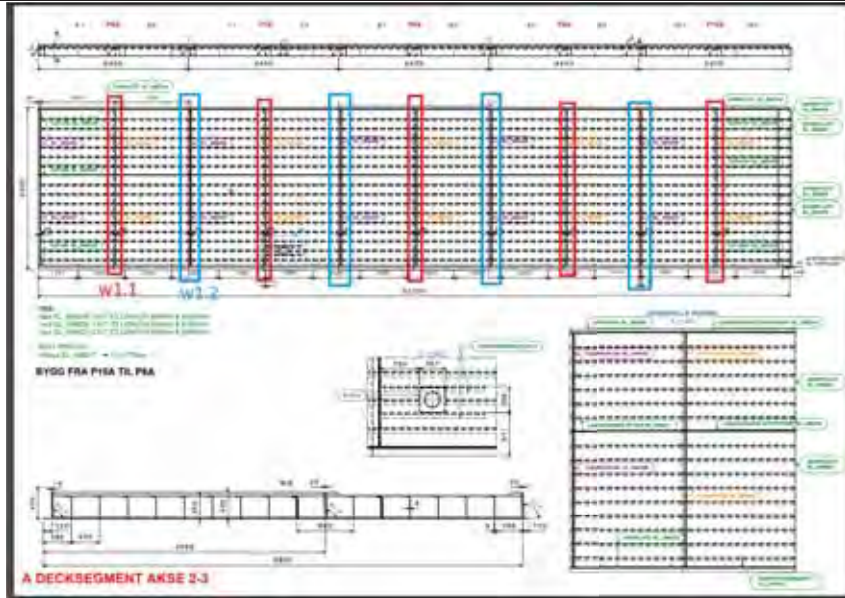
CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-17</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld w1.1\w1.2 and HAZ AKSE 2-3 A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y</b>	WELDING PROCESS / SVEISEPROSESS <b>135 Laser hybrid</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Magnaflux Y2((E3060))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>13</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-17</b>	PAGE / SIDE <b>2 of/av 2</b>
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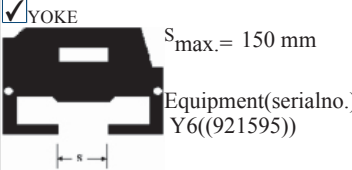


NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2296-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2296-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-19 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-06-19 <i>Doru Baciu</i>





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-24</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P18A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>After repairs fulfill requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

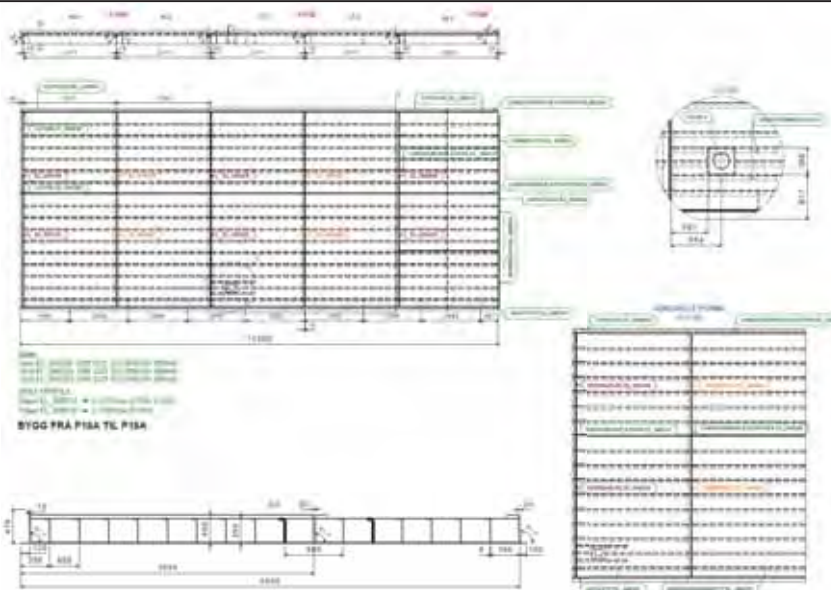
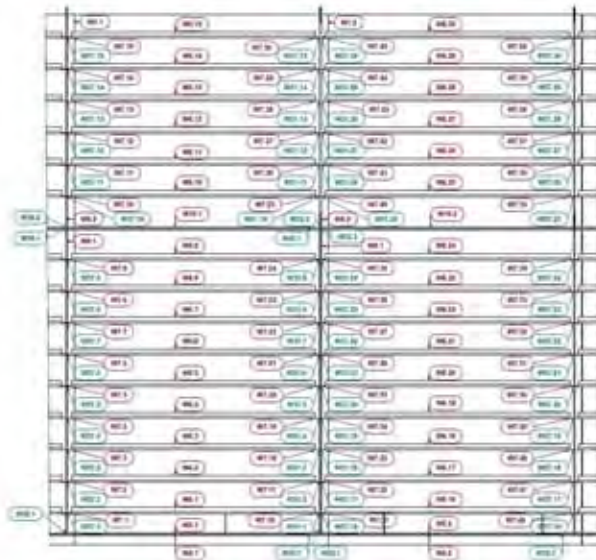
CLIENT / KUNDE  
**Prodtex industri as**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-06-17**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-24**

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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-24</b>	PAGE / SIDE <b>3 of/av 4</b>
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4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& bottom pl
W1.2	100%	100%	100%	LH, BW top& bottom pl
W4.1	-	100%	100%	R&LH, FW, side pl. h
W4.2	-	100%	100%	R&LH, FW h, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH&R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH&R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH&R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH&R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH&R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH&R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH&R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH&R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH&R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH&R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH&R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH&R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH&R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH&R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH&R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH&R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH&R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH&R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH&R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH&R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH&R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH&R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH&R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH&R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH&R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH&R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH&R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH&R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH&R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH&R, FW L profile
W9.1	-	20%	100%	R, Fillet, Tr - stop pl
W9.2	-	20%	100%	R, Fillet, Tr - stop pl
W9.1	-	20%	100%	LH, Fillet, Tr - stop pl
W9.2	-	20%	100%	LH, Fillet, Tr - stop pl

W9.2	-	20%	100%	LH, Fillet, Tr - stop pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, trinside
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, trinside
W39.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-24</b>	PAGE / SIDE <b>4 of/av 4</b>
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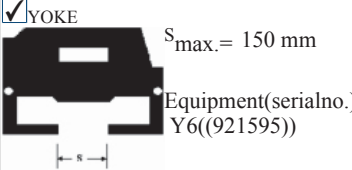
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-25</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P17A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>		FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>	
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

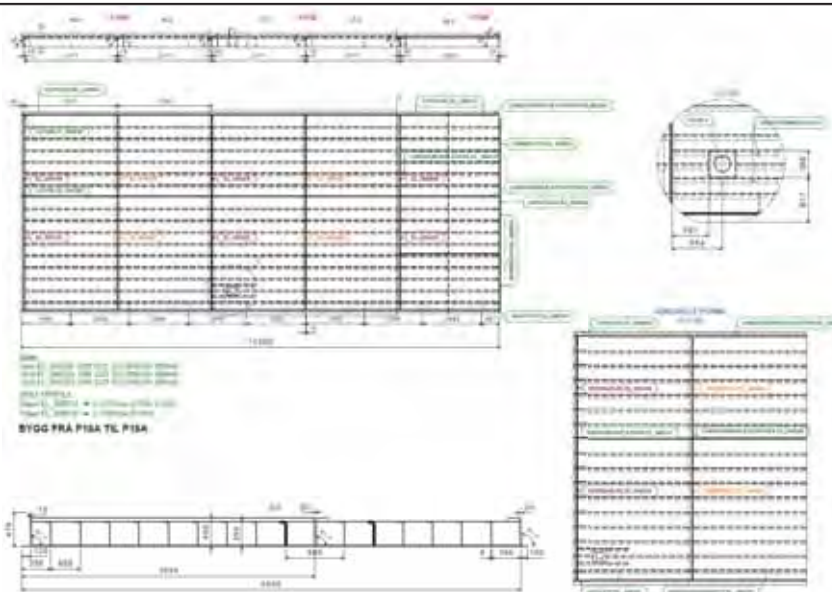
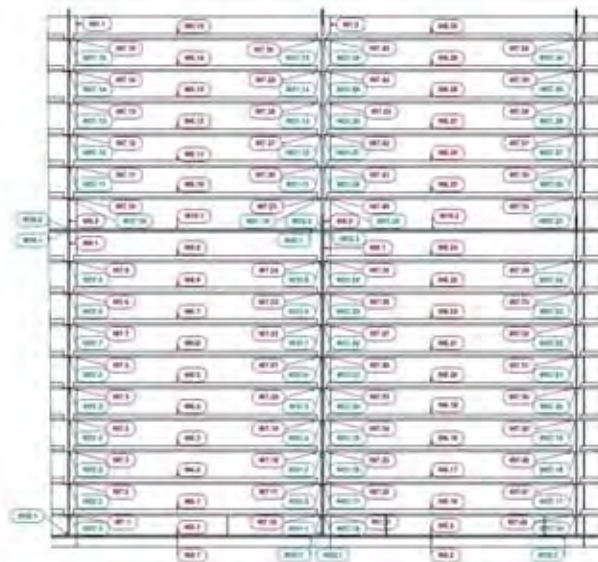
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-19

REPORT NO. / RAPPORT NR.  
10031-23-MP-25

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2 of/av 4





# Magnetic testing Magnepulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-25</b>	PAGE / SIDE <b>3 of/av 4</b>
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4.4.1 NDT-table  
Ref. NS-EN 1090-2 Annex L, Table L2  
For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B.

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& top pl
W1.2	100%	100%	100%	LH, BW top& top pl
W4.1	-	100%	100%	R&LH, FW, side pl. h
W4.2	-	100%	100%	R&LH, FW h, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH&R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH&R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH&R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH&R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH&R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH&R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH&R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH&R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH&R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH&R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH&R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH&R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH&R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH&R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH&R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH&R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH&R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH&R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH&R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH&R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH&R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH&R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH&R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH&R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH&R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH&R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH&R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH&R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH&R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH&R, FW L profile
W9.1	-	20%	100%	R, Fillet, Tr -top pl
W9.2	-	20%	100%	R, Fillet, Tr -top pl
W9.1	-	20%	100%	LH, Fillet, Tr -top pl
W9.2	-	20%	100%	LH, Fillet, Tr -top pl

W9.2	-	20%	100%	LH, Fillet, Tr -top pl
W10.1	-	100%	100%	LH, Fillet, Long, pl
W10.2	-	100%	100%	LH, Fillet, Long, pl
W10.3	-	100%	100%	LH, Fillet, Long, pl
W10.4	-	100%	100%	LH, Fillet, Long, pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr,side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr,side
W39.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long, pl
W55.1, W55.2	100%	100%	100%	BW, side, pl
<b>Bottom plate Welds</b>				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-25</b>	PAGE / SIDE <b>4 of/av 4</b>
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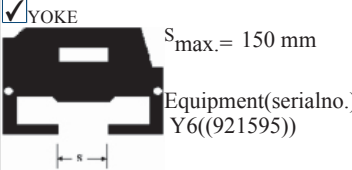
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-26</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P16A) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

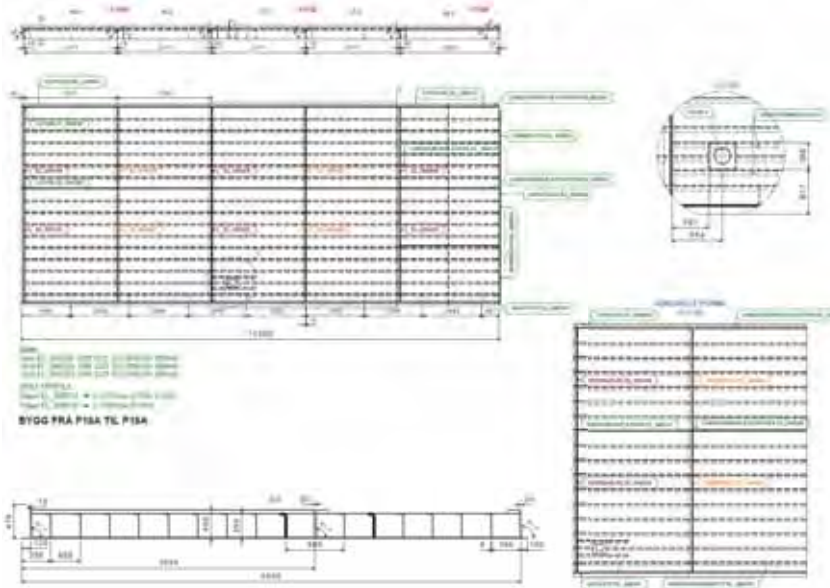
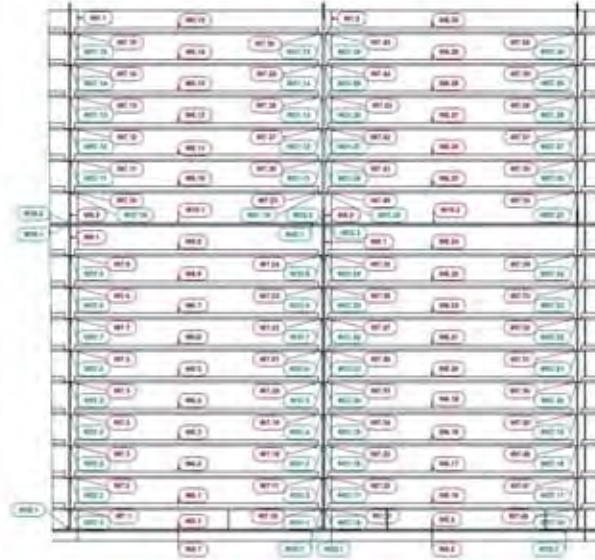
CLIENT / KUNDE  
Prodtext industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-19

REPORT NO. / RAPPORT NR.  
10031-23-MP-26

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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-26</b>	PAGE / SIDE <b>3 of/av 4</b>
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Bottom-plate description: Plate to bottom top from two plates. Plate 1 and Plate 2

#### 4.4.1 NDT-table

Ref. NS-EN 1090-2 Annex L, Table L2

For each sandwich panel separate, all the welds are to be checked according to the following tables for Side A and Side B:

Side A deck Section weld no.	UT	MT/PT	VT	Weld Details
W1.1	100%	100%	100%	LH, BW top& bottom pl
W1.2	100%	100%	100%	LH, BW top& bottom pl
W4.1	-	100%	100%	R&LH, FW, side pl. h
W4.2	-	100%	100%	R&LH, FW h, side pl. h
W7.1, W6.1, W7.16	-	20%	100%	LH&R, FW L profile
W7.2, W6.2, W7.17	-	20%	100%	LH&R, FW L profile
W7.3, W6.3, W7.18	-	20%	100%	LH&R, FW L profile
W7.4, W6.4, W7.19	-	20%	100%	LH&R, FW L profile
W7.5, W6.5, W7.20	-	20%	100%	LH&R, FW L profile
W7.6, W6.6, W7.21	-	20%	100%	LH&R, FW L profile
W7.7, W6.7, W7.22	-	20%	100%	LH&R, FW L profile
W7.8, W6.8, W7.23	-	20%	100%	LH&R, FW L profile
W7.9, W6.9, W7.24	-	20%	100%	LH&R, FW L profile
W7.10, W6.10, W7.25	-	20%	100%	LH&R, FW L profile
W7.11, W6.11, W7.26	-	20%	100%	LH&R, FW L profile
W7.12, W6.12, W7.27	-	20%	100%	LH&R, FW L profile
W7.13, W6.13, W7.28	-	20%	100%	LH&R, FW L profile
W7.14, W6.14, W7.29	-	20%	100%	LH&R, FW L profile
W7.15, W6.15, W7.30	-	20%	100%	LH&R, FW L profile
W7.31, W6.16, W7.46	-	20%	100%	LH&R, FW L profile
W7.32, W6.17, W7.47	-	20%	100%	LH&R, FW L profile
W7.33, W6.18, W7.48	-	20%	100%	LH&R, FW L profile
W7.34, W6.19, W7.49	-	20%	100%	LH&R, FW L profile
W7.35, W6.20, W7.50	-	20%	100%	LH&R, FW L profile
W7.36, W6.21, W7.51	-	20%	100%	LH&R, FW L profile
W7.37, W6.22, W7.52	-	20%	100%	LH&R, FW L profile
W7.38, W6.23, W7.53	-	20%	100%	LH&R, FW L profile
W7.39, W6.24, W7.54	-	20%	100%	LH&R, FW L profile
W7.40, W6.25, W7.55	-	20%	100%	LH&R, FW L profile
W7.41, W6.26, W7.56	-	20%	100%	LH&R, FW L profile
W7.42, W6.27, W7.57	-	20%	100%	LH&R, FW L profile
W7.43, W6.28, W7.58	-	20%	100%	LH&R, FW L profile
W7.44, W6.29, W7.59	-	20%	100%	LH&R, FW L profile
W7.45, W6.30, W7.60	-	20%	100%	LH&R, FW L profile
W9.1	-	20%	100%	R, Fillet, Tr -top pl
W9.2	-	20%	100%	R, Fillet, Tr -top pl
W9.1	-	20%	100%	LH, Fillet, Tr -top pl
W9.2	-	20%	100%	LH, Fillet, Tr -top pl

W9.2	-	20%	100%	LH, Fillet, Tr -top pl
W10.1	-	100%	100%	LH, Fillet, Long pl
W10.2	-	100%	100%	LH, Fillet, Long pl
W10.3	-	100%	100%	LH, Fillet, Long pl
W10.4	-	100%	100%	LH, Fillet, Long pl
W57.1, W31.1, W31.16, W57.16	-	20%	100%	R, FW vertical
W57.2, W31.2, W31.17, W57.17	-	20%	100%	R, FW vertical
W57.3, W31.3, W31.18, W57.18	-	20%	100%	R, FW vertical
W57.4, W31.4, W31.19, W57.19	-	20%	100%	R, FW vertical
W57.5, W31.5, W31.20, W57.20	-	20%	100%	R, FW vertical
W57.6, W31.6, W31.21, W57.21	-	20%	100%	R, FW vertical
W57.7, W31.7, W31.22, W57.22	-	20%	100%	R, FW vertical
W57.8, W31.8, W31.23, W57.23	-	20%	100%	R, FW vertical
W57.9, W31.9, W31.24, W57.24	-	20%	100%	R, FW vertical
W57.10, W31.10, W31.25, W57.25	-	20%	100%	R, FW vertical
W57.11, W31.11, W31.26, W57.26	-	20%	100%	R, FW vertical
W57.12, W31.12, W31.27, W57.27	-	20%	100%	R, FW vertical
W57.13, W31.13, W31.28, W57.28	-	20%	100%	R, FW vertical
W57.14, W31.14, W31.29, W57.29	-	20%	100%	R, FW vertical
W57.15, W31.15, W31.30, W57.30	-	20%	100%	R, FW vertical
W39.1, W32.1	-	20%	100%	R, fillet vert, tr-side
W39.2, W39.3, W32.2, W32.3	50%	100%	100%	R, fillet vert, tr-long
W39.1, W30.1	-	20%	100%	R, fillet vertical, side
W52.1, W52.2	100%	100%	100%	BW, long pl
W55.1, W55.2	100%	100%	100%	BW, side pl
Bottom plate Welds				
W12.1, W12.2	-	10%	100%	Laser Lap welds
W13.15, W13.30	-	10%	100%	Laser Lap welds
W13.14, W13.29	-	10%	100%	Laser Lap welds
W13.13, W13.28	-	10%	100%	Laser Lap welds
W13.12, W13.27	-	10%	100%	Laser Lap welds
W13.11, W13.26	-	10%	100%	Laser Lap welds
W13.10, W13.25	-	10%	100%	Laser Lap welds
W13.9, W13.24	-	10%	100%	Laser Lap welds
W13.8, W13.23	-	10%	100%	Laser Lap welds
W13.7, W13.22	-	10%	100%	Laser Lap welds
W13.6, W13.21	-	10%	100%	Laser Lap welds
W13.5, W13.20	-	10%	100%	Laser Lap welds
W13.4, W13.19	-	10%	100%	Laser Lap welds
W13.3, W13.18	-	10%	100%	Laser Lap welds
W13.2, W13.17	-	10%	100%	Laser Lap welds
W13.1, W13.16	-	10%	100%	Laser Lap welds
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-26</b>	PAGE / SIDE <b>4 of/av 4</b>
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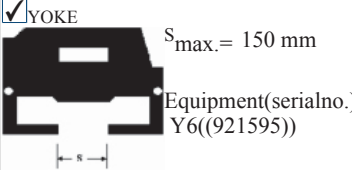
W14.1, W14.4	-	10%	100%	Laser Lap welds
W14.2, W14.3, W14.5, W14.6	-	10%	100%	Laser Lap welds
W15.1, W15.2, W15.3, W15.4	-	10%	100%	Laser Lap welds
W16.1, W16.2, W16.3, W16.4	-	10%	100%	Laser Lap welds



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-15 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-07-15 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-05</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-29</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of weld w1.1\w1.2 and HAZ at A decksegment AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE				CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-05</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-29</b>	PAGE / SIDE <b>2 of/av 2</b>
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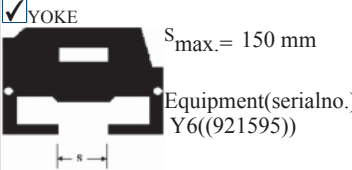


NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-17 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-07-17 <i>Aleksander Haahjem</i>





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-16</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section A (P11A) AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

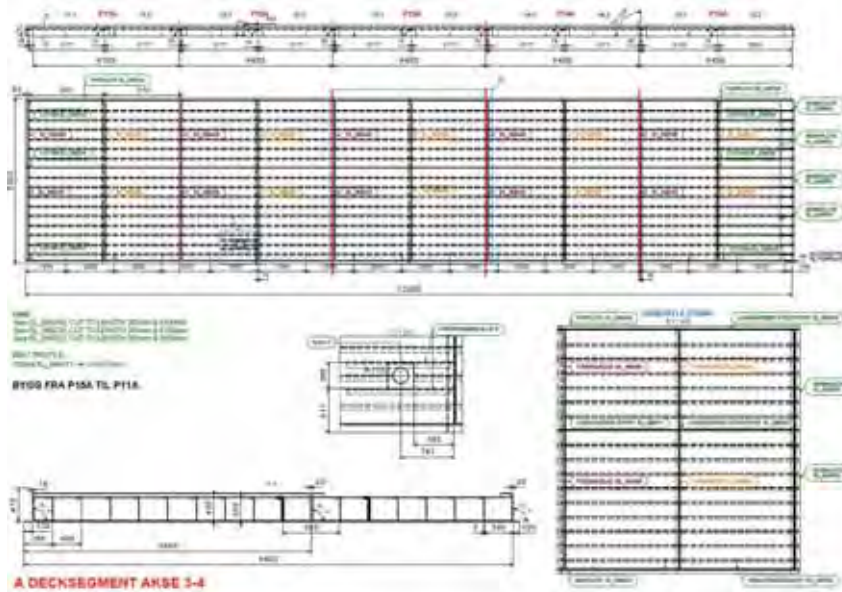
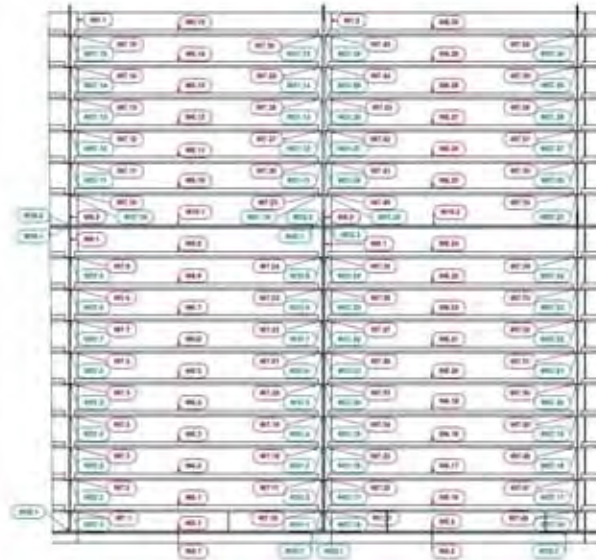
CLIENT / KUNDE  
Prodex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-05-31

REPORT NO. / RAPPORT NR.  
10031-23-MP-16

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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-16</b>	PAGE / SIDE <b>3 of av 4</b>
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Welding no.	Date	Filter on batch no.	ET Magnetic	Wc	St	MT PT	V1
W11				1	100%	100%	100%
W12				1	100%	100%	100%
W13				1	100%	100%	100%
W14				1	100%	100%	100%
W15				1	100%	100%	100%
W16				1	100%	100%	100%
W17				1	100%	100%	100%
W18				1	100%	100%	100%
W19				1	100%	100%	100%
W20				1	100%	100%	100%
W21				1	100%	100%	100%
W22				1	100%	100%	100%
W23				1	100%	100%	100%
W24				1	100%	100%	100%
W25				1	100%	100%	100%
W26				1	100%	100%	100%
W27				1	100%	100%	100%
W28				1	100%	100%	100%
W29				1	100%	100%	100%
W30				1	100%	100%	100%
W31				1	100%	100%	100%
W32				1	100%	100%	100%
W33				1	100%	100%	100%
W34				1	100%	100%	100%
W35				1	100%	100%	100%
W36				1	100%	100%	100%
W37				1	100%	100%	100%
W38				1	100%	100%	100%
W39				1	100%	100%	100%
W40				1	100%	100%	100%
W41				1	100%	100%	100%
W42				1	100%	100%	100%
W43				1	100%	100%	100%
W44				1	100%	100%	100%
W45				1	100%	100%	100%
W46				1	100%	100%	100%
W47				1	100%	100%	100%
W48				1	100%	100%	100%
W49				1	100%	100%	100%
W50				1	100%	100%	100%
W51				1	100%	100%	100%
W52				1	100%	100%	100%
W53				1	100%	100%	100%
W54				1	100%	100%	100%
W55				1	100%	100%	100%
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W59				1	100%	100%	100%
W60				1	100%	100%	100%
W61				1	100%	100%	100%
W62				1	100%	100%	100%
W63				1	100%	100%	100%
W64				1	100%	100%	100%
W65				1	100%	100%	100%
W66				1	100%	100%	100%
W67				1	100%	100%	100%
W68				1	100%	100%	100%
W69				1	100%	100%	100%
W70				1	100%	100%	100%
W71				1	100%	100%	100%
W72				1	100%	100%	100%
W73				1	100%	100%	100%
W74				1	100%	100%	100%
W75				1	100%	100%	100%
W76				1	100%	100%	100%
W77				1	100%	100%	100%
W78				1	100%	100%	100%
W79				1	100%	100%	100%
W80				1	100%	100%	100%
W81				1	100%	100%	100%
W82				1	100%	100%	100%
W83				1	100%	100%	100%
W84				1	100%	100%	100%
W85				1	100%	100%	100%
W86				1	100%	100%	100%
W87				1	100%	100%	100%
W88				1	100%	100%	100%
W89				1	100%	100%	100%
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W96				1	100%	100%	100%
W97				1	100%	100%	100%
W98				1	100%	100%	100%
W99				1	100%	100%	100%
W100				1	100%	100%	100%

W101				1	100%	100%	100%
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W103				1	100%	100%	100%
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W105				1	100%	100%	100%
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W127				1	100%	100%	100%
W128				1	100%	100%	100%
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W196				1	100%	100%	100%
W197				1	100%	100%	100%
W198				1	100%	100%	100%
W199				1	100%	100%	100%
W200				1	100%	100%	100%



# Magnetic testing Magnetpulverprøving

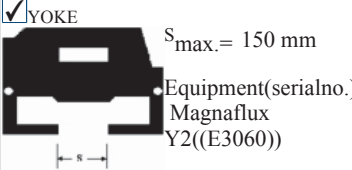
CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-16</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-06-08 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-06-08 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-30</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of weld P15A w1.2 and P14A w1.1 and HAZ at A decksegment AKSE 3-4 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE 	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-30</b>	PAGE / SIDE <b>2 of/av 2</b>
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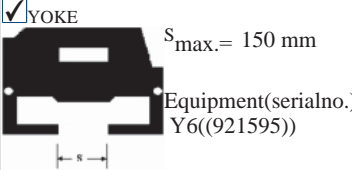
**A DECKSEGMENT AKSE 3-4**



NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2296-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2296-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-17 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-07-17 <i>Doru Baci</i>



# Magnetic testing Magnetpulverprøving

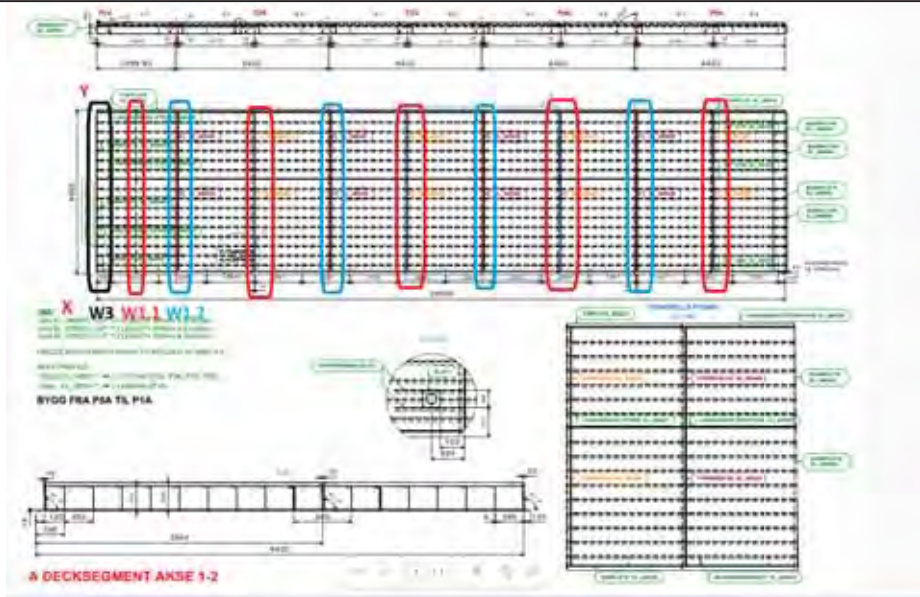
CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-31-REV1</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ welds w1.1 and w1.2 Deck section A AKSE 1-2 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135 + 52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE				CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

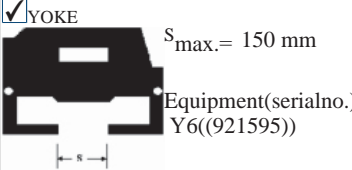
CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-31-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-09-15 Approved / Godkjent <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-09-15 <i>Mats K. Skjong</i>



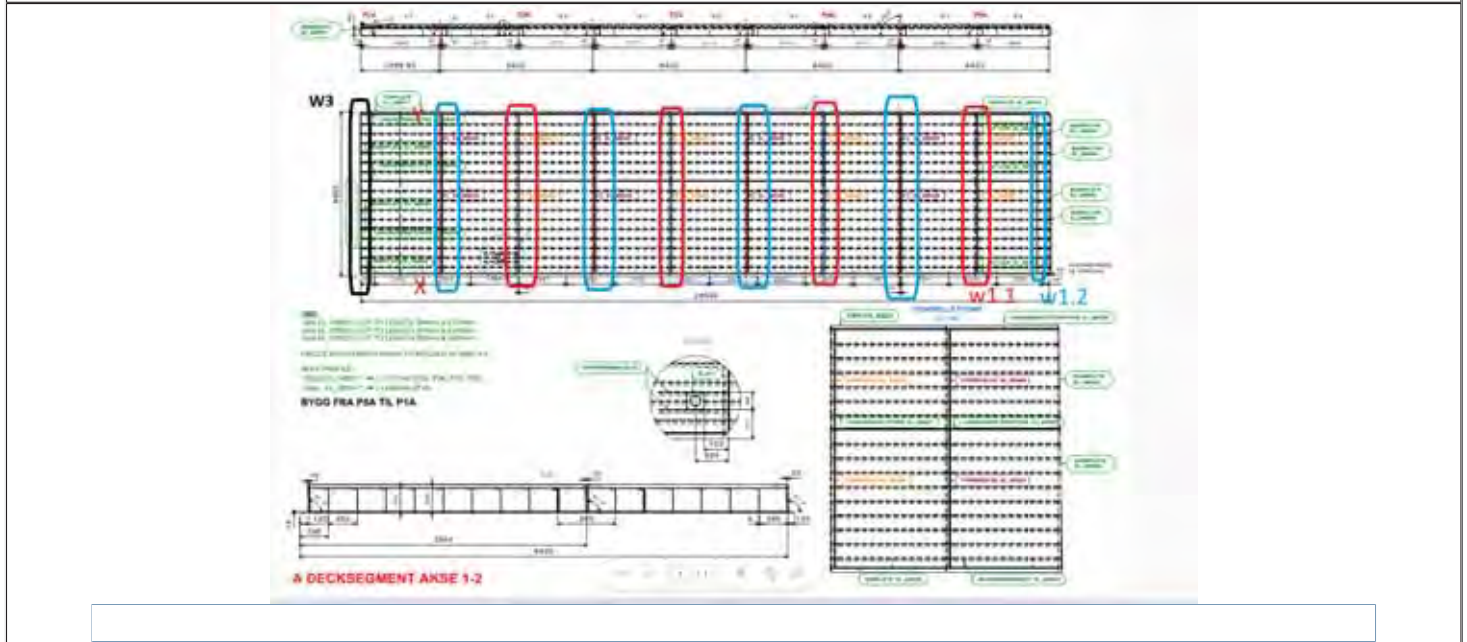
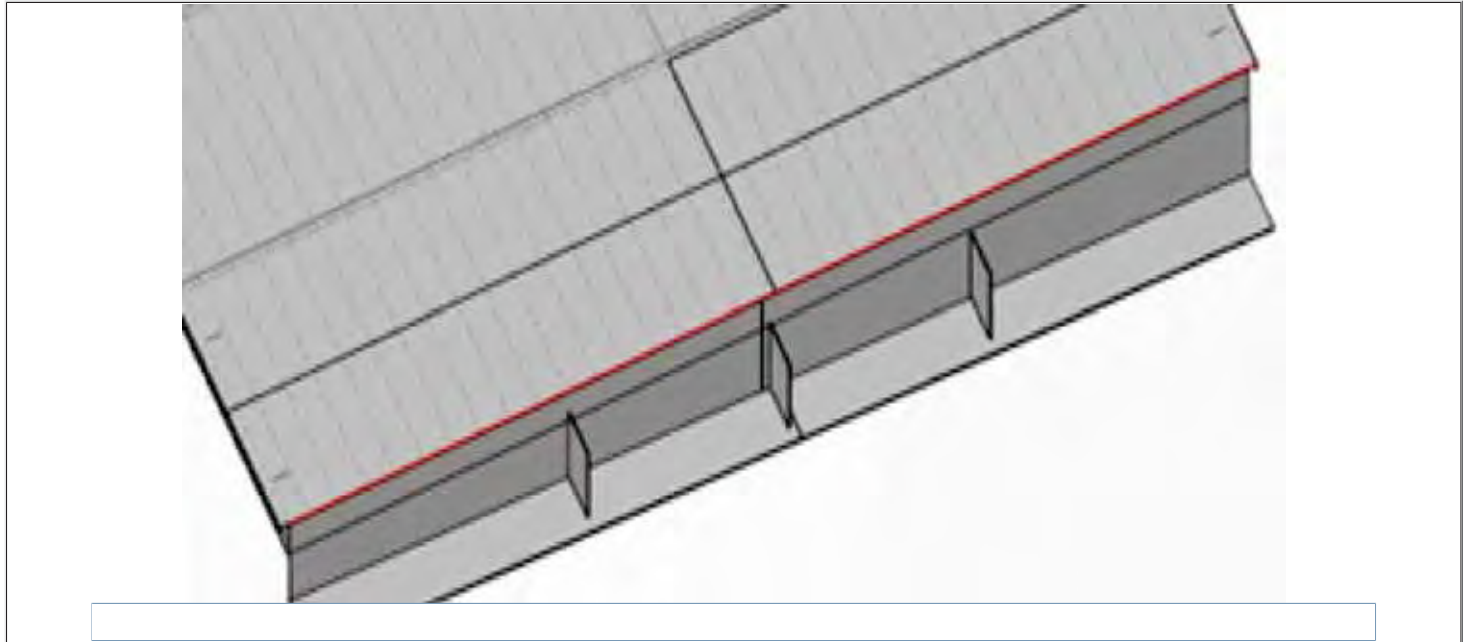
**Magnetic testing**  
**Magnetspulverprøving**

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-58</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ weld w3</b> <b>Deck section A AKSE 1-2</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) <b>Y6((921595))</b>	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>		FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>	
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

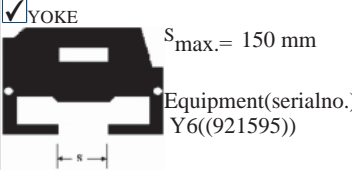
CLIENT / KUNDE Prodex industri as	CLIENT O.NO / KUNDE O.NR 20021 - Elverhoy	DATE OF TESTING / KONTROLLDATO 2023-06-19	REPORT NO. / RAPPORT NR. 10031-23-MP-58	PAGE / SIDE 2 of/av 2
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-09-15 Approved / Godkjent <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-09-15 <i>Mats K. Skjong</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-19</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-59-REV1</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ weldsw1.1, w1.2, w3 Deck section A AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135 + 52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE				CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

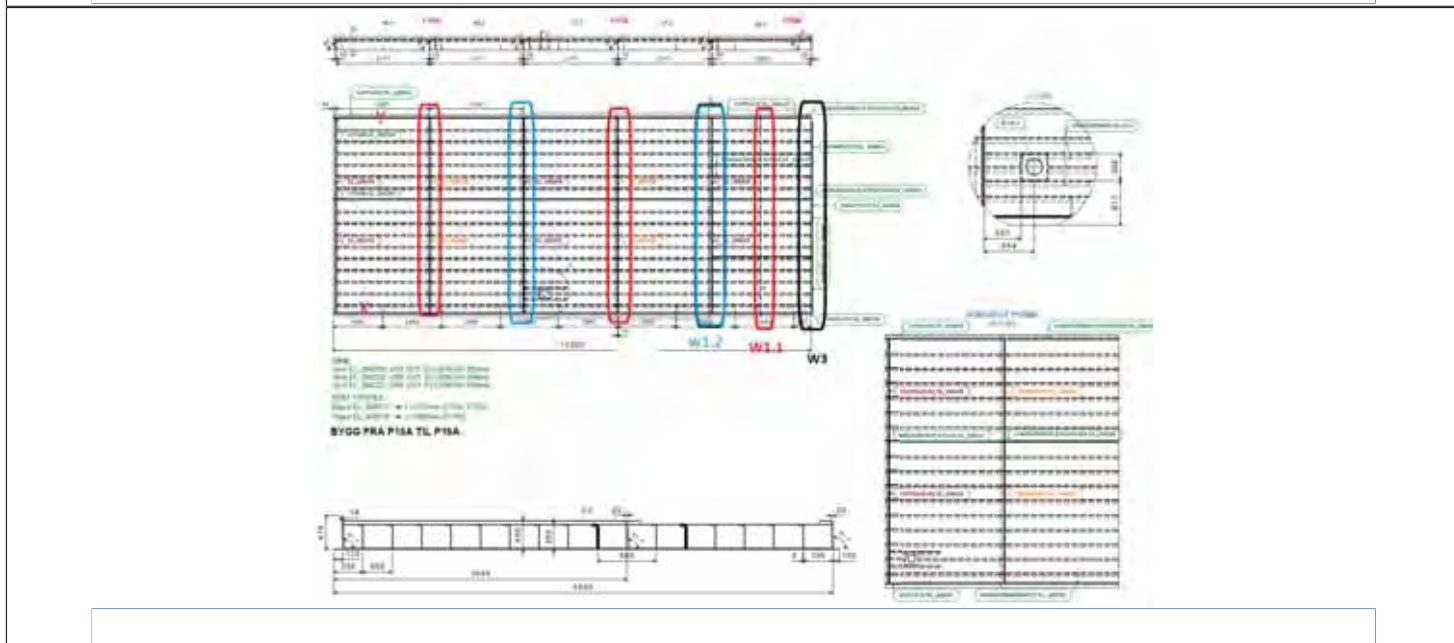
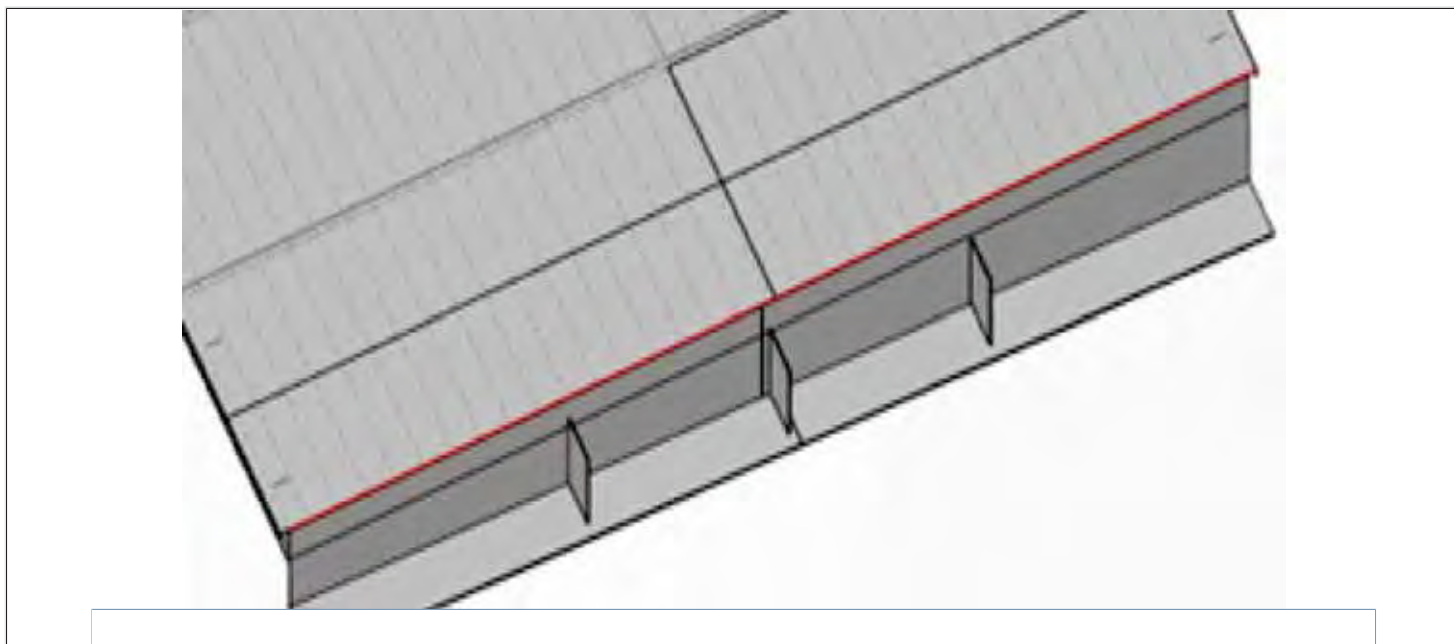
CLIENT / KUNDE  
Prodtex industri as

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-19

REPORT NO. / RAPPORT NR.  
10031-23-MP-59-REV1

PAGE / SIDE  
2 of/av 2



NAME CERT. NO. / NAVN SERT. NR.  
()

N2 NAME CERT. NO. / N2 NAVN SERT. NR.  
Mats Kristoffer Skjong (18369-N2-M)

OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR.  
Mats Kristoffer Skjong (18369-N2-M)

APPROVED / GODKJENT DATO:

APPROVED / GODKJENT DATO:2023-09-15

OPERATOR / OPERATØR DATO:2023-09-15

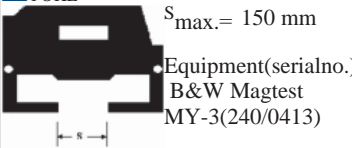
Approved / Godkjent  
*Mats K. Skjong*

*Mats K. Skjong*





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-60-REV1</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, magnetic testing of weld and HAZ AKSE 2-3 A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment (serial no.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

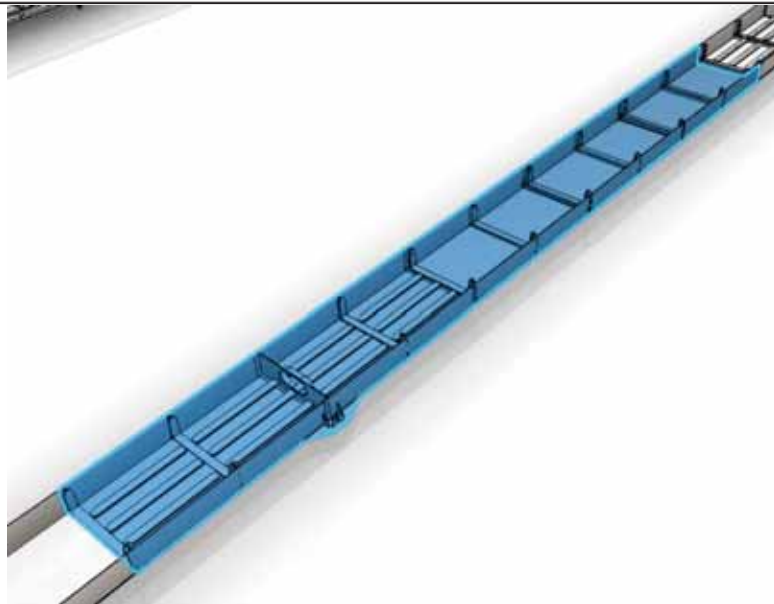
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-15**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-60-REV1**

PAGE / SIDE  
**2 of/av 3**







# Magnetic testing Magnetspulverprøving

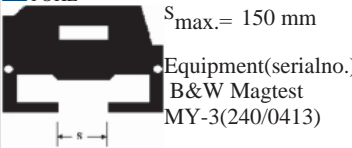
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-60-REV1</b>	PAGE / SIDE <b>3 of/av 3</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT		
W18,	100%	100%	100%			W42.3	100%	100%	100%		
W20,	100%	5%	100%			W42.4	100%	100%	100%		
W21,						W42.5	100%	100%	100%		
W22,	100%	100%	100%			W42.6	100%	100%	100%		
W23.1,	100%	20%	100%			W42.7	100%	100%	100%		
W23.2						W42.8	100%	100%	100%		
W27.1,						W53.1		20%	100%		
W27.2,						W53.2		20%	100%		
W27.3,	100%	5%	100%			W53.3		20%	100%		
W27.4,						W53.4		20%	100%		
W27.5,						W53.5		20%	100%		
W27.6						W53.6		20%	100%		
W42	100%	100%	100%			W71.1	-	100%	100%		
W19	100%	20%	100%								
W47	100%	100%	100%								
W24	100%	20%	100%								
W34	20%	100%	100%								
W43,											
W44,		20%	100%								
W45,											
W50											

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindii (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindii (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindii</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindii</i>



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-21</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-61-REV1</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, magnetic testing of weld and HAZ AKSE 3-4 A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment (serial no.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

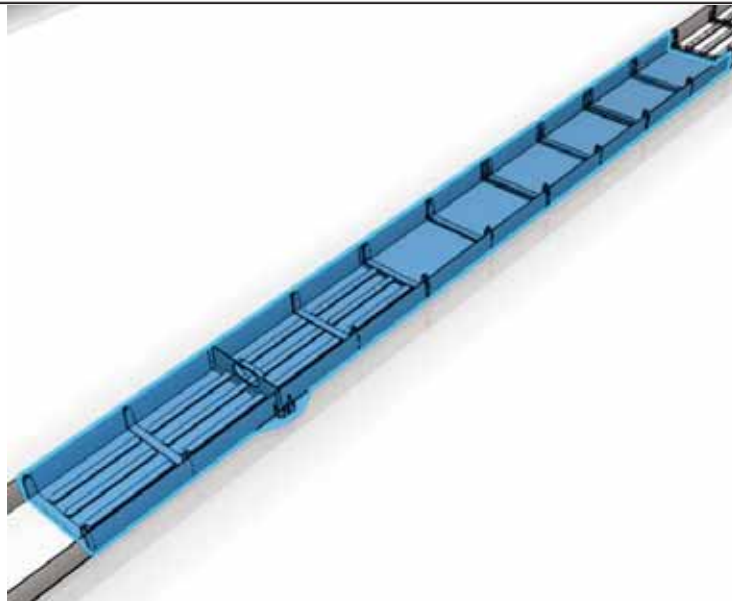
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-21**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-61-REV1**

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# Magnetic testing Magnetspulverprøving


CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-21</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-61-REV1</b>	PAGE / SIDE <b>3 of/av 3</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT		
W18,	100%	100%	100%			W42.3	100%	100%	100%		
W20,	100%	5%	100%			W42.4	100%	100%	100%		
W21,						W42.5	100%	100%	100%		
W22,	100%	100%	100%			W42.6	100%	100%	100%		
W23.1,	100%	20%	100%			W42.7	100%	100%	100%		
W23.2						W42.8	100%	100%	100%		
W27.1,						W53.1		20%	100%		
W27.2,						W53.2		20%	100%		
W27.3,	100%	5%	100%			W53.3		20%	100%		
W27.4,						W53.4		20%	100%		
W27.5,						W53.5		20%	100%		
W27.6						W53.6		20%	100%		
W42	100%	100%	100%			W71.1	-	100%	100%		
W19	100%	20%	100%								
W47	100%	100%	100%								
W24	100%	20%	100%								
W34	20%	100%	100%								
W43,											
W44,		20%	100%								
W45,											
W50											

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiu (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiu (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindiu</i>



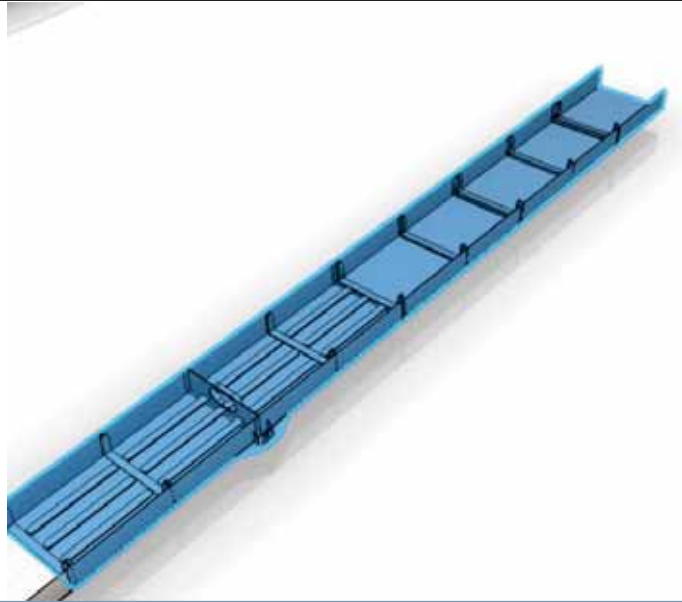
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-62-REV1</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, magnetic testing of weld and HAZ AKSE 1-2A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-62-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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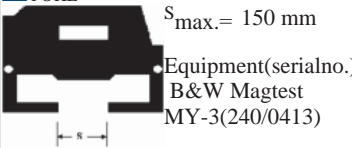


weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%			W42.7	100%	100%	100%
W23.2,						W42.8	100%	100%	100%
W27.1,						W53.1		20%	100%
W27.2,						W53.2		20%	100%
W27.3,	100%	5%	100%			W53.3		20%	100%
W27.4,						W53.4		20%	100%
W27.5,						W53.5		20%	100%
W27.6,						W53.6		20%	100%
W42	100%	100%	100%			W71.1	-	100%	100%
W19	100%	20%	100%						
W47	100%	100%	100%						
W24	100%	20%	100%						
W34	20%	100%	100%						
W43,									
W44,		20%	100%						
W45,									
W50									

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindu (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindu (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindu</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindu</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-63-REV1</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, magnetic testing of weld and HAZ AKSE 4-5 A Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment (serial no.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

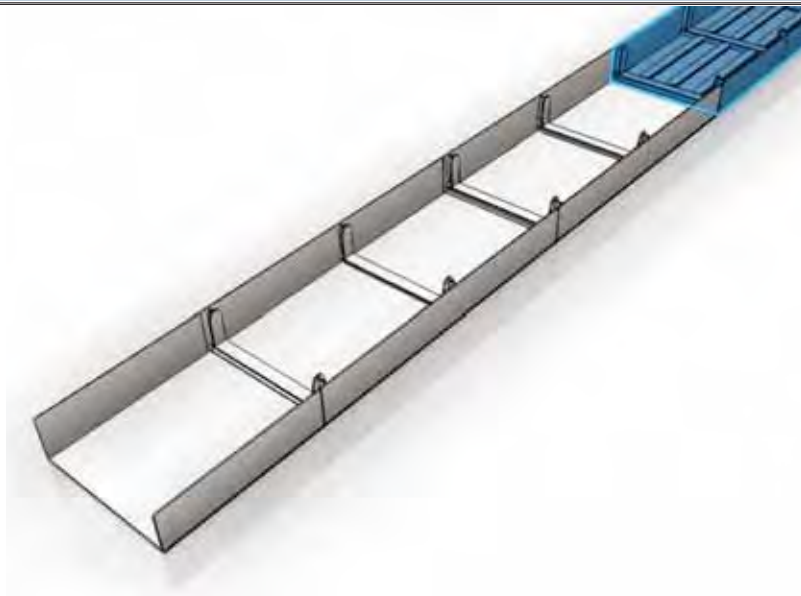
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-23**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-63-REV1**

PAGE / SIDE  
**2 of/av 3**





**Magnetic testing**  
**Magnetspulverprøving**

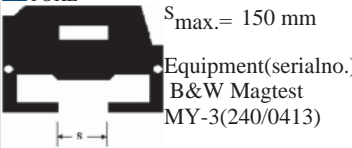
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-63-REV1</b>	PAGE / SIDE <b>3 of/av 3</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%						
W23.2									
W27.1,									
W27.2,									
W27.3,	100%	5%	100%			W42.7	100%	100%	100%
W27.4,									
W27.5,									
W27.6									
W42	100%	100%	100%			W42.8	100%	100%	100%
W19	100%	20%	100%			W53.1		20%	100%
W47	100%	100%	100%			W53.2		20%	100%
W24	100%	20%	100%			W53.3		20%	100%
						W53.4		20%	100%
W34	20%	100%	100%			W53.5		20%	100%
W43,						W53.6		20%	100%
W44,		20%	100%						
W45,									
W50									
						W71.1	-	100%	100%

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiū (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiū (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindiū</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindiū</i>



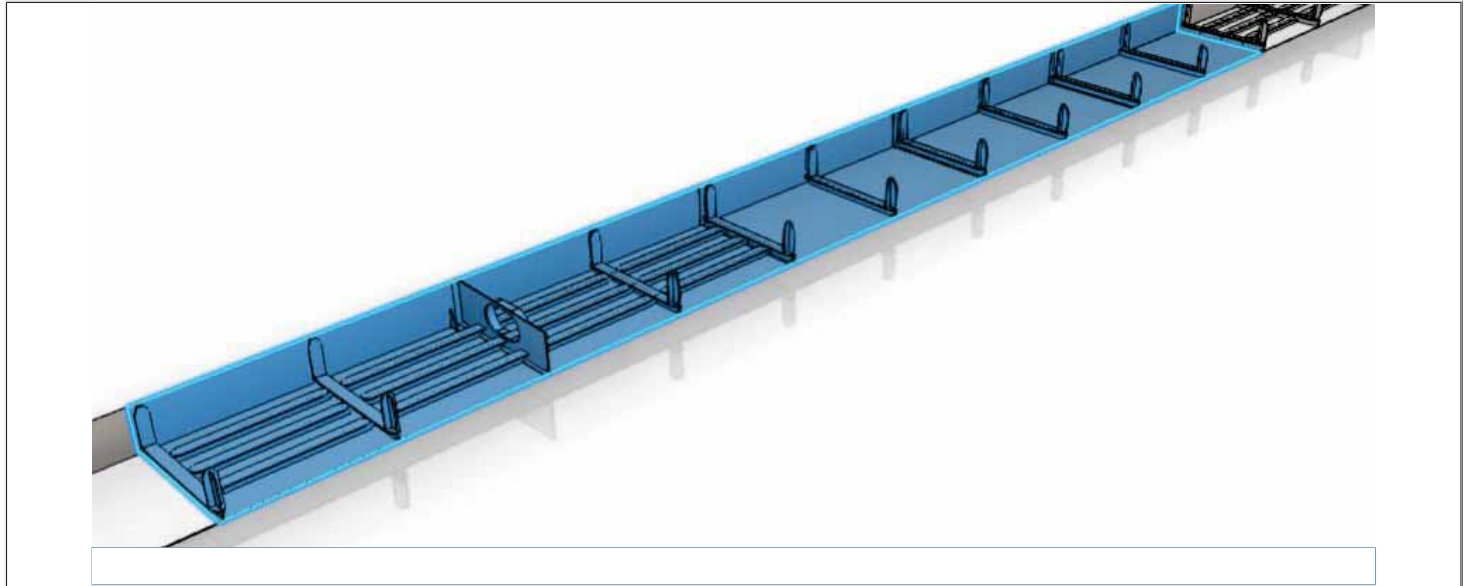
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-28</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-64-REV1</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, magnetic testing of weld and HAZ AKSE 2-3 B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment (serial no.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-28</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-64-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20, W21,	100%	5%	100%			W42.4	100%	100%	100%
W22,	100%	100%	100%			W42.5	100%	100%	100%
W23.1, W23.2	100%	20%	100%			W42.6	100%	100%	100%
W27.1, W27.2, W27.3, W27.4, W27.5, W27.6	100%	5%	100%			W42.7	100%	100%	100%
W42	100%	100%	100%			W42.8	100%	100%	100%
W19	100%	20%	100%			W53.1		20%	100%
W47	100%	100%	100%			W53.2		20%	100%
W24	100%	20%	100%			W53.3		20%	100%
						W53.4		20%	100%
W34	20%	100%	100%			W53.5		20%	100%
W43, W44, W45, W50		20%	100%			W53.6		20%	100%
						W71.1	-	100%	100%

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Ramona Bindi (456-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Ramona Bindi (456-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindi</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindi</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-29</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-65-REV1</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam ,magnetic testing of weld and HAZ AKSE 3-4B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup>Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

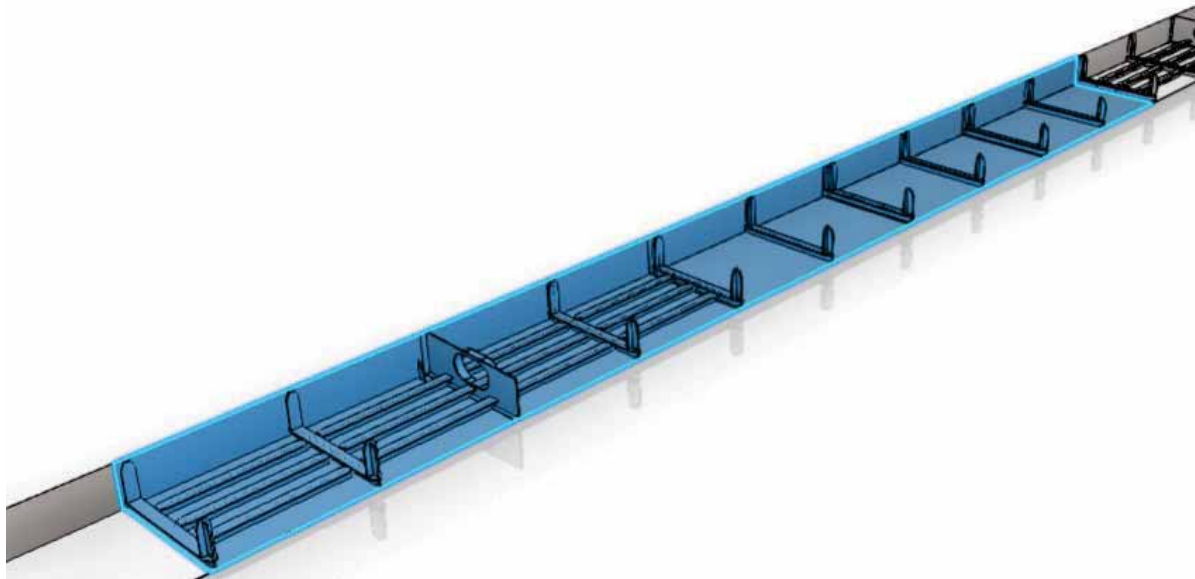
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-29**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-65-REV1**

PAGE / SIDE  
**2 of/av 3**





# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-29</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-65-REV1</b>	PAGE / SIDE <b>3 of/av 3</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT		
W18,	100%	100%	100%			W42.3	100%	100%	100%		
W20,	100%	5%	100%			W42.4	100%	100%	100%		
W21,						W42.5	100%	100%	100%		
W22,	100%	100%	100%			W42.6	100%	100%	100%		
W23.1,	100%	20%	100%			W42.7	100%	100%	100%		
W23.2						W42.8	100%	100%	100%		
W27.1,						W53.1		20%	100%		
W27.2,						W53.2		20%	100%		
W27.3,	100%	5%	100%			W53.3		20%	100%		
W27.4,						W53.4		20%	100%		
W27.5,						W53.5		20%	100%		
W27.6						W53.6		20%	100%		
W42	100%	100%	100%			W71.1	-	100%	100%		
W19	100%	20%	100%								
W47	100%	100%	100%								
W24	100%	20%	100%								
W34	20%	100%	100%								
W43,											
W44,		20%	100%								
W45,											
W50											

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiu (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiu (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindiu</i>





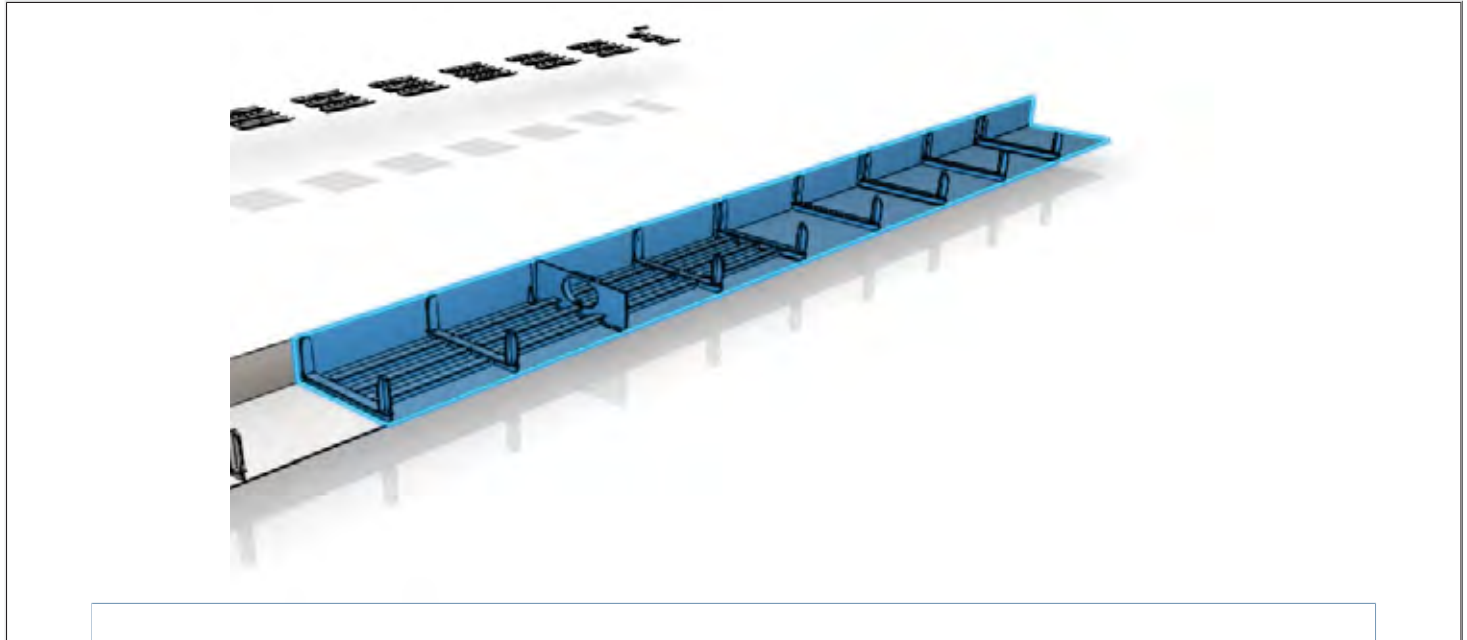
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-66-REV1</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam, magnetic testing of weld and HAZ AKSE 1-2 B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>05-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-30</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-66-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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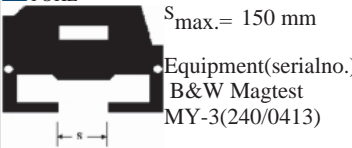


weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT
W18,	100%	100%	100%			W42.3	100%	100%	100%
W20,	100%	5%	100%			W42.4	100%	100%	100%
W21,						W42.5	100%	100%	100%
W22,	100%	100%	100%			W42.6	100%	100%	100%
W23.1,	100%	20%	100%						
W23.2									
W27.1,									
W27.2,									
W27.3,	100%	5%	100%			W42.7	100%	100%	100%
W27.4,									
W27.5,									
W27.6									
W42	100%	100%	100%			W42.8	100%	100%	100%
W19	100%	20%	100%			W53.1		20%	100%
W47	100%	100%	100%			W53.2		20%	100%
W24	100%	20%	100%			W53.3		20%	100%
						W53.4		20%	100%
W34	20%	100%	100%			W53.5		20%	100%
W43,						W53.6		20%	100%
W44,		20%	100%						
W45,									
W50									
						W71.1	-	100%	100%

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiu (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiu (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindiu</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-67-REV1</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Ramona Bindiu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of supporting beams ,magnetic testing of weld and HAZ AKSE 4-5B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>5-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X,k,v,1/2v</b>	WELDING PROCESS / SVEISEPROSESS <b>138/136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

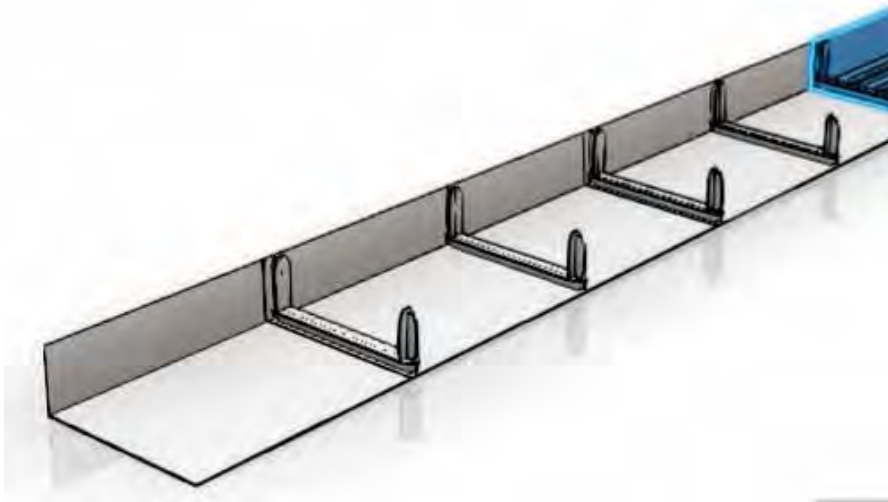
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-08-31**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-67-REV1**

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**2 of/av 3**





# Magnetic testing Magnetspulverprøving

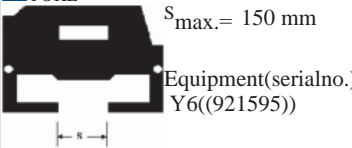
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-67-REV1</b>	PAGE / SIDE <b>3 of/av 3</b>
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weld no.	UT	MT/PT	VT			weld no.	UT	MT/PT	VT		
W18,	100%	100%	100%			W42.3	100%	100%	100%		
W20,	100%	5%	100%			W42.4	100%	100%	100%		
W21,						W42.5	100%	100%	100%		
W22,	100%	100%	100%			W42.6	100%	100%	100%		
W23.1,	100%	20%	100%			W42.7	100%	100%	100%		
W23.2						W42.8	100%	100%	100%		
W27.1,						W53.1		20%	100%		
W27.2,						W53.2		20%	100%		
W27.3,	100%	5%	100%			W53.3		20%	100%		
W27.4,						W53.4		20%	100%		
W27.5,						W53.5		20%	100%		
W27.6						W53.6		20%	100%		
W42	100%	100%	100%			W71.1	-	100%	100%		
W19	100%	20%	100%								
W47	100%	100%	100%								
W24	100%	20%	100%								
W34	20%	100%	100%								
W43,											
W44,		20%	100%								
W45,											
W50											

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindii (456-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindii (456-MT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-15 <b>Approved / Godkjent</b> <i>Ramona Bindii</i>	OPERATOR / OPERATØR DATO:2023-11-15 <i>Ramona Bindii</i>



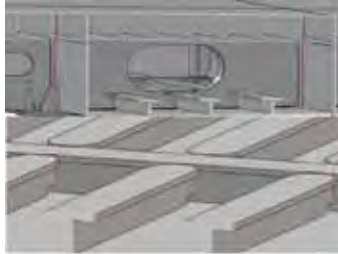
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-73</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam: weld 42.1, 42.2, 52.1 to 52.6</b> <b>AKSE A 1-2, 2-3, 3-4, 4-5</b> <b>AKSE B 1-2, 2-3, 3-4, 4-5</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>K, V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing.</b> <b>All were repaired and re-checked.</b>  <b>Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-31</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-73</b>	PAGE / SIDE <b>2 of/av 2</b>
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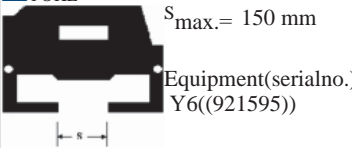


NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-17 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-10-17 <i>Mats K. Skjong</i>





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-09-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-74</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ at W41</b> <b>AKSE A 1-2, 2-3, 3-4, 4-5.</b> <b>AKSE B 1-2, 2-3, 3-4, 4-5.</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240</b> BATCH / PARTI <b>L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

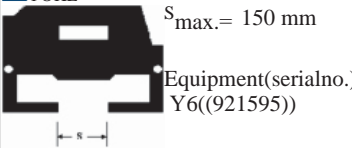
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-09-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-74</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-17 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-10-17 <i>Mats K. Skjong</i>



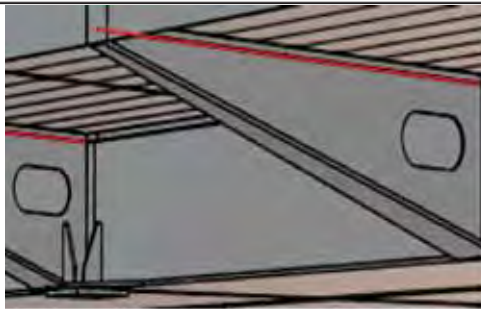
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-09-05</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-75</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ at W28</b> <b>AKSE A 1-2, 2-3, 3-4, 4-5.</b> <b>AKSE B 1-2, 2-3, 3-4, 4-5.</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>X</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240</b> BATCH / PARTI <b>L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

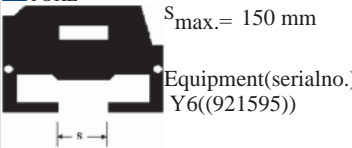
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-09-05</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-75</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-17 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-10-17 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-09-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-76</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beam: weld 42.3- 42.8</b> <b>AKSE A 1-2, 2-3, 3-4, 4-5</b> <b>AKSE B 1-2, 2-3, 3-4, 4-5</b> <b>Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing.</b> <b>All were repaired and re-checked.</b>  <b>Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-09-01</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-76</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-20 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-10-20 <i>Mats K. Skjong</i>



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-78</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W2 weld and HAZ at AKSE 1-2 A, B with AKSE 2-3 A, B Transverse weld Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) Magnaflux Y2((E3060))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>8</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

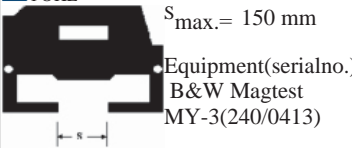
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-25</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-78</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciú (2296-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciú (2296-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-10-25 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-10-25 <i>Doru Baciú</i>



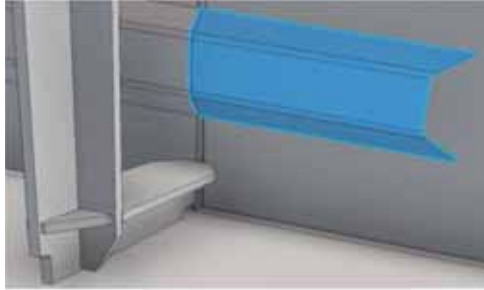
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-83-REV1</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W93 weld and HAZ at AKSE 3-4 B AKSE 4-5 B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>Yes / Ja</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>1/2 V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

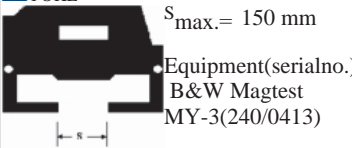
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-83-REV1</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-01 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-01 <i>Popescu Lucian</i>



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-84</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W2 weld and HAZ at AKSE 1-2 A,B with 2-3 A,B AKSE 3-4 A,B with 4-5 A,B Longitudinal weld Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment (serial no.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

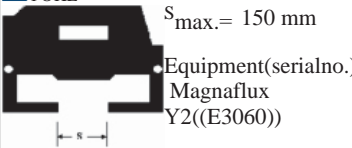
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-84</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-03 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-03 <i>Popescu Lucian</i>



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-85</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W2 weld and HAZ at AKSE 2-3 A, B with AKSE 3-4 A, B AKSE 3-4 A, B with AKSE 4-5 A, B Transverse weld Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serial no.) Magnaflux Y2((E3060))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-85</b>	PAGE / SIDE <b>2 of/av 2</b>
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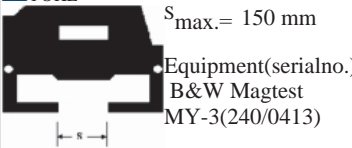


NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2296-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2296-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-03 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-11-03 <i>Doru Baci</i>





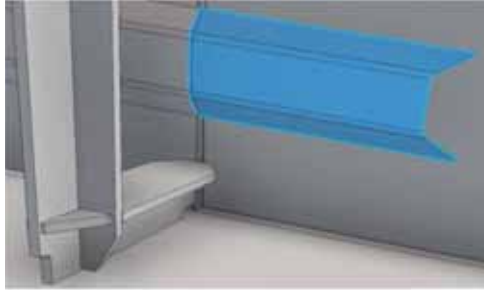
# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-86</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W93 weld and HAZ at AKSE 3-4 AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>1/2 V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

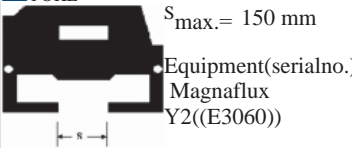
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-10-23</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-86</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-03 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-03 <i>Popescu Lucian</i>



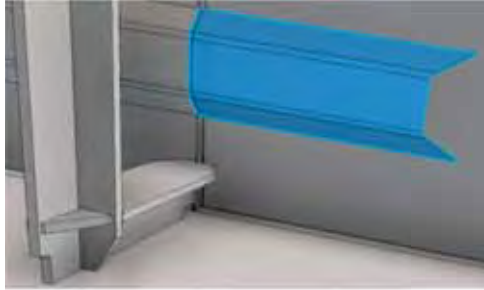
# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-87</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W93 weld and HAZ at AKSE 1-2 AKSE 2-3 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>1/2 V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) Magnaflux Y2((E3060))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

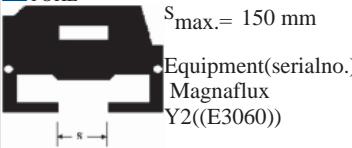
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-87</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciú (2296-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciú (2296-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-13 <b>Approved / Godkjent</b> <i>Doru Baciú</i>	OPERATOR / OPERATØR DATO:2023-11-13 <i>Doru Baciú</i>



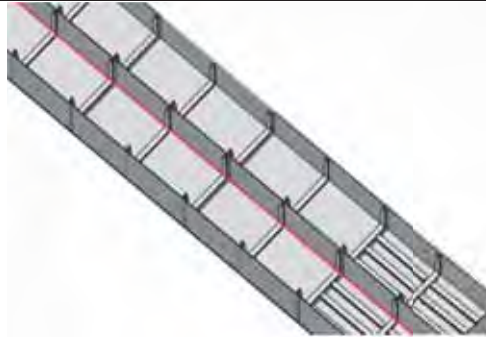
# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-88</b>	PAGE / SIDE <b>1 of/av 2</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunndasøra/Prodtex</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>MT of W68 weld and HAZ at AKSE 1-2, 2-3, 3-4, 4-5. Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>5%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>K</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>Magnaflux Y2((E3060))</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of checking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

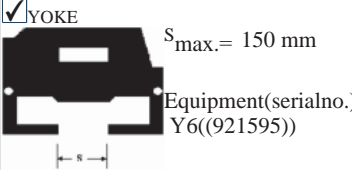
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-08</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-88</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-13 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-13 <i>Popescu Lucian</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-21</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-90</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ AKSE 1-2A - (P1A- P5A)</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>GROOVE / FUGEOMETRI Y, T, K, 1/2V, V</b> <b>A few minor indication was found at the time of testing.</b> <b>All were repaired and re-checked.</b>  <b>Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetspulverprøving

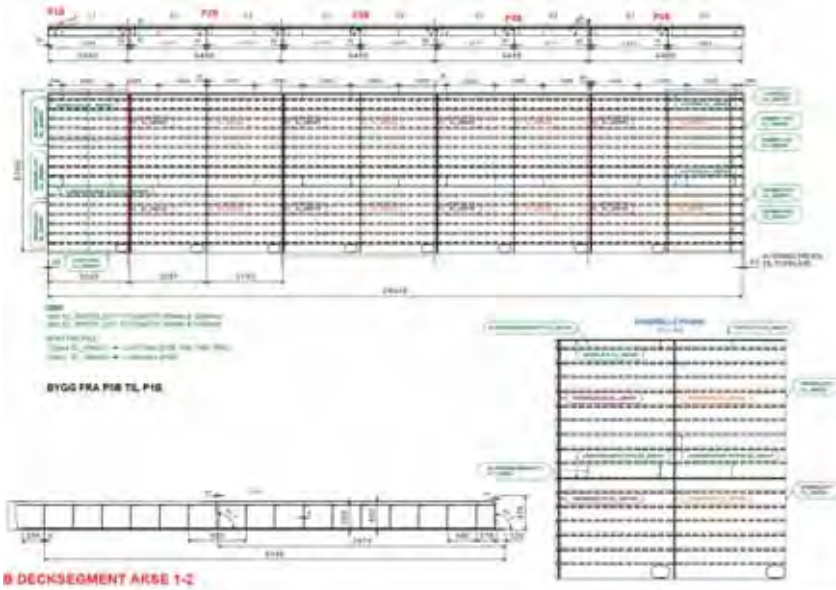
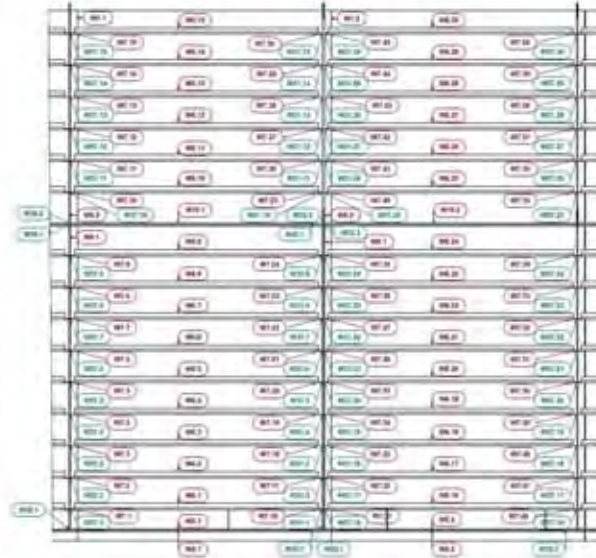
CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-11-21

REPORT NO. / RAPPORT NR.  
10031-23-MP-90

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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-11-21

REPORT NO. / RAPPORT NR.  
10031-23-MP-90

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Weld ID	Weld Type	WT	MT	MT/PT	VT	Weld Details			Magnetic Field	Magnetic Rate	Comments
						Position	Direction	Distance			
W1.1	1	100%	100%	100%	1/4 Fillet top pt	T	18	NOT REPORT	QC		
W1.2	5	100%	100%	100%	1/4 Fillet top pt	V	18	NOT REPORT	QC		
W1.3	8	100%	100%	100%	Flank, FW, side pt	F	18	NOT REPORT	QC		
W1.4	8	100%	100%	100%	Flank, FW, side pt	T	18	NOT REPORT	QC		
W1.5	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	<p>Reduced after 200% of same weld from 100% MT to 50%MT and after another 100% at 20% MT. If weld before</p> <p>Reduced after 200% of same weld from 100% MT to 50%MT and after another 100% at 20% MT. If weld before</p>	
W1.6	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.7	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.8	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.9	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.10	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.11	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.12	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.13	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.14	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.15	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.16	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.17	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.18	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.19	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		
W1.20	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC		

Page 2



W1.21	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.22	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.23	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.24	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.25	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.26	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.27	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.28	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.29	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.30	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.31	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.32	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.33	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.34	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.35	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.36	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.37	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.38	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.39	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.40	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.41	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.42	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.43	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.44	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.45	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.46	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.47	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.48	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.49	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.50	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.51	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.52	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.53	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.54	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.55	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.56	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.57	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.58	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.59	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.60	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.61	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.62	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.63	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.64	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.65	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.66	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.67	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.68	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.69	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	
W1.70	8	100%	100%	100%	1/4 Fillet profile			NOT REPORT	QC	





**Magnetic testing  
Magnetpulverprøving**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-21</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-90</b>	PAGE / SIDE <b>4 of/av 4</b>
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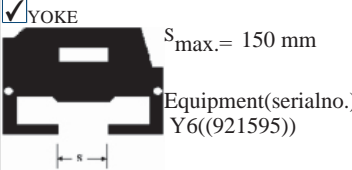
69	W67.8, W67.9, W67.10, W67.11	3	-	20%	100%	6, Fillet vertical		18	NDT report	QC	
70	W67.12, W67.13, W67.14, W67.15	3	-	20%	100%	6, Fillet vertical		18	NDT report	QC	
71	W67.16, W67.17, W67.18, W67.19	3	-	20%	100%	6, Fillet vertical		18	NDT report	QC	
72	W67.20, W67.21, W67.22, W67.23	3	-	20%	100%	6, Fillet vertical		18	NDT report	QC	
73	W67.24, W67.25, W67.26, W67.27	3	-	20%	100%	6, Fillet vertical		18	NDT report	QC	
74	W67.28, W67.29, W67.30, W67.31	3	-	20%	100%	6, Fillet vertical		18	NDT report	QC	
75	W69.1, W69.2	3	-	20%	100%	6, Fillet vert, inside	8	30-20	NDT report	QC	
76	W69.3, W69.4, W69.5, W69.6, W69.7	4	30%	100%	100%	6, Fillet vert, finishing	8	16-20	NDT report	QC	
77	W68.1, W68.2	3	-	20%	100%	6, Fillet vertical, side	8	16-18, 30-18	NDT report	QC	
78	W68.3, W68.4	3	-	20%	100%	6, Fillet vertical, side	8	16-18, 30-18	NDT report	QC	
79	W64.1, W64.2	3	-	100%	100%	Welding joint	5	20-20	NDT report	QC	
80	W65.1, W65.2	3	-	100%	100%	Welding joint	5	16-18	NDT report	QC	
81	W66.1, W66.2	3	-	10%	100%	Weld	5	16-18	NDT report	QC	

<b>Bottom plate Welds</b>											
82	W12.1, W12.2	2	-	10%	100%	Laser lap welds	92V	8-16	NDT report	QC	
83	W11.1, W11.2, W11.3, W11.4, W11.5, W11.6, W11.7, W11.8, W11.9, W11.10, W11.11, W11.12, W11.13, W11.14, W11.15, W11.16, W11.17, W11.18, W11.19, W11.20, W11.21, W11.22, W11.23	2	-	10%	100%	Laser lap welds	-	8-8	NDT report	QC	
84	W14.1, W14.2, W14.3, W14.4, W14.5, W14.6	2	-	10%	100%	MIG Fillet weld	92V	8-20	NDT report	QC	
85	W15.1, W15.2, W15.3, W15.4	3	-	20%	100%	MIG Fillet weld	92V	8-20	NDT report	QC	
86	W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Fillet weld	92V	8-16	NDT report	QC	

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Mats K. Skjong</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-91</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ AKSE 1-2B - P1B, P2B, P3B, P4B &amp; P5B</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>Y,K,V,1/2V</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>100448130223</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>		FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>	
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>GROOVE / FUGEOMETRI Y,T,K,1/2V,V. A few minor indication was found at the time of testing. All were repaired and re-checked.  Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetspulverprøving

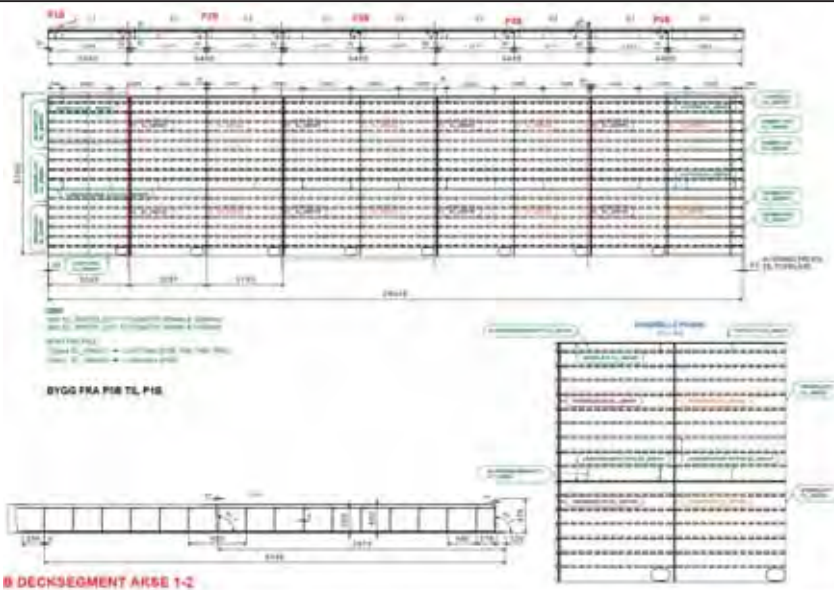
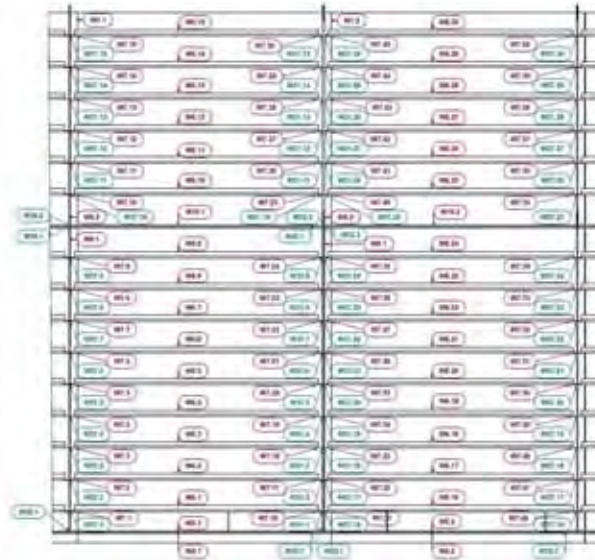
CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-08-03

REPORT NO. / RAPPORT NR.  
10031-23-MP-91

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8 DECKSEGMENT ARSE 1-2



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-91</b>	PAGE / SIDE <b>3 of/av 4</b>
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Slutts Ø (mm)	Weld	MT	MT	MT	Weld	Registered	Report	Comments	
W1.1	5	100%	100%	100%	UH, Ø100 top& bot pl	Y	18-18	NOT report	QC
W1.2	5	100%	100%	100%	UH, Ø100 top& bot pl	Y	18-18	NOT report	QC
W8.1	8	-	100%	100%	8, Fillet T1 +top pl			NOT report	QC
W8.2	8	-	100%	100%	8, Fillet T1 +top pl			NOT report	QC
W9.1	8	-	100%	100%	8, Fillet T1 +top pl			NOT report	QC
W9.2	8	-	100%	100%	8, Fillet T1 +top pl			NOT report	QC
W10.1	8	-	100%	100%	UH, Fillet, Long pl			NOT report	QC
W10.2	8	-	100%	100%	UH, Fillet, Long pl			NOT report	QC
W17.1, W17.2, W17.3, W17.4, W17.5, W17.6, W17.7, W17.8, W17.9, W17.10, W17.11, W17.12, W17.13, W17.14, W17.15, W17.16, W17.17, W17.18, W17.19, W17.20, W17.21, W17.22, W17.23, W17.24, W17.25, W17.26, W17.27, W17.28, W17.29, W17.30, W17.31, W17.32, W17.33, W17.34, W17.35, W17.36, W17.37, W17.38, W17.39, W17.40, W17.41, W17.42, W17.43, W17.44, W17.45, W17.46, W17.47, W17.48, W17.49, W17.50, W17.51, W17.52, W17.53, W17.54, W17.55, W17.56, W17.57, W17.58, W17.59, W17.60, W17.61, W17.62, W17.63, W17.64, W17.65, W17.66, W17.67, W17.68, W17.69, W17.70, W17.71, W17.72, W17.73, W17.74, W17.75, W17.76, W17.77, W17.78, W17.79, W17.80, W17.81, W17.82, W17.83, W17.84, W17.85, W17.86, W17.87, W17.88, W17.89, W17.90, W17.91, W17.92, W17.93, W17.94, W17.95, W17.96, W17.97, W17.98, W17.99, W17.100	3	-	100%	100%	8, FW, vertical			NOT report	QC

W17.1, W17.2, W17.3, W17.4, W17.5, W17.6, W17.7, W17.8, W17.9, W17.10, W17.11, W17.12, W17.13, W17.14, W17.15, W17.16, W17.17, W17.18, W17.19, W17.20, W17.21, W17.22, W17.23, W17.24, W17.25, W17.26, W17.27, W17.28, W17.29, W17.30, W17.31, W17.32, W17.33, W17.34, W17.35, W17.36, W17.37, W17.38, W17.39, W17.40, W17.41, W17.42, W17.43, W17.44, W17.45, W17.46, W17.47, W17.48, W17.49, W17.50, W17.51, W17.52, W17.53, W17.54, W17.55, W17.56, W17.57, W17.58, W17.59, W17.60, W17.61, W17.62, W17.63, W17.64, W17.65, W17.66, W17.67, W17.68, W17.69, W17.70, W17.71, W17.72, W17.73, W17.74, W17.75, W17.76, W17.77, W17.78, W17.79, W17.80, W17.81, W17.82, W17.83, W17.84, W17.85, W17.86, W17.87, W17.88, W17.89, W17.90, W17.91, W17.92, W17.93, W17.94, W17.95, W17.96, W17.97, W17.98, W17.99, W17.100	3	-	100%	100%	8, FW, vertical	V	18-18	NOT report	QC
W17.1, W17.2, W17.3, W17.4, W17.5, W17.6, W17.7, W17.8, W17.9, W17.10, W17.11, W17.12, W17.13, W17.14, W17.15, W17.16, W17.17, W17.18, W17.19, W17.20, W17.21, W17.22, W17.23, W17.24, W17.25, W17.26, W17.27, W17.28, W17.29, W17.30, W17.31, W17.32, W17.33, W17.34, W17.35, W17.36, W17.37, W17.38, W17.39, W17.40, W17.41, W17.42, W17.43, W17.44, W17.45, W17.46, W17.47, W17.48, W17.49, W17.50, W17.51, W17.52, W17.53, W17.54, W17.55, W17.56, W17.57, W17.58, W17.59, W17.60, W17.61, W17.62, W17.63, W17.64, W17.65, W17.66, W17.67, W17.68, W17.69, W17.70, W17.71, W17.72, W17.73, W17.74, W17.75, W17.76, W17.77, W17.78, W17.79, W17.80, W17.81, W17.82, W17.83, W17.84, W17.85, W17.86, W17.87, W17.88, W17.89, W17.90, W17.91, W17.92, W17.93, W17.94, W17.95, W17.96, W17.97, W17.98, W17.99, W17.100	3	-	100%	100%	8, Fillet vert., triple	8	18-18	NOT report	QC
W40.1	5	100%	100%	100%	Ø40, long pl	Y	18-18	NOT report	QC
W18.1, W18.2	5	-	100%	100%	Ø18, long pl	Y	18-18	NOT report	QC
Ø18, W17	5	-	100%	100%	FW	Y	18-18	NOT report	QC



**Magnetic testing**  
**Magnetpulverprøving**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-91</b>	PAGE / SIDE <b>4 of/av 4</b>
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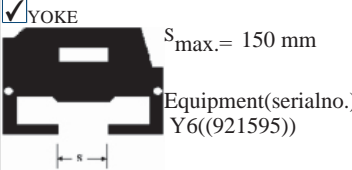
Bottom plate Welds										
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	12V	8-16	NOT report	OC	
W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23	2	-	10%	100%	Laser Lap welds	12V	8-8	NOT report	OC	
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	MIG Fillet weld	12V	8-20	NOT report	OC	
W15.1, W15.2, W15.3, W15.4	3	-	10%	100%	MIG Fillet weld	12V	8-30	NOT report	OC	
W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Fillet weld	12V	8-18	NOT report	OC	

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-21 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-11-21 <i>Mats K. Skjong</i>





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-92</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ AKSE 1-2B - P1B, P2B, P3B, P4B &amp; P5B</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>T</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>100448130223</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE		OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing. All were repaired and re-checked.</b>  <b>Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

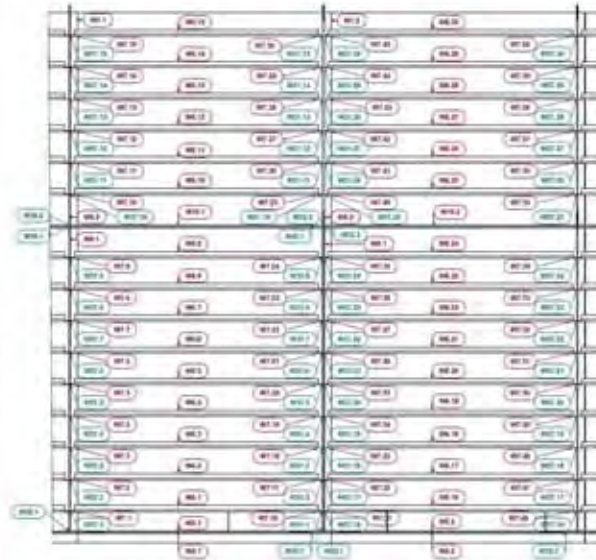
CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-08-03

REPORT NO. / RAPPORT NR.  
10031-23-MP-92

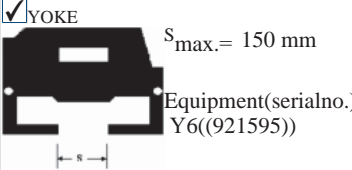
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# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-93</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ weld nr 8.1, 38.1, 30.1, 42.1, 42.2 in addition to the welds from the pictures. AKSE 2-3A -from P6A to P10A</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>Y,K,V,1/2V,T</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension</b> BATCH / PARTI <b>100448130223</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing. All were repaired and re-checked.</b>  <b>Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





**Magnetic testing**  
**Magnetpulverprøving**

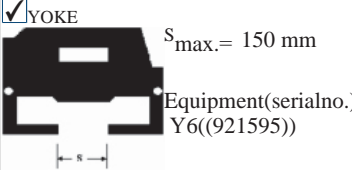
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-93</b>	PAGE / SIDE <b>3 of/av 3</b>
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W55.1, W55.2	5	-	100%	100%	BW, side pl.	Y	16-16	NOT report	QC
W76, W77	2	-	10%	100%	PM	Y	16-16	NOT report	QC
<b>Skillets plate W66a</b>									
W12.1, W12.2	8	-	10%	100%	Laser lap welds	WV	9-18	NOT report	QC
W10.1, W10.2, W10.3, W10.4, W10.5, W10.6, W10.7, W10.8, W10.9, W10.10, W10.11, W10.12, W10.13, W10.14, W10.15, W10.16, W10.17, W10.18, W10.19, W10.20, W10.21, W10.22, W10.23, W10.24, W10.25, W10.26, W10.27	2	-	10%	100%	Laser lap welds	-	9-9	NOT report	QC
W14.1, W14.2, W14.3, W14.4, W14.5, W14.6	5	-	10%	100%	MIG fillet welds	WV	9-20	NOT report	QC
W15.1, W15.2, W15.3, W15.4	3	-	10%	100%	MIG fillet welds	WV	9-30	NOT report	QC
W16.1, W16.2, W16.3, W16.4	8	-	10%	100%	MIG fillet welds	WV	9-16	NOT report	QC

NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Mats Kristoffer Skjong (18369-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Mats K. Skjong</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-94</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Mats Kristoffer Skjong</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ weld nr 7.43, 6.28, 7.58, 57.12, 31.12, 31.27, 57.27 in addition to the welds from the pictures. AKSE 2-3B -from P6B to P10B</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>Y,K,V,1/2V,T</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 100448130223</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing. All were repaired and re-checked.  Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				







# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-94</b>	PAGE / SIDE <b>3 of/av 4</b>
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W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW, vertical			NDT report	Q
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW, vertical			NDT report	Q
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW, vertical			NDT report	Q
W39.1, W39.2, W32.2	4	50%	100%	100%	R, fillet vert. tr+long	K	30-20	NDT report	Q
W30.1, W38.1	3	-	20%	100%	R, fillet vert., tr+side	K	30-16	NDT report	Q
W42.1	5	100%	100%	100%	BW, long. pl.	V	20-20	NDT report	Q
W55.1, W55.2	5	-	100%	100%	BW, long. pl.	V	16-16	NDT report	Q
W76, W77	2	-	10%	100%	FW	T	16-16	NDT report	Q

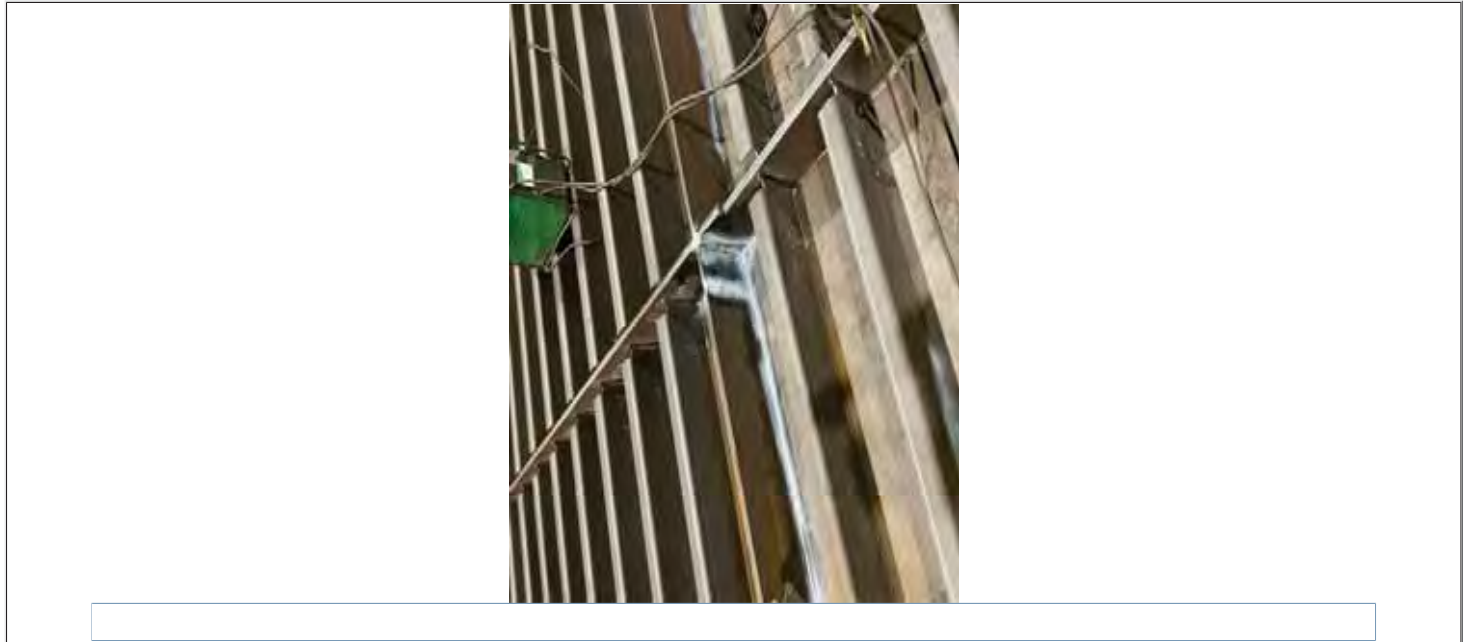
Bottom plate Welds									
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	12V	8-16	NDT report	C
W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30	2	-	10%	100%	Laser Lap welds		8-8	NDT report	C
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	MIG Fillet weld	12V	8-20	NDT report	C
W15.1, W15.2, W15.3, W15.4	3	-	20%	100%	MIG Fillet weld	12V	8-30	NDT report	C
W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Fillet weld	12V	8-16	NDT report	C

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**Magnetic testing**  
**Magnetpulverprøving**


CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-03</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-94</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Mats Kristoffer Skjong (18369-N2-M)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Mats Kristoffer Skjong (18369-N2-M)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Mats K. Skjong</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Mats K. Skjong</i>

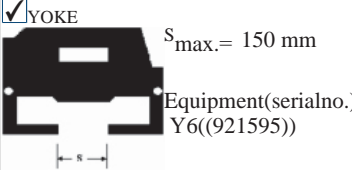


# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-05-22</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-95</b>	PAGE / SIDE <b>1 of/av 1</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Doru Baciu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ weld nr 76,77. AKSE 3-4A -from P11A to P15A</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>T-joint</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 100448130223</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>Magnaflux Y2((E3060))</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing. All were repaired and re-checked.  Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				
NAME CERT. NO. / NAVN SERT. NR. <b>()</b>	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Doru Baciu (2296-MT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Doru Baciu (2296-MT)</b>		
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Doru Baciu</i>		



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-96</b>	PAGE / SIDE <b>1 of/av 5</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ AKSE 3-4B -from P11B to P15B Details in the pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V,T</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>A few minor indication was found at the time of testing. All were repaired and re-checked.  Acc. according to standard.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-96</b>	PAGE / SIDE <b>3 of/av 5</b>
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W57.13, W31.13, W31.28, W57.28	3	-	20%	100%	R, FW, vertical			NDT report	Q
W57.14, W31.14, W31.29, W57.29	3	-	20%	100%	R, FW, vertical			NDT report	Q
W57.15, W31.15, W31.30, W57.30	3	-	20%	100%	R, FW, vertical			NDT report	Q
W39.1, W39.2, W32.2	4	50%	100%	100%	R, fillet vert. tr+long	K	30-20	NDT report	Q
W30.1, W38.1	3	-	20%	100%	R, fillet vert., tr+side	K	30-16	NDT report	Q
W42.1	5	100%	100%	100%	BW, long. pl.	V	20-20	NDT report	Q
W55.1, W55.2	5	-	100%	100%	BW, long. pl.	V	16-16	NDT report	Q
W76, W77	2	-	10%	100%	FW	T	16-16	NDT report	Q

Bottom plate Welds									
W12.1, W12.2	2	-	10%	100%	Laser Lap welds	12V	8-16	NDT report	C
W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30	2	-	10%	100%	Laser Lap welds		8-8	NDT report	C
W14.1, W14.2, W14.3, W14.4	2	-	10%	100%	MIG Fillet weld	12V	8-20	NDT report	C
W15.1, W15.2, W15.3, W15.4	3	-	20%	100%	MIG Fillet weld	12V	8-30	NDT report	C
W16.1, W16.2, W16.3, W16.4	3	-	20%	100%	MIG Fillet weld	12V	8-16	NDT report	C

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**Magnetic testing**  
**Magnetpulverprøving**

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-96</b>	PAGE / SIDE <b>4 of/av 5</b>
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	W7.40, W6.25, W7.55	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	
	W7.41, W6.26, W7.56	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	and
	W7.42, W6.27, W7.57	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	MT
	W7.43, W6.28, W7.58	5	-	20%	100%	LH+R, FW, L profile			NDT report	QC	occ
90	W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW, vertical			NDT report		
91	W57.12, W31.12, W31.27, W57.27	3	-	20%	100%	R, FW, vertical			NDT report		



# Magnetic testing Magnetpulverprøving

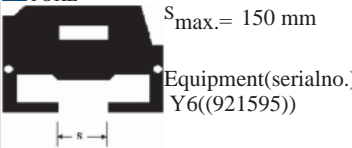
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-96</b>	PAGE / SIDE <b>5 of/av 5</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Aleksander Haahjem (18351-N2-M)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Aleksander Haahjem (18351-N2-M)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-28</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-97</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ weld nr: 76,77. Deck section A (P16 to 18A) AKSE 4-5 Details in the pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>FW</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 765/1314 A</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>15</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>After repairs fulfill requirements. No indications were found at the time of rechecking.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

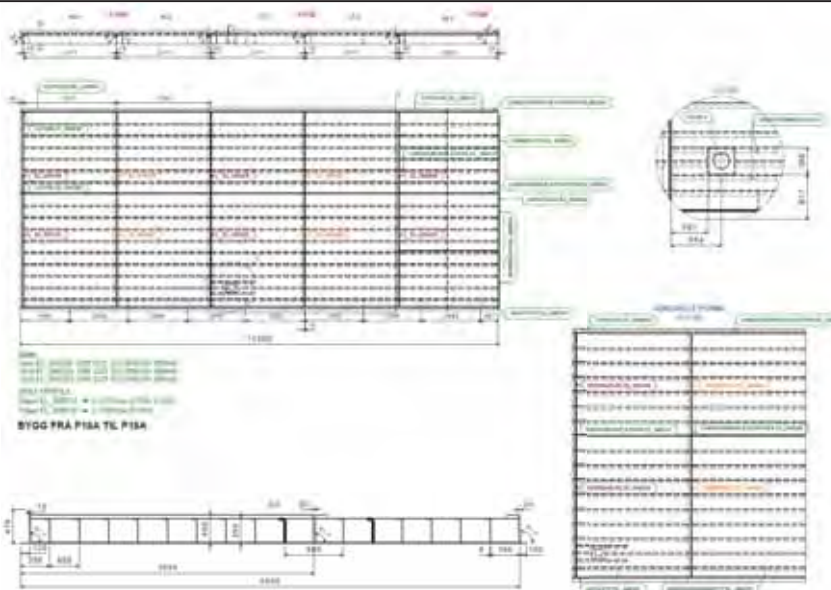
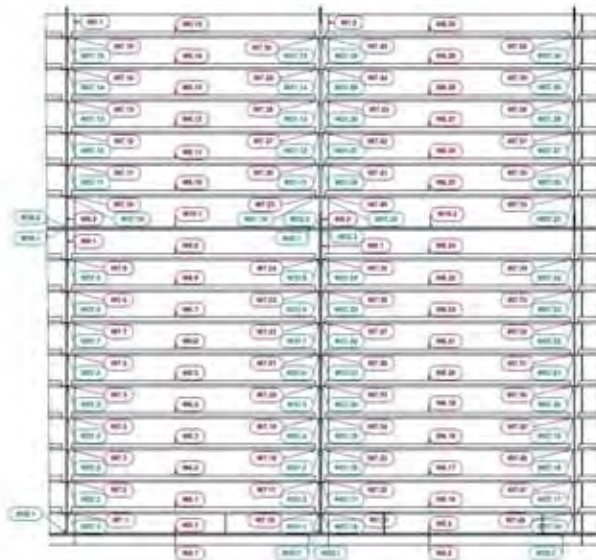
CLIENT / KUNDE  
Prodex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-06-28

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10031-23-MP-97

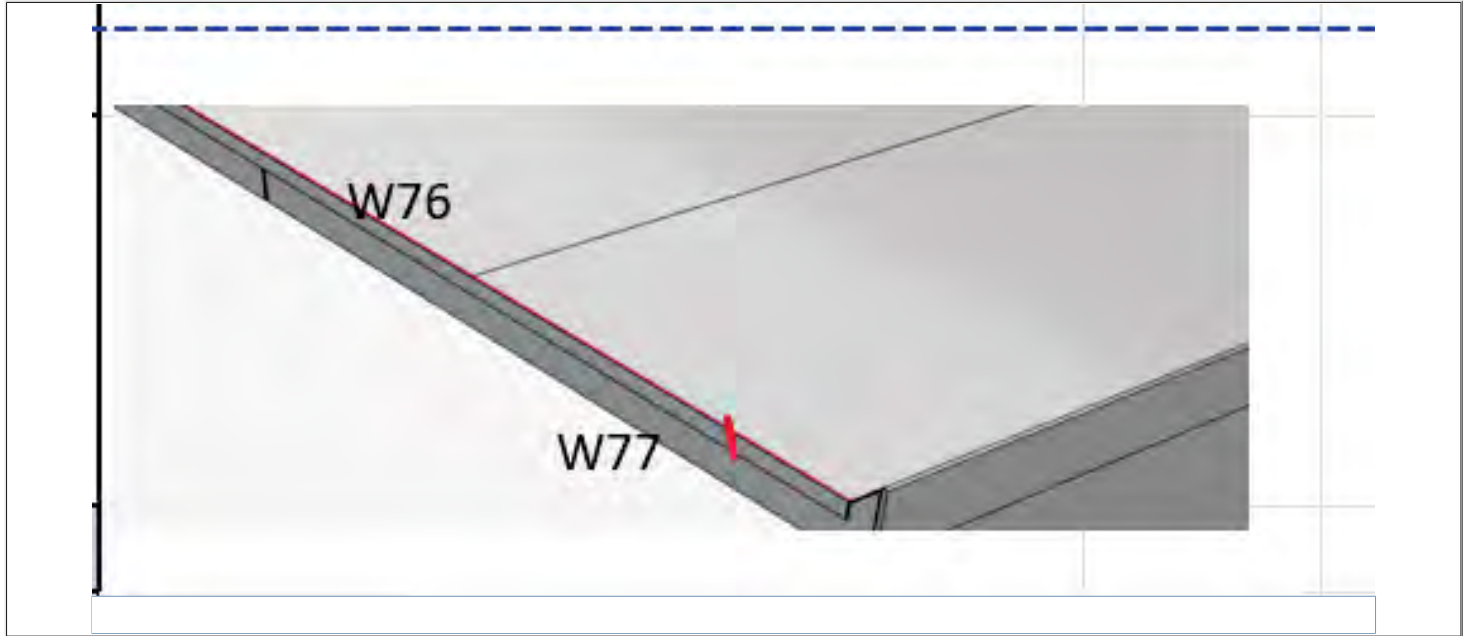
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Magnetic testing  
Magnetpulverprøving

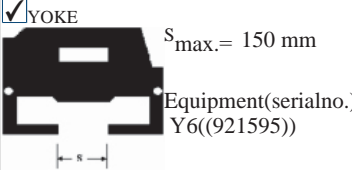
CLIENT / KUNDE Prodtex Industri As	CLIENT O.NO / KUNDE O.NR 20021 - Elverhøy	DATE OF TESTING / KONTROLLDATO 2023-06-28	REPORT NO. / RAPPORT NR. 10031-23-MP-97	PAGE / SIDE 3 of/av 3
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Aleksander Haahjem (18351-N2-M)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-29</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-98</b>	PAGE / SIDE <b>1 of/av 5</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Fiskåholmen/Prodtex</b>	OPERATOR / OPERATØR <b>Aleksander Haahjem</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Magnetic testing of weld and HAZ Deck section B (P16-P18B) AKSE 4-5 Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>10-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEGEOMETRI <b>Y,K,V,1/2V,T</b>	WELDING PROCESS / SVEISEPROSESS <b>52/135+52/136/138</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>PFINDER 240 BATCH / PARTI L49195</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment(serialno.) Y6((921595))	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>10</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>No indications were found at the time of inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

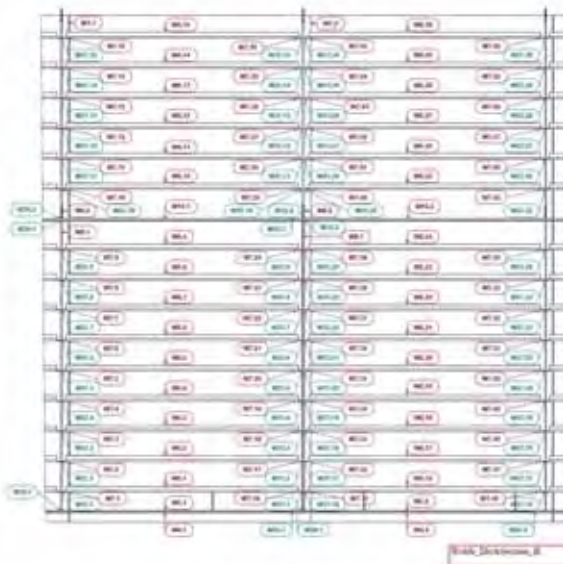
CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

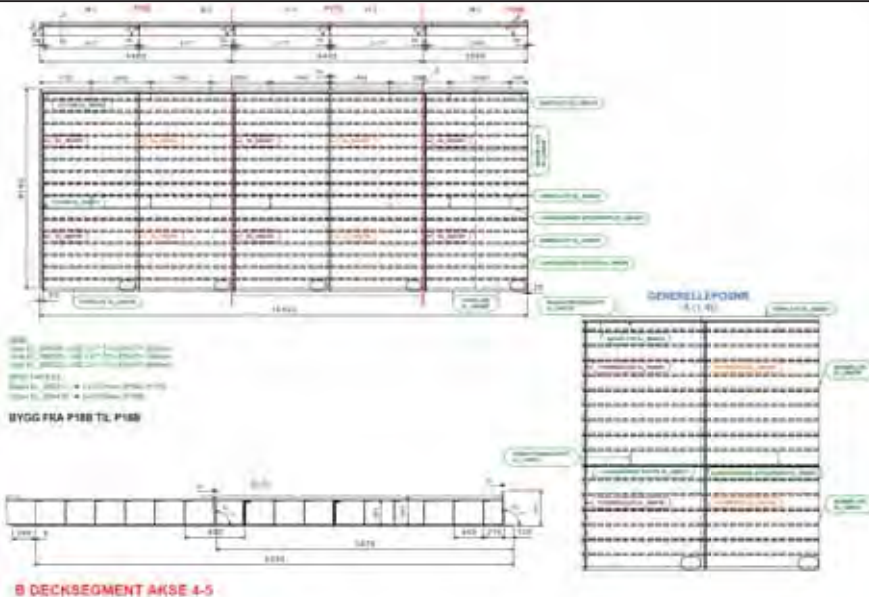
DATE OF TESTING / KONTROLLDATO  
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# Magnetic testing Magnetspulverprøving

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Item No.	Material	Spec.	Grade	Thickness	Equipment	Result	Comments
101.1	Stainless Steel	ASME SA-312	304	1.5	MT-100	Pass	
101.2	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.3	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.4	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.5	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.6	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.7	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.8	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.9	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.10	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.11	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.12	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.13	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.14	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.15	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.16	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.17	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.18	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	
101.19	Carbon Steel	ASME SA-106	B	1.5	MT-100	Pass	
101.20	Carbon Steel	ASME SA-106	B	2.0	MT-100	Pass	

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# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE  
**Prodtex Industri As**

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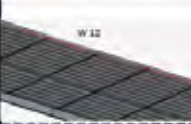
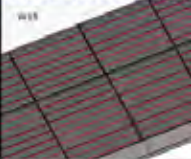



Order No.	Material	Spec	Grade	Quantity	Lot	Inspector	Result	Remarks	Photo
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02	W17.08, W17.09, W17.10	1	2004	2000	10000	10000	OK		
03	W17.11, W17.12, W17.13	1	2004	2000	10000	10000	OK		
04	W17.14, W17.15, W17.16	1	2004	2000	10000	10000	OK		
05	W17.17, W17.18, W17.19	1	2004	2000	10000	10000	OK		
06	W17.20, W17.21, W17.22	1	2004	2000	10000	10000	OK		
07	W17.23, W17.24, W17.25	1	2004	2000	10000	10000	OK		
08	W17.26, W17.27, W17.28	1	2004	2000	10000	10000	OK		
09	W17.29, W17.30, W17.31	1	2004	2000	10000	10000	OK		
10	W17.32, W17.33, W17.34	1	2004	2000	10000	10000	OK		
11	W17.35, W17.36, W17.37	1	2004	2000	10000	10000	OK		
12	W17.38, W17.39, W17.40	1	2004	2000	10000	10000	OK		
13	W17.41, W17.42, W17.43	1	2004	2000	10000	10000	OK		
14	W17.44, W17.45, W17.46	1	2004	2000	10000	10000	OK		
15	W17.47, W17.48, W17.49	1	2004	2000	10000	10000	OK		
16	W17.50, W17.51, W17.52	1	2004	2000	10000	10000	OK		
17	W17.53, W17.54, W17.55	1	2004	2000	10000	10000	OK		
18	W17.56, W17.57, W17.58	1	2004	2000	10000	10000	OK		
19	W17.59, W17.60, W17.61	1	2004	2000	10000	10000	OK		
20	W17.62, W17.63, W17.64	1	2004	2000	10000	10000	OK		
21	W17.65, W17.66, W17.67	1	2004	2000	10000	10000	OK		
22	W17.68, W17.69, W17.70	1	2004	2000	10000	10000	OK		
23	W17.71, W17.72, W17.73	1	2004	2000	10000	10000	OK		
24	W17.74, W17.75, W17.76	1	2004	2000	10000	10000	OK		
25	W17.77, W17.78, W17.79	1	2004	2000	10000	10000	OK		
26	W17.80, W17.81, W17.82	1	2004	2000	10000	10000	OK		
27	W17.83, W17.84, W17.85	1	2004	2000	10000	10000	OK		
28	W17.86, W17.87, W17.88	1	2004	2000	10000	10000	OK		
29	W17.89, W17.90, W17.91	1	2004	2000	10000	10000	OK		
30	W17.92, W17.93, W17.94	1	2004	2000	10000	10000	OK		
31	W17.95, W17.96, W17.97	1	2004	2000	10000	10000	OK		
32	W17.98, W17.99, W17.100	1	2004	2000	10000	10000	OK		

Order No.	Material	Spec	Grade	Quantity	Lot	Inspector	Result	Remarks	Photo
33	W18.01, W18.02, W18.03	1	2004	2000	10000	10000	OK		
34	W18.04, W18.05, W18.06	1	2004	2000	10000	10000	OK		
35	W18.07, W18.08, W18.09	1	2004	2000	10000	10000	OK		
36	W18.10, W18.11, W18.12	1	2004	2000	10000	10000	OK		
37	W18.13, W18.14, W18.15	1	2004	2000	10000	10000	OK		
38	W18.16, W18.17, W18.18	1	2004	2000	10000	10000	OK		
39	W18.19, W18.20, W18.21	1	2004	2000	10000	10000	OK		
40	W18.22, W18.23, W18.24	1	2004	2000	10000	10000	OK		
41	W18.25, W18.26, W18.27	1	2004	2000	10000	10000	OK		
42	W18.28, W18.29, W18.30	1	2004	2000	10000	10000	OK		
43	W18.31, W18.32, W18.33	1	2004	2000	10000	10000	OK		
44	W18.34, W18.35, W18.36	1	2004	2000	10000	10000	OK		
45	W18.37, W18.38, W18.39	1	2004	2000	10000	10000	OK		
46	W18.40, W18.41, W18.42	1	2004	2000	10000	10000	OK		
47	W18.43, W18.44, W18.45	1	2004	2000	10000	10000	OK		
48	W18.46, W18.47, W18.48	1	2004	2000	10000	10000	OK		
49	W18.49, W18.50, W18.51	1	2004	2000	10000	10000	OK		
50	W18.52, W18.53, W18.54	1	2004	2000	10000	10000	OK		
51	W18.55, W18.56, W18.57	1	2004	2000	10000	10000	OK		
52	W18.58, W18.59, W18.60	1	2004	2000	10000	10000	OK		
53	W18.61, W18.62, W18.63	1	2004	2000	10000	10000	OK		
54	W18.64, W18.65, W18.66	1	2004	2000	10000	10000	OK		
55	W18.67, W18.68, W18.69	1	2004	2000	10000	10000	OK		
56	W18.70, W18.71, W18.72	1	2004	2000	10000	10000	OK		
57	W18.73, W18.74, W18.75	1	2004	2000	10000	10000	OK		
58	W18.76, W18.77, W18.78	1	2004	2000	10000	10000	OK		
59	W18.79, W18.80, W18.81	1	2004	2000	10000	10000	OK		
60	W18.82, W18.83, W18.84	1	2004	2000	10000	10000	OK		
61	W18.85, W18.86, W18.87	1	2004	2000	10000	10000	OK		
62	W18.88, W18.89, W18.90	1	2004	2000	10000	10000	OK		
63	W18.91, W18.92, W18.93	1	2004	2000	10000	10000	OK		
64	W18.94, W18.95, W18.96	1	2004	2000	10000	10000	OK		
65	W18.97, W18.98, W18.99	1	2004	2000	10000	10000	OK		
66	W18.100, W18.101, W18.102	1	2004	2000	10000	10000	OK		



# Magnetic testing Magnetpulverprøving

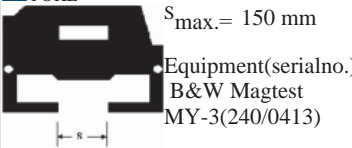
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-08-29</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-98</b>	PAGE / SIDE <b>5 of/av 5</b>
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Bottom plate Welds										
952	W12.1, W12.2	2	100%	100%	Laser Lap welds	u2V	S-16	NDT report	QC	
953	W13.1, W13.2, W13.3, W13.4, W13.5, W13.6, W13.7, W13.8, W13.9, W13.10, W13.11, W13.12, W13.13, W13.14, W13.15, W13.16, W13.17, W13.18, W13.19, W13.20, W13.21, W13.22, W13.23, W13.24, W13.25, W13.26, W13.27, W13.28, W13.29, W13.30	2	100%	100%	Laser Lap welds	u2V	S-16	NDT report	QC	
954	W14.1, W14.2, W14.3, W14.4	2	100%	100%	MIG Flat weld	x2V	S-20	NDT report	QC	
955	W15.1, W15.2, W15.3, W15.4	8	20%	100%	MIG Flat weld	u2V	S-20	NDT report	QC	
956	W16.1, W16.2, W16.3, W16.4	8	20%	100%	MIG Flat weld	u2V	S-16	NDT report	QC	
957										
958										

NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Aleksander Haahjem (18351-N2-M)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Aleksander Haahjem (18351-N2-M)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Aleksander Haahjem</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Aleksander Haahjem</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-99</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of support beams. AKSE 1-2, 2-3, 3-4, 4-5 A and B Details in pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>K,X,V,T</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 100448130223</b>	<input checked="" type="checkbox"/> YOKE  $S_{max.} = 150 \text{ mm}$ Equipment (serial no.) B&W Magtest MY-3(240/0413)	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

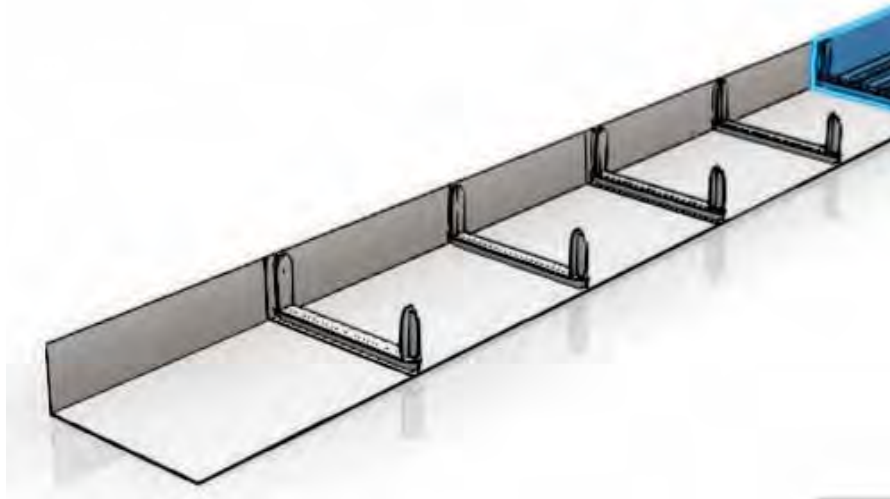
CLIENT / KUNDE  
Prodex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøy

DATE OF TESTING / KONTROLLDATO  
2023-11-15

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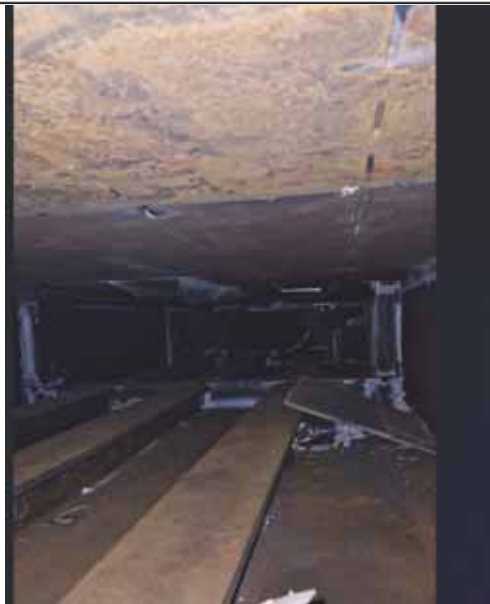


weld no.	WIC	UT	MT/PT	VT	Weld Details		
W26	3	-	20%	100%	R, FW, Bunnflens & Lagerfundament	T	30-40
W35	4	-	100%	100%	R, FW, Tverbjelke&Langsgaende stegstivere	K	30-20
W46	4	-	100%	100%	R, FWvert. endeplate& Langsgående stegstiver	V	20-20
W69.1	5	100%	100%	100%	M, BW Bunnflens & Bunflens	X	30-30
W69.2	5	100%	100%	100%	M, BW Bunnflens & Bunflens		
W69.3	5	100%	100%	100%	M, BW Bunnflens & Bunflens		
W69.4	5	100%	100%	100%	M, BW Bunnflens & Bunflens		



# Magnetic testing Magnetpulverprøving


CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-15</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-99</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ()	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-22 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-22 <i>Popescu Lucian</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-101</b>	PAGE / SIDE <b>1 of/av 3</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of mounting endplate AKSE 1-2, 4-5 A and B Details in the pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>20-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>1/2V, K, V</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 100448130223</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				





# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-101</b>	PAGE / SIDE <b>2 of/av 3</b>
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veld n	WIC	UT	MT/P.T	VT	Weld		Regist	Respoi	Comm
W3	5	100%	100%	100%	R, BW Topplate & Endeplate	1/2V	16-20	NDT report	QC
W11	4	-	20%	100%	R, FW Bunnplate & Endeplate	1/2V	20-8	NDT report	QC
W25	5	20%	100%	100%	R, BW Bunnflens & Endeplate	K	20-30	NDT report	QC
W46	4	-	100%	100%	R, BW Bunnplate & Endeplate	1/2V	20-20	NDT report	QC
W56	5	-	100%	100%	R, BW Sideplate & Endeplate	V	16-20	NDT report	QC





# Magnetic testing Magnetpulverprøving

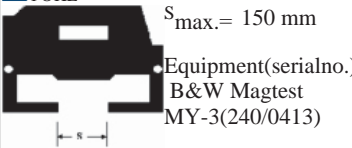
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-14</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-101</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-23 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-23 <i>Popescu Lucian</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-102</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of assembly AKSE 1-2, 2-3, 3-4, 4-5 A and B Details in the pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>5-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>1/2V, V, slots</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 100448130223</b>	<input checked="" type="checkbox"/> YOKE  Equipment(serialno.) <b>B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE  
**Prodtex Industri As**

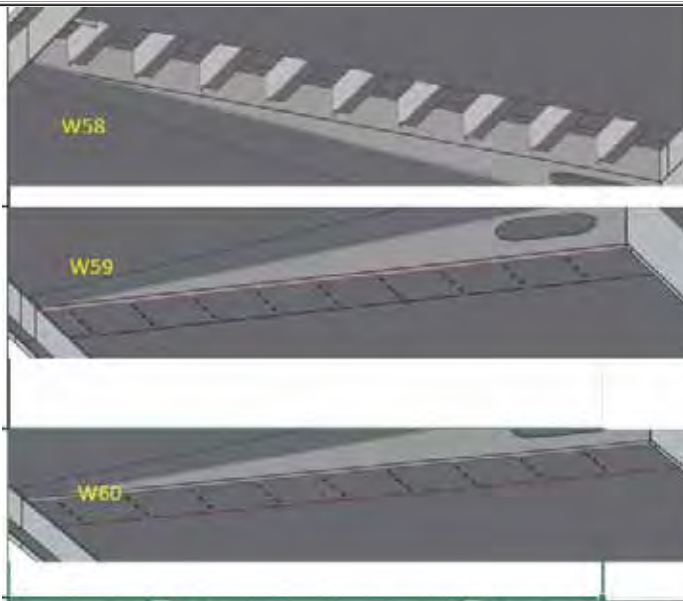
CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-11-02**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-102**

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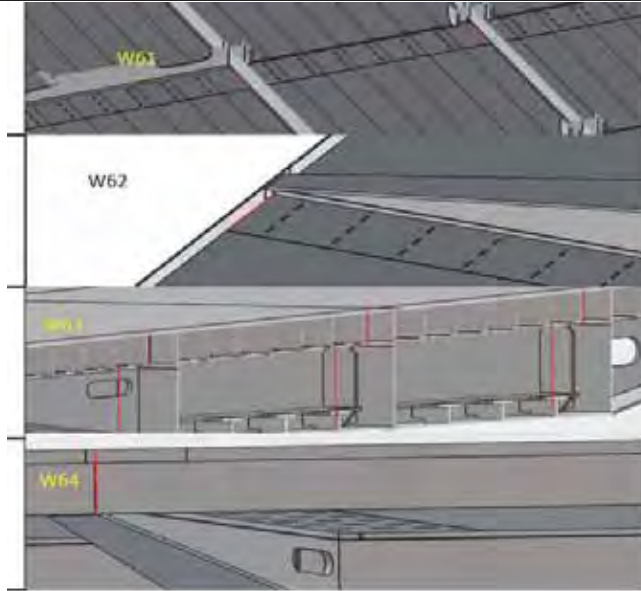
Weld no.	Weld	M/TP	VT	Weld Details	Side	Mag. field	Report	Result
W57	2	96	100%	M, komplate stive	side	8-8	MDT report	OK
W58	2	97%	100%	N, PW, langgledet & kornete	side	8-8	MDT report	OK
W59	3	100%	100%	N, PW, kornete	side	8-8	MDT report	OK
W60	3	100%	100%	N, SW, kornete	side	8-8	MDT report	OK
W61	2	96	100%	N, PW, kornete	side	8-12	MDT report	OK
W62	3	96	100%	M, SW, kornete	side	8-12	MDT report	OK
W63	3	100%	100%	M, SW, langgledet & kornete	side	10-20	MDT report	OK
W64	3	100%	100%	M, SW, kornete & kornete	side	10-18	MDT report	OK





# Magnetic testing Magnetpulverprøving

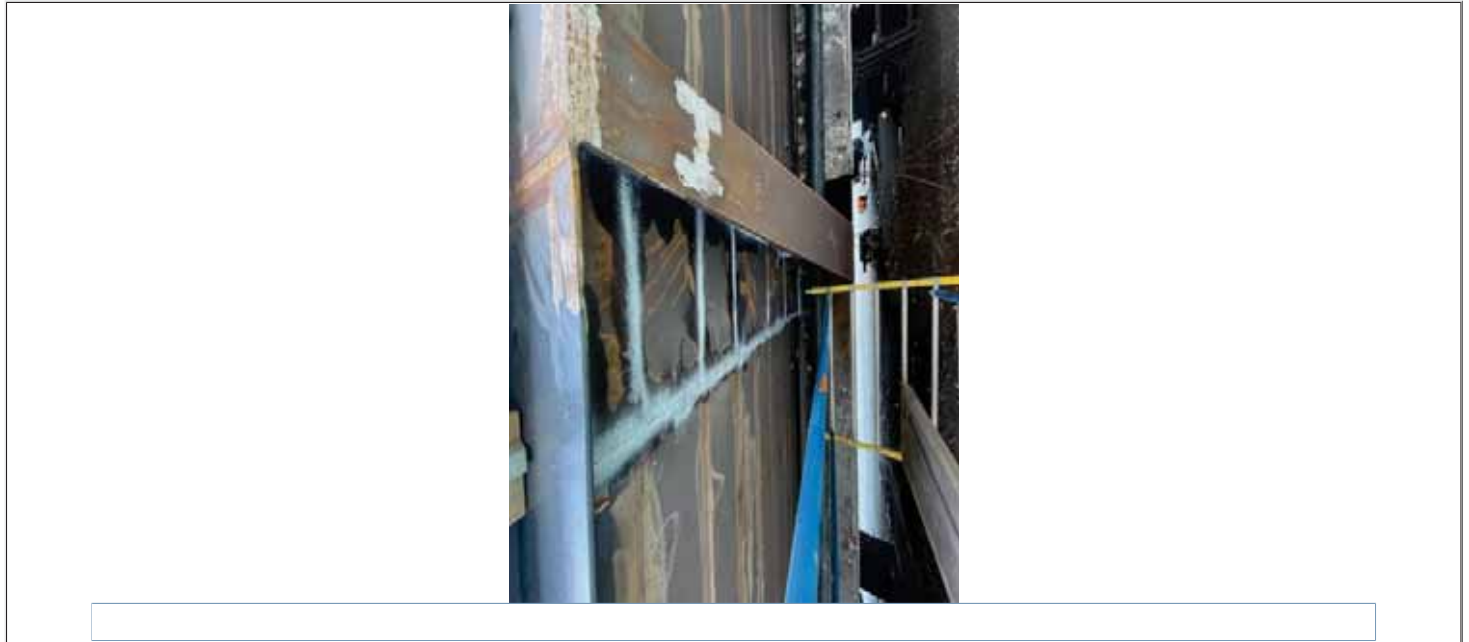
CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-102</b>	PAGE / SIDE <b>3 of/av 4</b>
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# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-102</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-23 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-23 <i>Popescu Lucian</i>







# Liquid penetrant testing Prøving med penetrerende væske


CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-11</b>	REPORT NO. / RAPPORT NR. <b>10031-23-PT-6</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiu (1815-PT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiu (1815-PT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-25 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-07-25 <i>Ramona Bindiu</i>



# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-100</b>	PAGE / SIDE <b>1 of/av 4</b>
DRAWING NO. / TEGNING NO. <b>NA</b>	PLACE OF WORK / KONTROLLSTED <b>Sunnalsøra</b>	OPERATOR / OPERATØR <b>Lucian Popescu</b>	ATTACHMENT / VEDLEGG <b>0</b>	
OBJECT / KONTROLL AV <b>Control of mounting support beams under. AKSE 1-2, 2-3, 3-4, 4-5 A and B Details in the pictures.</b>				
PROCEDURE / PROSEDYRE <b>Prodtex KC04.05_P03 (MT)</b>	REV <b>2</b>	EXTENT OF TESTING / KONTROLLOMFANG <b>5-100%</b>	ACCEPTANCE STANDARD / AKSEPTSTANDARD <b>ISO 23278 Lev 2X</b>	
MATERIAL TYPE / MATERIALTYPE <b>S420J5W M</b>	HEAT TREATED / VARMEBEHANDLET <b>No / Nei</b>	SURFACE / OVERFLATE <b>As welded</b>	GROOVE / FUGEOMETRI <b>X, K,V,1/2V,T</b>	WELDING PROCESS / SVEISEPROSESS <b>136</b>
MAGNETIC PARTICLE INK / MAGNETISK PULVER TYPE <b>MR 76S MP suspension BATCH / PARTI 100448130223</b>	<input checked="" type="checkbox"/> YOKE  <b>S<sub>max</sub> = 150 mm Equipment(serialno.) B&amp;W Magtest MY-3(240/0413)</b>	<input type="checkbox"/> OTHER / ANNEN METODE	OBJECT TEMPERATURE / OVERFLATETEMPERATUR <b>5</b>	
MEDIUM <input checked="" type="checkbox"/> WET / VÅTT <input type="checkbox"/> DRY / TØRT <input type="checkbox"/> BLACK / SVART <input type="checkbox"/> FLUORESCENT / FLUORISERENDE			<b>500<sup>2</sup> Lux</b>	CONTRAST COLOR / KONTRASTFARGE <b>White</b>
LIFTING CAPACITY / LØFTEKAPASITET <b>4.5 kg</b>	FIELD STRENGTH / FELT STYRKE <b>2 kA/m - 6.5 kA/m</b>	FIELD INDICATOR / FELTINDIKATOR <b>Castrol strips</b>		
MAGNETIZED FOR / MAGNETISERT FOR <b>LONGITUDINAL + TRANSVERSE DEFECTS / LANGSGÅENDE + TVERRGÅENDE INDIKASJONER</b>				
TEST RESULTS - REMARKS / RESULTATER - BEMERKNINGER <b>Indications were found and repaired before the time of re-inspection.</b>				
REPAIRS MARKED ON / REPARASJONER AVMERKET PÅ <input type="checkbox"/> OBJECT / OBJEKT <input type="checkbox"/> SKETCH / SKISSE				



# Magnetic testing Magnetspulverprøving

CLIENT / KUNDE  
Prodtex Industri As

CLIENT O.NO / KUNDE O.NR  
20021 - Elverhøj

DATE OF TESTING / KONTROLDDATO  
2023-11-13

REPORT NO. / RAPPORT NR.  
10031-23-MP-100

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Opkald nr.	WC	VT	MI/PT	VI	Byld Detalje			Regikey nr. (sic)	Region	Combin
W25	3	100%	100%	100%	R, BW Svarflera & Endrylabe	R	30-20	NDT report	QC	
W88	2	-	3%	100%	R, FW Svarflera & Langgæmde tagplader	R	30-20	NDT report	QC	
W17	2	-	3%	100%	R, FW Svarplade & Langgæmde tagplader	W/da	8-8	NDT report	QC	
W28	3	20%	20%	100%	M, BW Tverbjælke & Tverrstæbe	K	30-30	NDT report	QC	
W29	4	50%	100%	100%	M, BW Tverbjælke & Tverrstæbe	V	30-30	NDT report	QC	
W38	3	20%	20%	100%	M, BW Tverbjælke & Tverrstæbe	K	30-30	NDT report	QC	
W37	3	-	20%	100%	M, FW Tverbjælke & Skidestæbe	F	30-18	NDT report	QC	
W54	3	-	20%	100%	M, FW Tverbjælke & Skidestæbe	J/V	16-30	NDT report	QC	
W59	3	20%	20%	100%	R, BW Svarplade & Tverbjælke	J/M	8-50	NDT report	QC	
W41	3	20%	20%	100%	M, BW Langgæmde & Langgæmde	V	20-20	NDT report	QC	
W82	3	20%	20%	100%	enigt.	R	30-30	NDT report	QC	
W88	6	100%	100%	100%	Tverrstæbe (Skidestæbe) & Bjælke med langgæmde tagplader	R	30-22	NDT report	QC	It. er be includet i den rapport om den bygning
W91	8	100%	100%	100%	M, BW Langgæmde & Langgæmde tagplader	J/V	20-20	NDT report	QC	Area erklæret som færdigt og sikker



# Magnetic testing Magnetpulverprøving

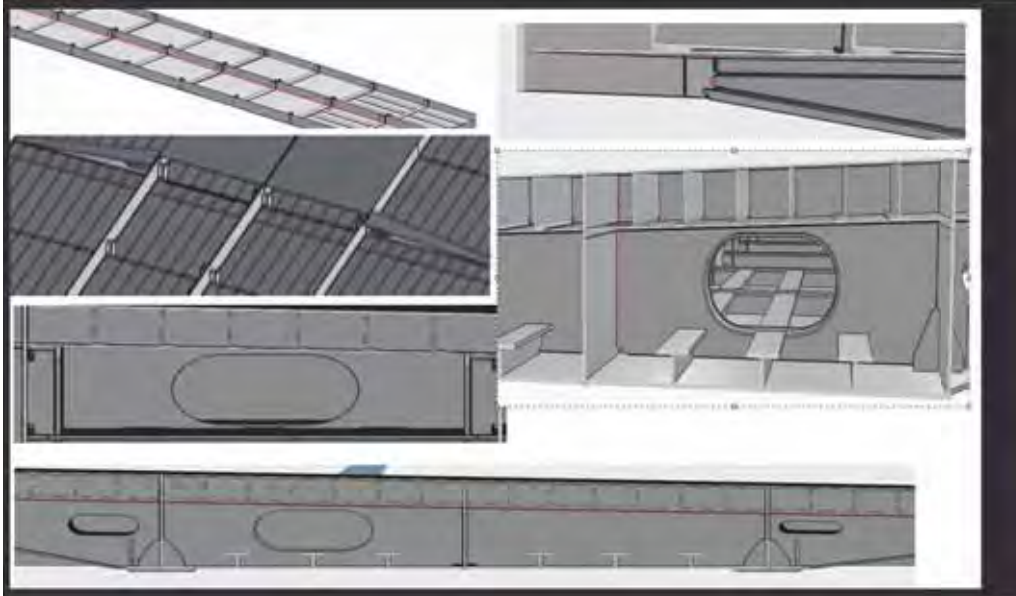
CLIENT / KUNDE  
**Prodtex Industri As**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhøy**

DATE OF TESTING / KONTROLLDATO  
**2023-11-13**

REPORT NO. / RAPPORT NR.  
**10031-23-MP-100**

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# Magnetic testing Magnetpulverprøving

CLIENT / KUNDE <b>Prodtex Industri As</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-11-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-MP-100</b>	PAGE / SIDE <b>4 of/av 4</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Lucian Popescu (466-N2-MT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Lucian Popescu (466-N2-MT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-11-23 <b>Approved / Godkjent</b> <i>Popescu Lucian</i>	OPERATOR / OPERATØR DATO:2023-11-23 <i>Popescu Lucian</i>







# Liquid penetrant testing Prøving med penetrerende væske

CLIENT / KUNDE  
**Prodtex industri as**

CLIENT O.NO / KUNDE O.NR  
**20021 - Elverhoy**

DATE OF TESTING / KONTROLLDATO  
**2023-06-02**

REPORT NO. / RAPPORT NR.  
**10031-23-PT-9**

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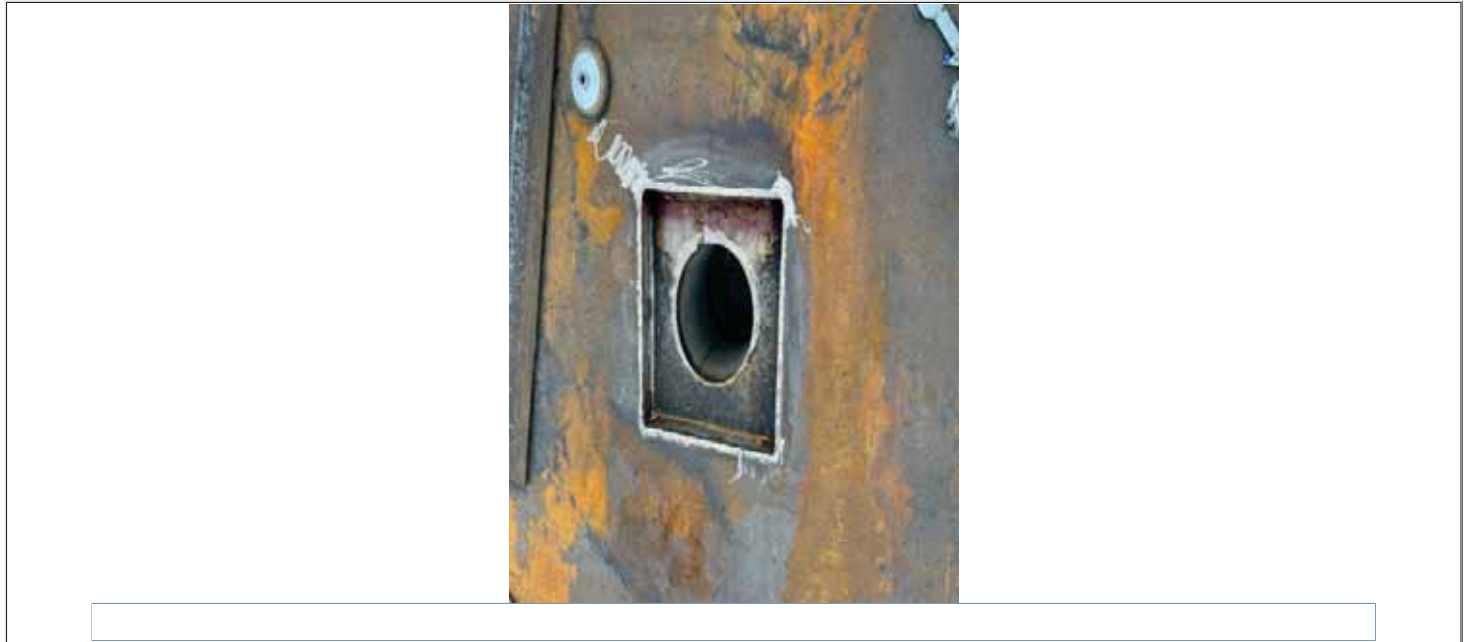






# Liquid penetrant testing Prøving med penetrerende væske

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-02</b>	REPORT NO. / RAPPORT NR. <b>10031-23-PT-9</b>	PAGE / SIDE <b>3 of/av 3</b>
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NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baci (2304-PT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baci (2304-PT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-27 <b>Approved / Godkjent</b> <i>Doru Baci</i>	OPERATOR / OPERATØR DATO:2023-07-27 <i>Doru Baci</i>





# Liquid penetrant testing Prøving med penetrerende væske

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhoy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-PT-10</b>	PAGE / SIDE <b>2 of/av 3</b>
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# Liquid penetrant testing Prøving med penetrerende væske

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-06-13</b>	REPORT NO. / RAPPORT NR. <b>10031-23-PT-10</b>	PAGE / SIDE <b>3 of/av 3</b>
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**A DECKSEGMENT AKSE 3-4**

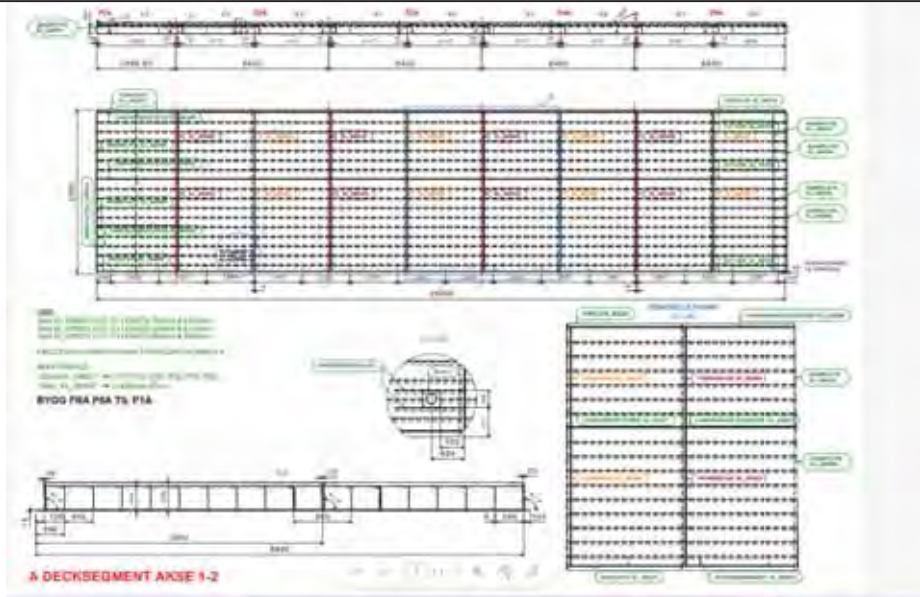
NAME CERT. NO. / NAVN SERT. NR. ( )	N2 NAME CERT. NO. / N2 NAVN SERT. NR. Doru Baciu (2304-PT)	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. Doru Baciu (2304-PT)
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-07-27 <b>Approved / Godkjent</b> <i>Doru Baciu</i>	OPERATOR / OPERATØR DATO:2023-07-27 <i>Doru Baciu</i>





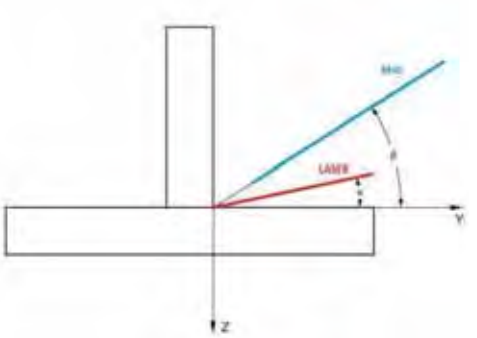
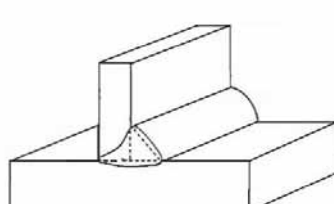
# Liquid penetrant testing Prøving med penetrerende væske

CLIENT / KUNDE <b>Prodtex industri as</b>	CLIENT O.NO / KUNDE O.NR <b>20021 - Elverhøy</b>	DATE OF TESTING / KONTROLLDATO <b>2023-07-17</b>	REPORT NO. / RAPPORT NR. <b>10031-23-PT-11</b>	PAGE / SIDE <b>2 of/av 2</b>
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NAME CERT. NO. / NAVN SERT. NR. <b>()</b>	N2 NAME CERT. NO. / N2 NAVN SERT. NR. <b>Ramona Bindiu (1815-PT)</b>	OPERATOR NAME CERT. NO. / OPERATØR NAVN SERT. NR. <b>Ramona Bindiu (1815-PT)</b>
APPROVED / GODKJENT DATO:	APPROVED / GODKJENT DATO:2023-08-31 <b>Approved / Godkjent</b> <i>Ramona Bindiu</i>	OPERATOR / OPERATØR DATO:2023-08-31 <i>Ramona Bindiu</i>



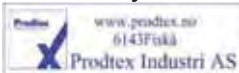
Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>									
Location: Fiskå													
Welding process:	1	135+52 (Laser Hybrid)		2		3							
Shielding gas type:		M12-Arc2											
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range[mm]						
	A	S420J5W M	EN 10029 Class A	2.1	TM	6,4 - 8	NA						
	B	S420J5W M	EN 10029 Class A	2.1	TM	16	NA						
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment							
	I	Sidergas Cor	EN ISO 14341-A: G 46 4 M21 Z	2.2	1,2	-							
	NA	-	-	-	-	-							
Equipment identification	Welding unit (device)		Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics						
	Fanuc M-20iA-35M		0,6	Fronius	Trumpf trudisk10002 fiberlaser	Fronius TPSI 500i	Trumpf Optics						
Joint design				Sketch process			Joint type	T					
							Joint preparation	Flat					
 <p>Rootface: 0    Rootgap:0    Groove angle:0</p>							Single/double side	Single					
							Welding Positions	PB					
							Gouging method	NA					
							Cleaning method	Sandblast					
							Backing	NA					
							Purging gas type	NA					
							Flux	NA					
							Flux treatment	NA					
							Weaving	NA					
							Tack welding	Yes					
							Mechanical clamping	NA					
							Preheat min: 50 °C		Heating rate: NA			PWHT min: NA    max: NA	
							Interpass temp: NA		Cooling rate: NA			Temp. control: Digital	
							Non - Destructive Testing:						
VT: 100%    UT:-    RT: -    MT: 100%    PT: -													



Welding parameters	Unit	1'st pass	2'nd pass	3'rd pass
Welding position		PB	NA	NA
Shielding gas		Arcal Chrome		Ar + CO <sub>2</sub> 2 % ±0,5 %
-Classification and type		ISO 14175-M12-ArC-2		
-gas flow	l/min	20	NA	NA
Torch arrangement		Leading Wire	NA	NA
Beam power at the workpiece				
-Continuous	W	9000	NA	NA
Power ramping details				
-slope up	mm	NA	NA	NA
-overlap	mm	NA	NA	NA
-slope down	mm	NA	NA	NA
-slope profile		NA	NA	NA
Geometrical parameters				
- Beam angle transverse	° deg.	13,4	NA	NA
- Beam angle longitudinal	° deg.	32,8	NA	NA
- Distance beam-wire	mm	2	NA	NA
-Focus position	mm	314	NA	NA
-Beam position	mm	1	NA	NA
Welding speed	m/min	1,2	NA	NA
Arc parameters				
-mode polarity		DC+	NA	NA
-wire feed rate	m/min	9	NA	NA
-current	A	207	NA	NA
-voltage level	V	24,8	NA	NA
-stick out wire	mm	15	NA	NA
-pulse dynamic corr.		10	NA	NA
-arc length corr.		2,4	NA	NA
Nominal Heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,21 – 0,29	NA	NA

Comments:-

Produced by: Prodtex



Date: 17.01.2023

Approved by:

Ödön Bogdan Bindiu

Date: 17.01.2023

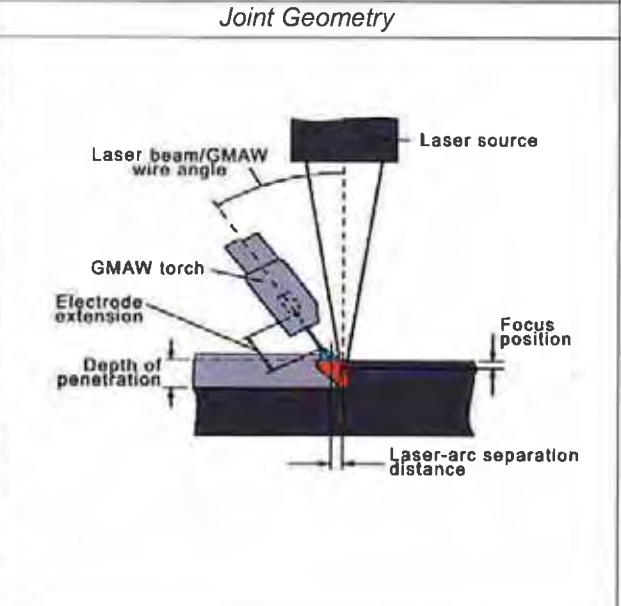
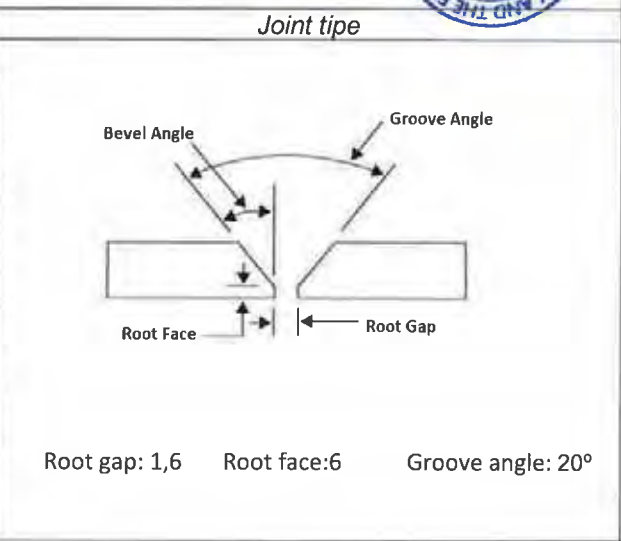


*Bindiu*  
Sign

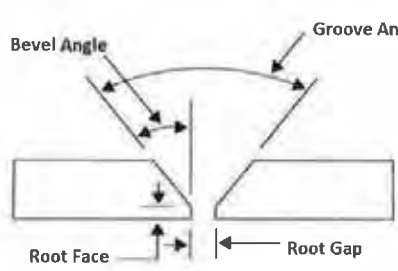
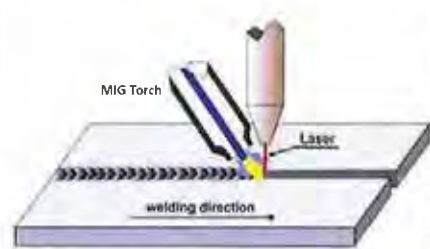
Date: 25.11.2022	Test nr: 033-LH-BW-16	Welding position: PA	Welding process: 135+52 Laser Hybrid	Client: <b>Prodtex Industri AS</b>
Filler material:	Batch no.	size	Material A	Material B
Sidergas	555109	1,2 mm	Material thickness: 16mm	Material thickness: 16mm
Test Length	800		Material grade: 420ML	Material grade: 420ML
			Heat no: 59159-041	Heat no: 59159-041
Operator: Geir Jonny Nakken		Logged by IWE: Ödön Bogdan Bindiu	Witnessed by DNV: Geir Bergli	



Welding parameters				
	Unit	1'st run	2'nd run	
1	Welding position		PA	PA
2	Torch arrangement		Leading Wire	Leading Wire
3	Beam power at workpiece			
	-Continuous	W	10 000	3 000
4	Power ramping details			
	-slope up	mm	-	-
	-overlap	mm	-	-
	-slope down	mm	-	-
	-slope profile		-	-
5	Geometrical parameters			
	- Beam angle transverse	deg	90	90
	- Beam angle longitudinal	deg	5	5
	- Distance beam-wire	mm	3	3
	-Focus position	mm	313	313
	-Beam position	mm	0	0
6	Welding speed	m/min	1,1	0,7
7	Arc parameters			
	-mode polarity		DC+	DC+
	-wire feed rate	m/min	13	14
	-current	A	331	347
	-voltage level	V	20,9	21,1
	-stick out wire	mm	15	15
	-pulse dynamic corr.		-10	-10
	-arc length corr.		-10	-10
8	Shielding gas			
	-Classification and type		M12-ARC-2	M12-ARC-2
	-gas flow	l/min	20	20
	Interpas Temp (preheat)	°C	12°	69°



**Comments:**  
Material is not delivered with certificate acc. To EN 10 204 – 3.1. Test plate information delivered from SSAB.

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>			
Location							
Welding process:	1	135 +52 (Laser Hybrid)		2		3	
Shielding gas type:	M12-ARC-2						
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Heat no.
	A	420ML	SSAB Weathering 420ML	2.1	TM	16	59159-041
	B	420ML	SSAB Weathering 420ML	2.1	TM	16	59159-041
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment	
	I	Sidergas Cor	EN ISO 14341-A: G 46 4 M21 Z	2.2	1,2		
Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics	
	Fanuc M-20iA-35M	0,6mm	Fronius	Trumpf trudisk 10002 fiberlaser	Fronius TPSI 500i	Trumpf Optics	
Geometry	Joint design			Joint type	BW		
						Joint preparation	V
Rootface:6 Rootgap:1,6 Groove angle: 20°			Single/double side		S		
			Welding Positions		PA		
			Gouging method		NA		
			Cleaning method		<b>Grinding</b>		
			Backing		NA		
			Purging gas type		NA		
			Flux		NA		
			Flux treatment		NA		
			Weaving		NA		
			Tack welding proc.		NA		
Mechanical clamping		Yes					
Preheat min: 12°C		Heating rate: -		PWHT min: - max:-			
Interpass max: 69°C		Cooling rate: -		Temp. control: Digital			
Non - Destructive Testing: VT: 100%    UT: 100%    RT: -    MT: 100%    PT:-				Destructive Testing: Macro/ Hardness: Yes    Mechanical: Yes			

Welding parameters					
		Unit	Tacking pass	1'st pass	2'nd pass
1	Welding position			PA	PA
2	Torch arrangement			Leading Wire	Leading Wire
3	Beam power at work piece				
	-Continuous	W		10 000	3 000
4	Power ramping details				
	-slope up	mm		NA	NA
	-overlap	mm		NA	NA
	-slope down	mm		NA	NA
	-slope profile			NA	NA
5	Geometrical parameters				
	- Beam angle transverse	° deg.		90	90
	- Beam angle longitudinal	° deg.		5	5
	- Distance beam-wire	mm		3	3
	-Focus position	mm		313	313
	-Beam position	mm		0	0
6	Welding speed	m/min		1,1	0,7
7	Arc parameters				
	-mode polarity			DC+	DC+
	-wire feed rate	m/min		13	14
	-current	A		331	347
	-voltage level	V		20,9	21,1
	-stick out wire	mm		15	15
	-pulse dynamic corr.			-10	-10
	-arc length corr.			-10	-10
8	Shielding gas			Arcal Chrome	Ar + CO <sub>2</sub> 2 % ±0,5 %
	-Classification and type			ISO 14175-M12-ArC-2	
	-gas flow	l/min		20	20
9	Nominal Heat input	Kj/mm		0,37	0,63
	$Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$				

**Comments:**

Material is not delivered with certificate acc. To EN 10 204 – 3.1. Test plate information delivered from SSAB.

**Produced by: Prodtex**

IWE Odön Bogdan Bindiu

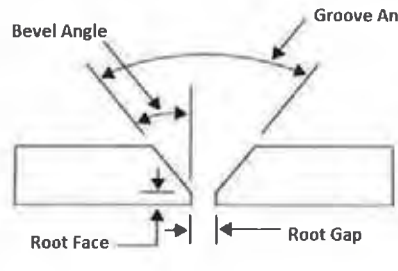
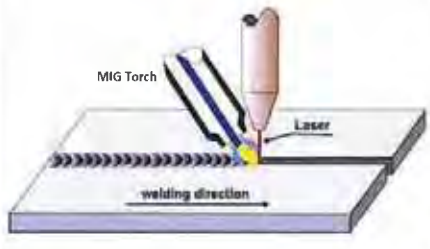
Date: 20.12.2022



*Bindiu*  
Sign:





Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>			
Location							
Welding process:	1	135+52 (Laser Hybrid)		2		3	
Shielding gas type:		M12-ARC-2					
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]
	A	420ML	SSAB Weathering 420ML	2.1	TM	12,8 - 16	>150
	B	420ML	SSAB Weathering 420ML	2.1	TM	12,8 - 16	>150
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment	
	I	Sidergas Cor	EN ISO 14341-A: G 46 4 M21 Z	2.2	1,2	-	
Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics	
	Fanuc M-20iA-35M	0,6mm	Fronius	Trumpf trudisk 10002 fiberlaser	Fronius TPSI 500i	Trumpf Optics	
Geometry			Joint design			Joint type	BW
						Joint preparation	V
						Single/double side	S
<p>Rootface:6    Rootgap:1,6    Groove angle: 20°</p>						Welding Positions	PA
						Gouging method	NA
						Cleaning method	Grinding
						Backing	NA
						Purging gas type	NA
						Flux	NA
						Flux treatment	NA
						Weaving	NA
						Tack welding proc.	NA
						Mechanical clamping	Yes
Preheat min: 12°C		Heating rate: -		PWHT min: -                      max:-			
Interpass max: 69°C		Cooling rate: -		Temp. control: Digital			
Non - Destructive Testing:							
VT: 100%	UT: 100%	RT: -	MT: 100%	PT:-			

Welding parameters	Unit	1'st pass	2'nd pass	3'rd pass
Welding position		PA	PA	NA
Shielding gas		Arcal Chrome		Ar + CO <sub>2</sub> 2 % ±0,5 %
-Classification and type		ISO 14175-M12-ArC-2		
-gas flow	l/min	20	20	NA
Torch arrangement		Leading Wire	Leading Wire	NA
Beam power at the workpiece				
-Continuous	W	10000	3000	NA
Power ramping details				
-slope up	mm	NA	NA	NA
-overlap	mm	NA	NA	NA
-slope down	mm	NA	NA	NA
-slope profile		NA	NA	NA
Geometrical parameters				
- Beam angle transverse	° deg.	90	90	NA
- Beam angle longitudinal	° deg.	5	5	NA
- Distance beam-wire	mm	3	3	NA
-Focus position	mm	313	313	NA
-Beam position	mm	0	0	NA
Welding speed	m/min	1,1	0,7	NA
Arc parameters				
-mode polarity		DC+	DC+	NA
-wire feed rate	m/min	13	14	NA
-current	A	331	347	NA
-voltage level	V	20,9	21,1	NA
-stick out wire	mm	15	15	NA
-pulse dynamic corr.		-10	-10	NA
-arc length corr.		-10	-10	NA
Nominal Heat input range $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,37 +- 15% valid	0,63 +- 15% valid	NA

Comments:-

Produced by: Prodtex

IWE Ödön Bogdan Bindu

Date: 20.12.2022



Sign  
Bindu



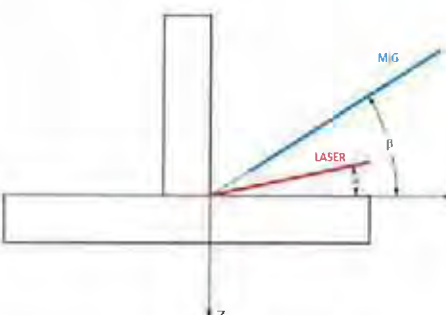
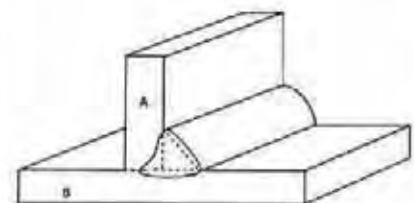
Produced by: Prodtex Industri AS Project: General Client: **Prodtex Industri AS**  
Location: Fiskå

Welding process:	1	135+52 (Laser Hybrid)	2		3	
Shielding gas type:		M12-Arc2				

Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]
	A	S420J5W M	EN 10025-5:2019	2.1	TM	12,8 - 16	NA
	B	S420J5W M	EN 10025-5:2019	2.1	TM	12,8 - 16	NA

Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment
	I	Sidergas Cor	EN ISO 14341-A: G 46 4 M21 Z	2.2	1,2	-
	NA	-	-	-	-	-

Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics
	Fanuc M-20iA-35M	0,6	Fronius	Trumpf trudisk10002 fiberlaser	Fronius TPSI 500i	Trumpf Optics

Joint design	Sketch process	Joint type	Filler
 <p>Rootface:      Rootgap:0      Groove angle:</p>		Joint preparation	Flat
		Single/double side	Single
		Welding Positions	PB
		Gouging method	NA
		Cleaning method	Sandblast
		Backing	NA
		Purging gas type	NA
		Flux	NA
		Flux treatment	NA
		Weaving	NA
		Tack welding	Yes
		Mechanical clamping	NA

Preheat min: 12 °C	Heating rate: NA	PWHT min: NA	max: NA
Interpass temp: NA	Cooling rate: NA	Temp. control: Digital	

Non - Destructive Testing:  
VT: 100%      UT:-      RT: -      MT: 100%      PT: -



Welding parameters	Unit	1'st pass	2'nd pass	3'rd pass
Welding position		PB	NA	NA
Shielding gas		Arcal Chrome Ar + CO <sub>2</sub> 2 % ±0,5 %		
-Classification and type		ISO 14175-M12-ArC-2		
-gas flow	l/min	20	NA	NA
Torch arrangement		Leading Wire	NA	NA
Beam power at the workpiece				
-Continuous	W	8000	NA	NA
Power ramping details				
-slope up	mm	NA	NA	NA
-overlap	mm	NA	NA	NA
-slope down	mm	NA	NA	NA
-slope profile		NA	NA	NA
Geometrical parameters				
- Beam angle transverse	° deg.	12,3	NA	NA
- Beam angle longitudinal	° deg.	8	NA	NA
- Distance beam-wire	mm	2	NA	NA
-Focus position	mm	324	NA	NA
-Beam position	mm	0	NA	NA
Welding speed	m/min	1,2	NA	NA
Arc parameters				
-mode polarity		DC+	NA	NA
-wire feed rate	m/min	10,3	NA	NA
-current	A	286	NA	NA
-voltage level	V	24	NA	NA
-stick out wire	mm	15	NA	NA
-pulse dynamic corr.		+2	NA	NA
-arc length corr.		-3	NA	NA
Nominal Heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,34 Valid +- 15%	NA	NA

Comments:- Partial Penetration s, minimum=7mm

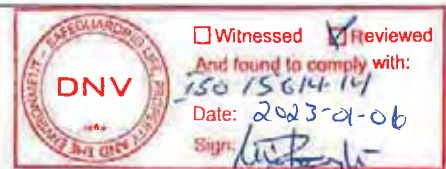
Produced by: Prodtex

IWE Odön Bogdan Bindeu

Date: 19.12.2022



Sign: *Bogdan Bindeu*

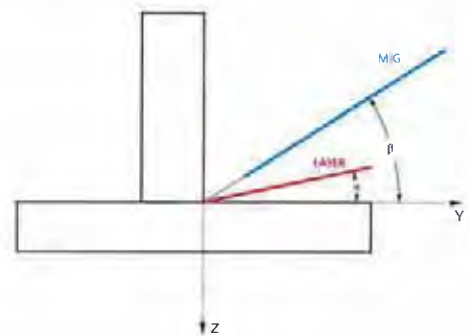


Date: 25.11.2022	Test nr: 035-LH-T162	Welding position: PB	Welding process: 135 +52	Client: Prodtex Industri AS
Filler material: Sidergas Cor	Lot no. 555109	size 1,2 mm	<b>Material A</b> Material thickness: 20 mm Material grade: S420J5W M	<b>Material B</b> Material thickness: 16 mm Material grade: S420J5W M
Test Length 800			Heat no: 20503	Heat no: 20505
Operator: Mathias Marstøl			Logged by IWE: Ödön Bogdan Bindiu	Witnessed by DNV: Geir Berpli



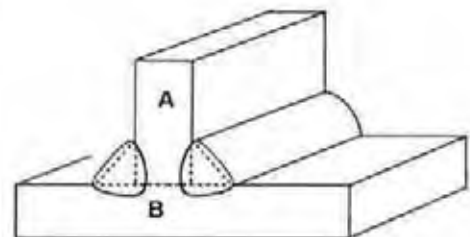
Welding parameters				
	Unit	1'st side	2'nd side	
1	Welding position		PB	PB
2	Torch arrangement		Leading Wire	Leading Wire
3	Beam power at workpiece			
	-Continuous	W	10000	10000
4	Power ramping details			
a	-slope up	mm	-	-
b	-overlap	mm	-	-
c	-slope down	mm	-	-
d	-slope profile		-	-
5	Geometrical parameters			
a	- Beam angle transverse	° deg.	12,3	12,3
b	- Beam angle longitudinal	° deg.	27,5	27,5
c	- Distance beam-wire	mm	2	2
d	-Focus position	mm	324	324
e	-Beam position	mm	0	0
6	Welding speed	m/min	1,2	1,2
7	Arc parameters			
a	-mode polarity		DC+	DC+
b	-wire feed rate	m/min	10,2	10,2
c	-current	A	252	251,9
d	-voltage level	V	24,7	24,2
e	-stick out wire	mm	20	20
f	-pulse dynamic corr.		+2	+2
g	-arc length corr.		-3	-3
8	Shielding gas			
a	-Classification and type		M12-ARC-2	M12-ARC-2
b	-gas flow	l/min	20	20
	Interpas Temp (preheat)	*C	12 °	75 °

### Joint tipe

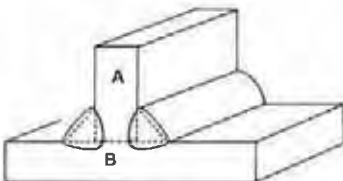
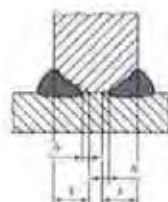
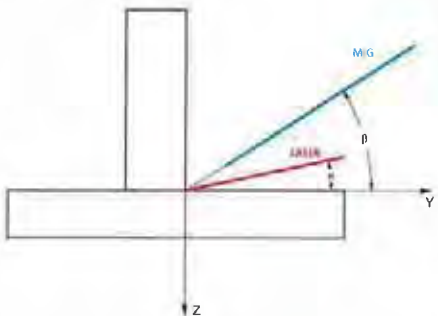


Root gap: 0      Root face: 0  
Groove angle: 0

### Joint Geometry



### Comments:

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>			
Location: Fiskå							
Welding process:	1	135+52 (Laser hybrid)		2		3	
Shielding gas type:	M12-Arc2						
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Heat no.
	A	S420J5W M	EN 10025-5:2019	2.1	TM	20	20503
	B	S420J5W M	EN 10025-5:2019	2.1	TM	16	20505
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment	
	I	Sidergas Cor	EN ISO 14341-A: G 46 4 M21 Z	2.2	1,2	-	
	NA	-	-	-	-	-	
Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics	
	Fanuc M-20iA-35M	0,6	Fronius	Trumpf trudisk10002 fiberlaser	Fronius TPSI 500i	Trumpf Optics	
Joint design				  <small>T joint (partial penetration - double-side welding)</small>		Joint type	Fillet
						Joint preparation	Flat
 Rootface:      Rootgap:0      Groove-angle:				Single/double side	DS		
				Welding Positions	PB		
				Gouging method	NA		
				Cleaning method	Sandblast		
				Backing	NA		
				Purging gas type	NA		
				Flux	NA		
				Flux treatment	NA		
				Weaving	NA		
				Tack welding.	Yes		
Mechanical clamping	NA						
1'st run temp. min: 12 °C		Heating rate: NA		PWHT min: NA      max:NA			
2'nd run temp. max: 75 °C		Cooling rate: NA		Temp. control: Digital			
Non - Destructive Testing: VT: 100%      UT: -      RT: -      MT: 100%      PT:				Destructive Testing: Macro/ Hardness: Yes      Mechanical: Yes			



Welding parameters					
		Unit	Tacking pass	1'st side	2'nd side
1	Welding position			PB	PB
2	Torch arrangement			Leading Wire	Leading Wire
3	Beam power at workpiece (P)				
	-Continuous	W		10000	10000
4	Power ramping details				
	-slope up	mm		-	-
	-overlap	mm		-	-
	-slope down	mm		-	-
	-slope profile			-	-
5	Geometrical parameters				
	- Beam angle transverse	° deg.		12,3	12,3
	- Beam angle longitudinal	° deg.		27,5	27,5
	- Distance beam-wire	mm		2	2
	-Focus position	mm		324	324
	-Beam position	mm		0	0
6	Welding speed	m/min		1,2	1,2
7	Arc parameters				
	-mode polarity			DC+	DC+
	-wire feed rate	m/min		10,2	10,2
	-current	A		252	251,9
	-voltage level	V		24,7	24,2
	-stick out wire	mm		20	20
	-pulse dynamic corr.			+2	+2
	-arc length corr.			-3	-3
8	Shielding gas		EN ISO 14175-M12-ArC-2 / Arcal Chrome	Ar + CO <sub>2</sub> 2 % ±0,5 %	
	-Classification and type			M12- Arc2	M12- Arc2
	-gas flow	l/min		20	20
	Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm		0,31	0,30

**Comments:-**

*Partial penetration s, minimum 7mm*

Produced by: Prodtex Industry AS

IWE: Ödön Bogdan Birtiu



Date: 20.12.2022

*Birtiu*



Witnessed  Reviewed  
And found to comply with:  
15614-14  
Date: 2022.12.23  
Sign: *[Signature]*

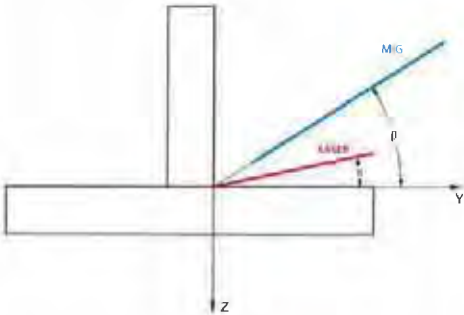
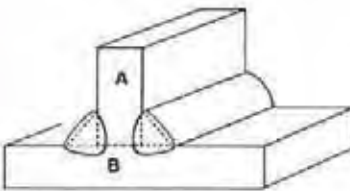
Produced by: Prodtex Industri AS Project: General Client: **Prodtex Industri AS**  
Location: Fiskå

Welding process:	1	135+52 (Laser Hybrid)	2		3	
Shielding gas type:		M12-Arc2				

Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]
	A	S420J5W M	EN 10025-5:2019	2.1	TM	20	NA
	B	S420J5W M	EN 10025-5:2019	2.1	TM	16	NA

Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment
	I	Sidergas Cor	EN ISO 14341-A: G 46 4 M21 Z	2.2	1,2	-
	NA	-	-	-	-	-

Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics
	Fanuc M-20iA-35M	0,6	Fronius	Trumpf trudisk10002 fiberlaser	Fronius TPSI 500i	Trumpf Optics

Joint design	Sketch process	Joint type	Fillet
 <p>Rootface:      Rootgap:0      Groove angle:</p>		Joint preparation	Flat
		Single/double side	DS
		Welding Positions	PB
		Gouging method	NA
		Cleaning method	Sandblast
		Backing	NA
		Purging gas type	NA
		Flux	NA
		Flux treatment	NA
		Weaving	NA
		Tack welding	Yes
		Mechanical clamping	NA

Preheat min: 12 °C	Heating rate: NA	PWHT min: NA	max: NA
Interpass temp: 75 °C	Cooling rate: NA	Temp. control: Digital	

Non - Destructive Testing:  
VT: 100%      UT:-      RT: -      MT: 100%      PT:-

Welding parameters	Unit	1'st side	2'nd side	3'rd pass
Welding position		PB	PB	NA
Shielding gas		Arcal Chrome Ar + CO <sub>2</sub> 2 % ±0,5 %		
-Classification and type		ISO 14175-M12-ArC-2		
-gas flow	l/min	20	20	NA
Torch arrangement		Leading Wire	Leading Wire	NA
Beam power at the workpiece				
-Continuous	W	10000	10000	NA
Power ramping details				
-slope up	mm	NA	NA	NA
-overlap	mm	NA	NA	NA
-slope down	mm	NA	NA	NA
-slope profile		NA	NA	NA
Geometrical parameters				
- Beam angle transverse	° deg.	12,3	12,3	NA
- Beam angle longitudinal	° deg.	27,5	27,5	NA
- Distance beam-wire	mm	2	2	NA
-Focus position	mm	324	324	NA
-Beam position	mm	0	0	NA
Welding speed	m/min	1,2	1,2	NA
Arc parameters				
-mode polarity		DC+	DC+	NA
-wire feed rate	m/min	10,2	10,2	NA
-current	A	252	251,9	NA
-voltage level	V	24,7	24,2	NA
-stick out wire	mm	20	20	NA
-pulse dynamic corr.		+2	+2	NA
-arc length corr.		-3	-3	NA
Nominal Heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,31	0,30	NA

Comments:- partial penetration s, minimum 7mm

Produced by: Prodtex

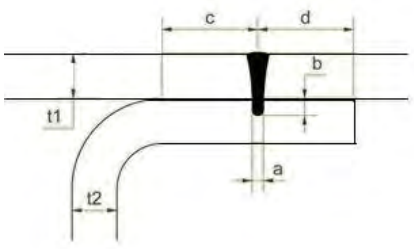
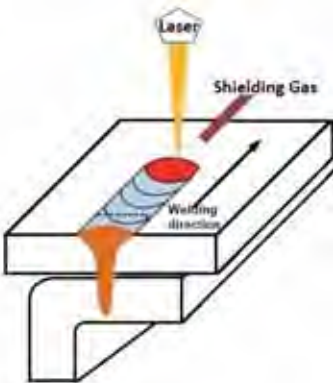
IWE Odön Bogdan Binciu

Date: 20.12.2022



Sign  
Binciu



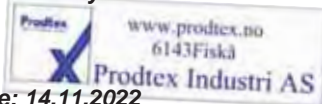
Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>																													
Location: Fiskå																																	
Welding process:	1	52	2		3																												
Shielding gas type:		M12-Arc-2																															
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Depth of penetration [mm]																										
	A	S420J5W M	EN 10029 Class A	2.2	TM	6,8 – 9,2	6,8 – 9,2																										
	B	S420J5W M	EN 10029 Class A	2.2	TM	6,8 – 9,2	2																										
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment																											
	NA	-	-	-	-	-	-																										
	NA	-	-	-	-	-	-																										
Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics																											
	Fanuc M-20iA-35M	0,6	Fronius	Trumpf trdisk10002 fiberlaser	NA	Trumpf Optics																											
Joint design			Sketch process		<table border="1"> <tr><td>Joint type</td><td>LW</td></tr> <tr><td>Joint preparation</td><td>Flat</td></tr> <tr><td>Single/double side</td><td>Single</td></tr> <tr><td>Welding Positions</td><td>PA</td></tr> <tr><td>Gouging method</td><td>NA</td></tr> <tr><td>Cleaning method</td><td>Sandblast</td></tr> <tr><td>Backing</td><td>NA</td></tr> <tr><td>Purging gas type</td><td>NA</td></tr> <tr><td>Flux</td><td>NA</td></tr> <tr><td>Flux treatment</td><td>NA</td></tr> <tr><td>Weaving</td><td>NA</td></tr> <tr><td>Tack welding proc.</td><td>NA</td></tr> <tr><td>Mechanical clamping</td><td>Yes</td></tr> </table>			Joint type	LW	Joint preparation	Flat	Single/double side	Single	Welding Positions	PA	Gouging method	NA	Cleaning method	Sandblast	Backing	NA	Purging gas type	NA	Flux	NA	Flux treatment	NA	Weaving	NA	Tack welding proc.	NA	Mechanical clamping	Yes
Joint type	LW																																
Joint preparation	Flat																																
Single/double side	Single																																
Welding Positions	PA																																
Gouging method	NA																																
Cleaning method	Sandblast																																
Backing	NA																																
Purging gas type	NA																																
Flux	NA																																
Flux treatment	NA																																
Weaving	NA																																
Tack welding proc.	NA																																
Mechanical clamping	Yes																																
 <p>Plates gap: 0 - 1.5 mm</p>																																	
1'st run temp. min: 20 °C		Heating rate: NA		PWHT min: NA max:NA																													
2'nd run temp. max: NA		Cooling rate: NA		Temp. control: Digital																													
Non - Destructive Testing: VT: 100%      UT:100%      RT: -      MT: -      PT: -																																	



Welding parameters	Unit	1'st pass	2'nd pass	3'rd pass
Welding position		PA	NA	NA
Shielding gas		Arcal Chrome		Ar + CO <sub>2</sub> 2 % ±0,5 %
-Classification and type		ISO 14175-M12-ArC-2		
-gas flow	l/min	20	NA	NA
Depth of penetration				
A	mm	8	NA	NA
B	mm	2	NA	NA
Torch arrangement		Laser	NA	NA
Beam power at the workpiece				
-Continuous	W	10 000	NA	NA
Power ramping details				
-slope up	mm	NA	NA	NA
-overlap	mm	NA	NA	NA
-slope down	mm	NA	NA	NA
-slope profile		NA	NA	NA
Geometrical parameters				
- Beam angle transverse	° deg.	90	NA	NA
- Beam angle longitudinal	° deg.	5	NA	NA
- Distance beam-wire	mm	NA	NA	NA
-Focus position	mm	313	NA	NA
-Beam position	mm	0	NA	NA
Welding speed	m/min	1	NA	NA
Arc parameters				
-mode polarity		NA	NA	NA
-wire feed rate	m/min	NA	NA	NA
-current	A	NA	NA	NA
-voltage level	V	NA	NA	NA
-stick out wire	mm	NA	NA	NA
-pulse dynamic corr.		NA	NA	NA
-arc length corr.		NA	NA	NA
Nominal Heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0, 0006	NA	NA

**Comments:-**

**Produced by: Prodtex**



**Date: 14.11.2022**

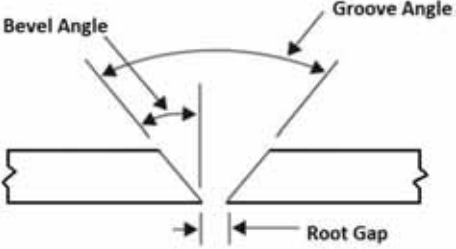
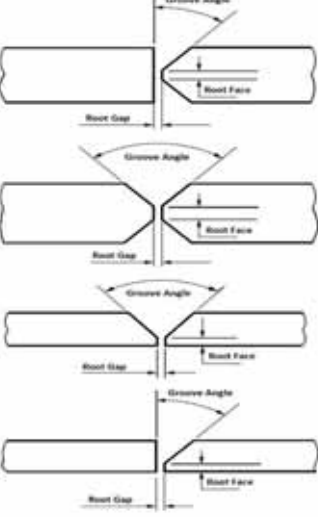
**Approved by:**



**Ödön Bogdan Bindiu**

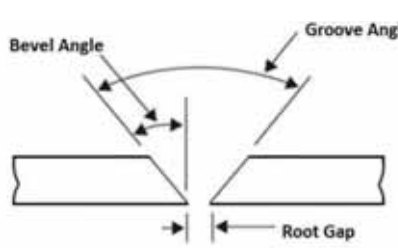
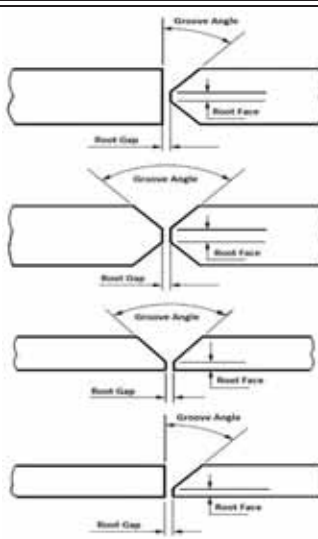
**Date: 15.11.2022**



*Bindiu*  
Sign

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>						
Location: Fiskå										
Welding process:	1	138		2	136		3	-		
Shielding gas type:		Arcal Force Ar+CO2 18% ± 1,8%			Arcal Force Ar+CO2 18% ± 1,8%			-		
Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]			
	A	S420 ML	EN 10029 Class A	2.1	TM	3 - 24	>150			
	B	S420 ML	EN 10029 Class A	2.1	TM	3 - 24	>150			
Filler Material specification	Index	Brand name	Classification	Group		Size [mm]	Filler treatment			
	I	Sidergas Cor	EN ISO 14341-A:21 G46 4 M21 Z	2,2		1,2	-			
	II	Ceweld AAR Corten	EN ISO 17632-A: T 46 2 Z P M21 H5	2,2		1,2	-			
Equipment identification	Welding unit (device)		Fiber core dia.	Beam focusing system	Laser power source	Welding power source	Focusing optics			
	KEMPI 510		NA	NA	NA	KEMPI 4000	NA			
Joint design				Geometry						
 <p>Bevel Angle Groove Angle Root Gap</p> <p>Rootface:0-5 mm    Rootgap: 3-4 mm Groove Angle: 30°±10°</p>								Joint type	BW	
				Joint preparation				V, 1/2V, X, K		
				Single/double side				S/DS		
				Welding Positions				All except PG		
				Gouging method				NA		
				Cleaning method				Sandblast		
				Backing				NA		
				Purging gas type				NA		
				Flux				NA		
				Flux treatment				NA		
				Weaving				NA		
				Tack welding proc.				NA		
				Mechanical clamping				Yes		
Preheat min: 21°C			Heating rate: -			PWHT min: NA      max: NA				
Interpass max: 75°C			Cooling rate: -			Temp. control: Digital				
Non - Destructive Testing:										
VE: 100%		UT:20%		RT: -		MT: 20%		PT: -		

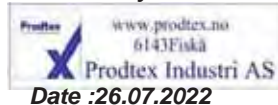
Welding parameters	Unit	1'st run	2'nd run	3'rd run	n'th run
Welding position		All except PG	All except PG	All except PG	All except PG
Process index		1	2	2	2
Filler material index		I	II	II	II
Shielding gas					
Classification and type		EN ISO 14175-M21-ArC-18 /		Arcal Force Ar+CO <sub>2</sub> 18% ± 1,8%	
-gas flow	l/min	18	18	18	18
Torch arrangement		NA	NA	NA	NA
Beam power	W	NA	NA	NA	NA
Power ramping					
-slope up	mm	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA
Geometrical parameters					
-Beam angle transverse	° deg.	NA	NA	NA	NA
-Beam angle longitudinal	° deg.	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA
Welding speed	m/min	0,1	0,2	0,25	0,2
Arc parameters					
-mode polarity		DC+	DC+	DC+	DC+
-wire feed rate	m/min	2,4 - 2,5	6 - 7	6 - 7	5,8 - 6
-current	A	98 - 102	180 - 198	178 - 200	180-200
-voltage level	V	16	21 - 22	21 - 22	21 - 22
-stick out wire	mm	17	17	17	17
-pulse dynamic corr.		NA	NA	NA	NA
-arc length corr.		NA	NA	NA	NA
Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0.73 - 0,97	0,85 - 1,41	0.67- 1,12	0,85 - 1,41
Produced by: Prodtex Industry AS Date:01.11.2022			Approved by IWE: Odón Bogdan Bindiu Date:10.11.2022		
					

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>																													
Location: Fiskå																																	
Welding process:	1	138		2	136		3																										
Shielding gas type:		Arcal Force Ar+CO <sub>2</sub> 18% ± 1,8% EN ISO 14175-M21-ArC-18			Arcal Chrome Ar + CO <sub>2</sub> 2 % ±0,5 % EN ISO 14175-M12-ArC-2																												
Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]																										
	A	S420J5W M	EN 10029 CLASS A	2.1	TM	10 - 40	>150																										
	B	S420J5W M	EN 10029 CLASS A	2.1	TM	10 - 40	>150																										
Filler Material specification	Index	Brand name	Classification	Group		Size [mm]	Filler treatment																										
	I	Sidergas Cor	EN ISO 14341-A:21 G46 4 M21 Z	2.2		1,2	-																										
	II	Ceweld AAR Corten	EN ISO 17632-A: T 46 2 Z P M21 H5	2.2		1,2	-																										
Equipment identification	Welding unit (device)		Fiber core	Beam focusing	Lasers power source	Welding power source	Focusing optics																										
	Kempi 510		NA	NA	NA	Kempi 4000	NA																										
	Fanuc M-30iB Plus		NA	NA	NA	Fronius TPS 400i	NA																										
Joint design			Geometry			<table border="1"> <tr><td>Joint type</td><td>BW</td></tr> <tr><td>Joint preparation</td><td>V, 1/2V, X, K</td></tr> <tr><td>Single/double side</td><td>S, DS</td></tr> <tr><td>Welding Positions</td><td>All except PG</td></tr> <tr><td>Gouging method</td><td>NA</td></tr> <tr><td>Cleaning method</td><td>Grinding</td></tr> <tr><td>Backing</td><td>NA</td></tr> <tr><td>Purging gas type</td><td>NA</td></tr> <tr><td>Flux</td><td>NA</td></tr> <tr><td>Flux treatment</td><td>NA</td></tr> <tr><td>Weaving</td><td>NA</td></tr> <tr><td>Tack welding proc.</td><td>NA</td></tr> <tr><td>Mechanical clamping</td><td>Yes</td></tr> </table>		Joint type	BW	Joint preparation	V, 1/2V, X, K	Single/double side	S, DS	Welding Positions	All except PG	Gouging method	NA	Cleaning method	Grinding	Backing	NA	Purging gas type	NA	Flux	NA	Flux treatment	NA	Weaving	NA	Tack welding proc.	NA	Mechanical clamping	Yes
Joint type	BW																																
Joint preparation	V, 1/2V, X, K																																
Single/double side	S, DS																																
Welding Positions	All except PG																																
Gouging method	NA																																
Cleaning method	Grinding																																
Backing	NA																																
Purging gas type	NA																																
Flux	NA																																
Flux treatment	NA																																
Weaving	NA																																
Tack welding proc.	NA																																
Mechanical clamping	Yes																																
 <p>Rootface: 0 -15mm    Rootgap: 3 - 4,2mm Groove angle: 30° ±10°</p>																																	
Preheat min: 21°C			Heating rate: -			PWHT min: -                      max:-																											
Interpass max: 75°C			Cooling rate: -			Temp. control: Digital																											
Non - Destructive Testing:																																	
VE: 100%		UT: 100%		RT: -		MT: 100%      PT:-																											

Welding parameters											
	Unit	1'st run	2'nd run	3'rd run	4'th run	5'th run	6'th run	7'th run	8'th run	9'th run	n'th run
Welding position		All except PG									
Process index		1	2	2	2	2	2	2	2	2	2
Filler material index		I	II	II	II	II	II	II	II	II	II
Shielding gas											
-Classification and type		1	2	2	2	2	2	2	2	2	2
-gas flow	l/min	18	18	18	18	18	18	18	18	18	18
Torch arrangement		NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
Beam power											
-Continous	W	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
Power ramping details											
-slope up	mm	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
Geometrical parameters											
- Beam angle transverse	° deg.	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
- Beam angle longitudinal	° deg.	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
Welding speed	m/min	0,1	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6
Arc parameters											
-mode polarity		DC+	DC+	DC+	DC+	DC+	DC+	DC+	DC+	DC+	DC+
-wire feed rate	m/min	2,2	7-10	7-10	7-10	7-10	7-10	7-10	7-10	7-10	7-10
-current	A	80-100	210-260	200-250	210-260	200-250	200-250	200-250	210-260	200-250	200-250
-voltage level	V	16-18	23-24	24-25	24-25	24-25	24-25	24-25	24-25	24-25	24-25
-stick out wire	mm	18	18-21	18-21	18-21	18-21	18-21	18-21	18-21	18-21	18-21
-pulse dynamic corr.		NA	NA	NA	NA	NA	NA	NA	NA	NA	NA
-arc length corr.		NA	-2,5	-2,5	-2,5	-2,5	-2,5	-2,5	-2,5	-2,5	-2,5
Nominal Heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,5-0,9	0,6-1,3	0,6-1,3	0,6-1,3	0,6-1,3	0,6-1,3	0,6-1,3	0,6-1,3	0,6-1,3	0,6-1,3

**Comments:** visually OK

**Produced by: Prodtex**



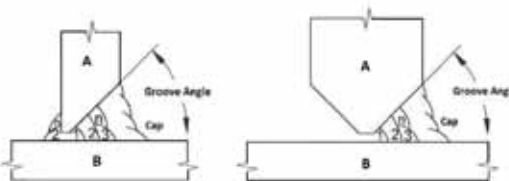
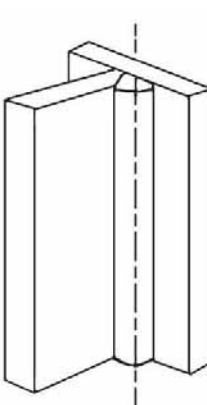
**Approved by:**


Ödön Bogdan Bindiu

Date : 28.07.2022

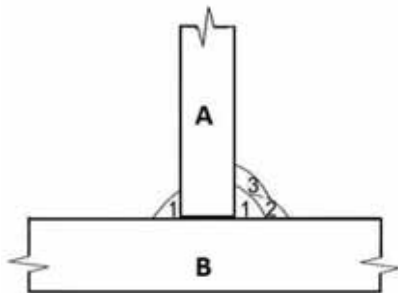
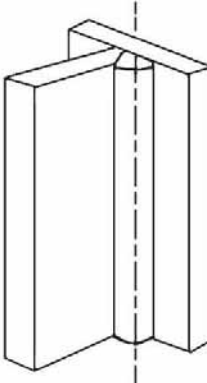





Sign

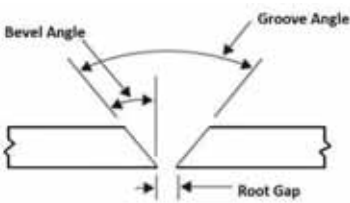
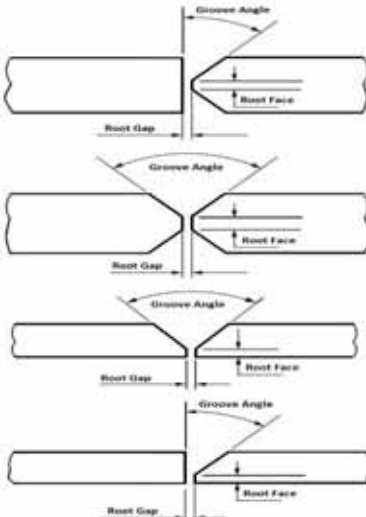
Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>			
Location: Fiskå							
Welding process:	1	138		2			3
Shielding gas type:	Arcal Force Ar+CO <sub>2</sub> 18% ± 1,8%						
		EN ISO 14175-M21-ArC-18					
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]
	A	S420J5W M	EN 10029 Class A	2.1	TM	10 - 40	NA
	B	S420J5W M	EN 10029 Class A	2.1	TM	10 - 40	NA
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment	
	I	Sidergas Cor	EN ISO 14341-A:21 G46 4 M21 Z	2,2	1,2	-	
						-	
Equipment identification	Welding unit (device)		Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics
	KEMPI 510		NA	NA	NA	KEMPI 4000	NA
	Fanuc M-30iB Plus		NA	NA	NA	Fronius TPS 400i	NA
Joint design			Sketch process				
 <p>Groove Angle: 0° - 40°    Rootface:0-15 mm Rootgap: 0-4 mm</p>							
			Joint type		T		
			Joint preparation		K, 1/2V		
			Single/double side		S / D		
			Welding Positions		All except PG		
			Gouging method		NA		
			Cleaning method		Sandblast		
			Backing		NA		
			Purging gas type		NA		
			Flux		NA		
			Flux treatment		NA		
			Weaving		NA		
			Tack welding proc.		NA		
			Mechanical clamping		Yes		
Preheat min: 21°C			Heating rate: -		PWHT min: NA                      max: NA		
Interpass max: 75°C			Cooling rate: -		Temp. control: Digital		
Non - Destructive Testing:							
VE: 100%                      UT:-                      RT: -                      MT: 20%                      PT: -							



Welding parameters	Unit	1'st run	2'nd run	3'rd run	n'th run
Welding position		All except PG	All except PG	All except PG	All except PG
Process index		1	1	1	1
Filler material index		I	I	I	I
Shielding gas					
Classification and type		2	2	2	2
-gas flow	l/min	18	18	18	18
Torch arrangement		NA	NA	NA	NA
Beam power	W	NA	NA	NA	NA
Power ramping					
-slope up	mm	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA
Geometrical parameters					
-Beam angle transverse	° deg.	NA	NA	NA	NA
-Beam angle longitudinal	° deg.	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA
Welding speed	m/min	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6
Arc parameters					
-mode polarity		DC+	DC+	DC+	DC+
-wire feed rate	m/min	7 - 10	7 - 10	7 - 10	7 - 10
-current	A	200 - 260	200 - 280	210 - 260	200-250
-voltage level	V	22 - 24	22 - 24	22 - 24	22 - 24
-stick out wire	mm	18 - 21	18 - 21	18 - 21	18 - 21
-pulse dynamic corr.		NA	NA	NA	NA
-arc length corr.		NA	NA	NA	NA
Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,6 - 1,3	0,6 - 1,3	0,6 - 1,3	0,6 - 1,3
Produced by: Prodtex Industry AS Date: 21.11.2022 			Approved by IWE: Ödön Bogdan Bindiu Date: 20.03.2023  		

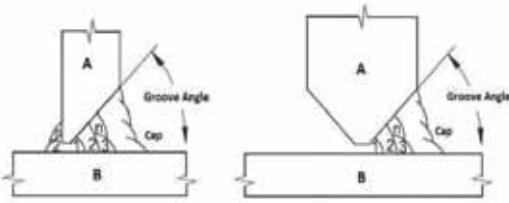
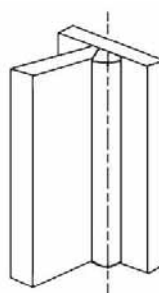


Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>				
Location: Fiskå								
Welding process:	1	136		2			3	
Shielding gas type:	Arcal Chrome Ar + CO <sub>2</sub> 2 % ±0,5 %		EN ISO 14175-M12-ArC-2					
Material specification	Part	Name/Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]	
	A	S420J5W M	EN 10029 Class A	2.1	TM	3 - 40	NA	
	B	S420J5W M	EN 10029 Class A	2.1	TM	3 - 40	NA	
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment		
	I	Ceweld AAR Corten	EN ISO 17632-A: T 46 2 Z P M21 H5	2,2	1,2	-		
	-	-	-	-	-	-		
Equipment identification	Welding unit (device)		Fiber core diameter	Beam focusing system	Lasere power source	Welding power source	Focusing optics	
	KEMPI 510		NA	NA	NA	KEMPI 4000	NA	
	Fanuc M-30iB Plus		NA	NA	NA	Fronius TPS 400i	NA	
Joint design			Sketch process					
 <p>Groove Angle: 0° Rootface:- Rootgap: 0-1 mm</p>							Joint type	FW
							Joint preparation	T,
							Single/double side	S / D
							Welding Positions	All except PG
							Gouging method	NA
							Cleaning method	Sandblast
							Backing	NA
							Purging gas type	NA
							Flux	NA
							Flux treatment	NA
							Weaving	NA
							Tack welding proc.	NA
							Mechanical clamping	Yes
Preheat min: 21°C		Heating rate: -			PWHT min: NA max: NA			
Interpass max: 75°C		Cooling rate: -			Temp. control: Digital			
Non - Destructive Testing:								
VE: 100% UT:- RT: - MT: 20% PT: -								

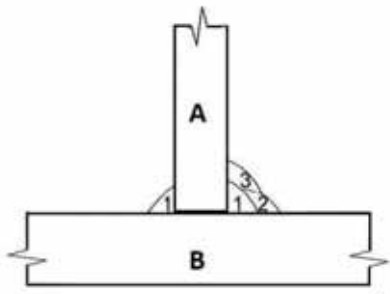
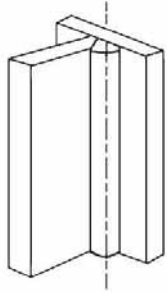
Welding parameters	Unit	1'st run	2'nd run	3'rd run	n'th run
Welding position		All except PG	All except PG	All except PG	All except PG
Process index		1	1	1	1
Filler material index		I	I	I	I
Shielding gas					
Classification and type		2	2	2	2
-gas flow	l/min	18	18	18	18
Torch arrangement		NA	NA	NA	NA
Beam power	W	NA	NA	NA	NA
Power ramping					
-slope up	mm	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA
Geometrical parameters					
-Beam angle transverse	° deg.	NA	NA	NA	NA
-Beam angle longitudinal	° deg.	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA
Welding speed	m/min	0,2-0,6	0,2-0,6	0,2-0,6	0,2-0,6
Arc parameters					
-mode polarity		DC+	DC+	DC+	DC+
-wire feed rate	m/min	7 - 10	7 - 10	7 - 10	7 - 10
-current	A	200 - 260	200 - 260	210 - 260	200-250
-voltage level	V	22 - 24	22 - 24	22 - 24	22 - 24
-stick out wire	mm	18 - 21	18 - 21	18 - 21	18 - 21
-pulse dynamic corr.		NA	NA	NA	NA
-arc length corr.		NA	NA	NA	NA
Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0,6 - 1,3	0,6 - 1,3	0,6- 1,3	0,6 - 1,3
Produced by: Prodtex Industry AS Date: 21.11.2022			Approved by IWE: Ödön Bogdan Bindiu Date: 22.11.2022		
			 		

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>				
Location: Fiskå								
Welding process:	1	138		2	136		3	-
Shielding gas type:		Arcal Force Ar+CO2 18% ± 1,8%			Arcal Force Ar+CO2 18% ± 1,8%			-
Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]	
	A	S420J5W M	EN 10029 Class A	2.1	TM	10 - 40	>150	
	B	S420J5W M	EN 10029 Class A	2.1	TM	10 - 40	>150	
Filler Material specification	Index	Brand name	Classification	Group		Size [mm]	Filler treatment	
	I	Sidergas Cor	EN ISO 14341-A:21 G46 4 M21 Z	2,2		1,2	-	
	II	Ceweld AAR Corten	EN ISO 17632-A: T 46 2 Z P M21 H5	2,2		1,2	-	
Equipment identification	Welding unit (device)		Fiber core dia.	Beam focusing system	Laser power source	Welding power source	Focusing optics	
	KEMPI 510		NA	NA	NA	KEMPI 4000	NA	
Joint design			Geometry				Joint type	BW
 <p>Rootface:0-5 mm    Rootgap: 3-4 mm Groove Angle: 30°±10°</p>							Joint preparation	V,1/2V, X, K
							Single/double side	S/DS
							Welding Positions	All except PG
							Gouging method	NA
							Cleaning method	Sandblast
							Backing	NA
							Purging gas type	NA
							Flux	NA
							Flux treatment	NA
							Weaving	NA
Tack welding proc.	NA							
Mechanical clamping	Yes							
Preheat min: 20°C			Heating rate: -			PWHT min: NA	max: NA	
Interpass max: 75°C			Cooling rate: -			Temp. control: Digital		
Non - Destructive Testing:								
VE: 100%    UT:20%    RT: -    MT: 20%    PT: -								

Welding parameters	Unit	1'st run	2'nd run	3'rd run	n'th run
Welding position		All except PG	All except PG	All except PG	All except PG
Process index		1	2	2	2
Filler material index		I	II	II	II
Shielding gas					
Classification and type		EN ISO 14175-M21-ArC-18 /		Arcal Force Ar+CO <sub>2</sub> 18% ± 1,8%	
-gas flow	l/min	18	18	18	18
Torch arrangement		NA	NA	NA	NA
Beam power	W	NA	NA	NA	NA
Power ramping					
-slope up	mm	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA
Geometrical parameters					
-Beam angle transverse	° deg.	NA	NA	NA	NA
-Beam angle longitudinal	° deg.	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA
Welding speed	m/min	0,1	0,1 – 0,3	0,1 - 0,3	0,1 – 0,3
Arc parameters					
-mode polarity		DC+	DC+	DC+	DC+
-wire feed rate	m/min	2,2 - 2,5	6 - 7	6 - 7	6 - 7
-current	A	80 - 100	180 - 230	170 - 250	150-240
-voltage level	V	16	22 - 23	22 - 23	22 - 23
-stick out wire	mm	17	17	17	17
-pulse dynamic corr.		NA	NA	NA	NA
-arc length corr.		NA	NA	NA	NA
Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0.77 - 0,97	1,8 - 2,8	1,8 - 2,9	1,8 - 2,9
Produced by: Prodtex Industry AS Date:18.01.2023			Approved by IWE: Odón Bogdan Bindiu Date:18.01.2023		
					

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>						
Location: Fiskå										
Welding process:	1	138		2	136		3	-		
Shielding gas type:		Arcal Force Ar+CO2 18% ± 1,8%			Arcal Force Ar+CO2 18% ± 1,8%			-		
Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]			
	A	S420J5W M	EN 10029 Class A	2.1	TM	10 - 40	NA			
	B	S420J5W M	EN 10029 Class A	2.1	TM	10 - 40	NA			
Filler Material specification	Index	Brand name	Classification	Group		Size [mm]	Filler treatment			
	I	Sidergas Cor	EN ISO 14341-A:21 G46 4 M21 Z	2,2		1,2	-			
	II	Ceweld AAR Corten	EN ISO 17632-A: T 46 2 Z P M21 H5	2,2		1,2	-			
Equipment identification	Welding unit (device)		Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics			
	KEMPI 510		NA	NA	NA	KEMPI 4000	NA			
Joint design				Sketch process			Joint type		T	
 <p>Rootface: 0-5 mm    Rootgap: 3-4 mm Groove Angle: 30° ± 10°</p>							Joint preparation		1/2V, K	
							Single/double side		S, DS	
							Welding Positions		All except PG	
							Gouging method		NA	
							Cleaning method		Grinding	
							Backing		NA	
							Purging gas type		NA	
							Flux		NA	
							Flux treatment		NA	
							Weaving		NA	
							Tack welding proc.		NA	
							Mechanical clamping		Yes	
							Preheat min: 20°C			Heating rate: -
Interpass max: 75°C			Cooling rate: -			Temp. control: Digital				
Non - Destructive Testing:										
VE: 100%    UT:-    RT: -    MT: 20%    PT: -										

Welding parameters	Unit	1'st run	2'nd run	3'rd run	n'th run
Welding position		All except PG	All except PG	All except PG	All except PG
Process index		1	2	2	2
Filler material index		I	II	II	II
Shielding gas					
Classification and type		EN ISO 14175-M21-ArC-18 /		Arcal Force Ar+CO <sub>2</sub> 18% ± 1,8%	
-gas flow	l/min	18	18	18	18
Torch arrangement		NA	NA	NA	NA
Beam power	W	NA	NA	NA	NA
Power ramping					
-slope up	mm	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA
Geometrical parameters					
-Beam angle transverse	° deg.	NA	NA	NA	NA
-Beam angle longitudinal	° deg.	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA
Welding speed	m/min	0,1	0,1 - 0,2	0,1 - 0,3	0,1 - 0,3
Arc parameters					
-mode polarity		DC+	DC+	DC+	DC+
-wire feed rate	m/min	2,4 - 2,5	6 - 7	6 - 7	5,8 - 6
-current	A	80 - 100	180 - 200	180 - 210	180-210
-voltage level	V	16 -17	21 - 23	21 - 22	21 - 22
-stick out wire	mm	17	17	17	17
-pulse dynamic corr.		NA	NA	NA	NA
-arc length corr.		NA	NA	NA	NA
Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0.77 - 1,02	0,85 - 1,41	0.85 - 1,12	0,85 - 1,41
Produced by: <b>Prodtex Industry AS</b> Date: 19.01.2023 			Approved by IWE: <b>Ödön Bogdan Bindiu</b> Date: 20.03.2023  		

Produced by: Prodtex Industri AS		Project: General		Client: <b>Prodtex Industri AS</b>			
Location: Fiskå							
Welding process:	1	136	2	-	3	-	
Shielding gas type:	Arcal Force Ar+CO2 18% ± 1,8%		-		-		
Material specification	Part	Name/ Grade	Standard	Group	Delivery cond.	Thick. Range [mm]	Diameter range [mm]
	A	S420J5W M	EN 10029 Class A	2.1	TM	3 - 40	NA
	B	S420J5W M	EN 10029 Class A	2.1	TM	3 - 40	NA
Filler Material specification	Index	Brand name	Classification	Group	Size [mm]	Filler treatment	
	I	Ceweld AAR Corten	EN ISO 17632-A: T 46 2 Z P M21 H5	2,2	1,2	-	
	-	-	-	-	-	-	
Equipment identification	Welding unit (device)	Fiber core diameter	Beam focusing system	Laser power source	Welding power source	Focusing optics	
	KEMPI 510	NA	NA	NA	KEMPI 4000	NA	
Joint design		Sketch process			Joint type	FW	
					Joint preparation	T	
 <p>Rootface: 0-5 mm    Rootgap: 3-4 mm Groove Angle: 30° ± 10°</p>					Single/double side	S, DS	
					Welding Positions	All except PG	
					Gouging method	NA	
					Cleaning method	Grinding	
					Backing	NA	
					Purging gas type	NA	
					Flux	NA	
					Flux treatment	NA	
					Weaving	NA	
					Tack welding proc.	NA	
					Mechanical clamping	Yes	
					Preheat min: 20°C		Heating rate: -
Interpass max: 75°C		Cooling rate: -		Temp. control: Digital			
Non - Destructive Testing: VE: 100%                      UT:-                      RT: -                      MT: 20%                      PT: -							



Welding parameters	Unit	1'st run	2'nd run	3'rd run	n'th run
Welding position		All except PG	All except PG	All except PG	All except PG
Process index		1	1	1	1
Filler material index		I	I	I	I
Shielding gas					
Classification and type		EN ISO 14175-M21-ArC-18 /		Arcal Force Ar+CO <sub>2</sub> 18% ± 1,8%	
-gas flow	l/min	18	18	18	18
Torch arrangement		NA	NA	NA	NA
Beam power	W	NA	NA	NA	NA
Power ramping					
-slope up	mm	NA	NA	NA	NA
-overlap	mm	NA	NA	NA	NA
-slope down	mm	NA	NA	NA	NA
-slope profile		NA	NA	NA	NA
Geometrical parameters					
-Beam angle transverse	° deg.	NA	NA	NA	NA
-Beam angle longitudinal	° deg.	NA	NA	NA	NA
- Distance beam-wire	mm	NA	NA	NA	NA
-Focus position	mm	NA	NA	NA	NA
-Beam position	mm	NA	NA	NA	NA
Welding speed	m/min	0,1	0,1 - 0,2	0,1 - 0,3	0,1 - 0,3
Arc parameters					
-mode polarity		DC+	DC+	DC+	DC+
-wire feed rate	m/min	2,4 - 2,5	6 - 7	6 - 7	5,8 - 6
-current	A	80 - 100	180 - 200	180 - 210	180-210
-voltage level	V	16 - 17	21 - 23	21 - 22	21 - 22
-stick out wire	mm	17	17	17	17
-pulse dynamic corr.		NA	NA	NA	NA
-arc length corr.		NA	NA	NA	NA
Nominal heat input $Q_{nom} = \frac{(P + U \times I)}{v} 10^{-3}$	Kj/mm	0.77 - 1,02	0,85 - 1,41	0.85 - 1,12	0,85 - 1,41
Produced by: Prodtex Industry AS Date: 19.01.2023 			Approved by IWE: Ödön Bogdan Bindiu Date: 20.03.2023  		

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# S-22-11727 - Installation of Elverhøy Bru Sunndalen





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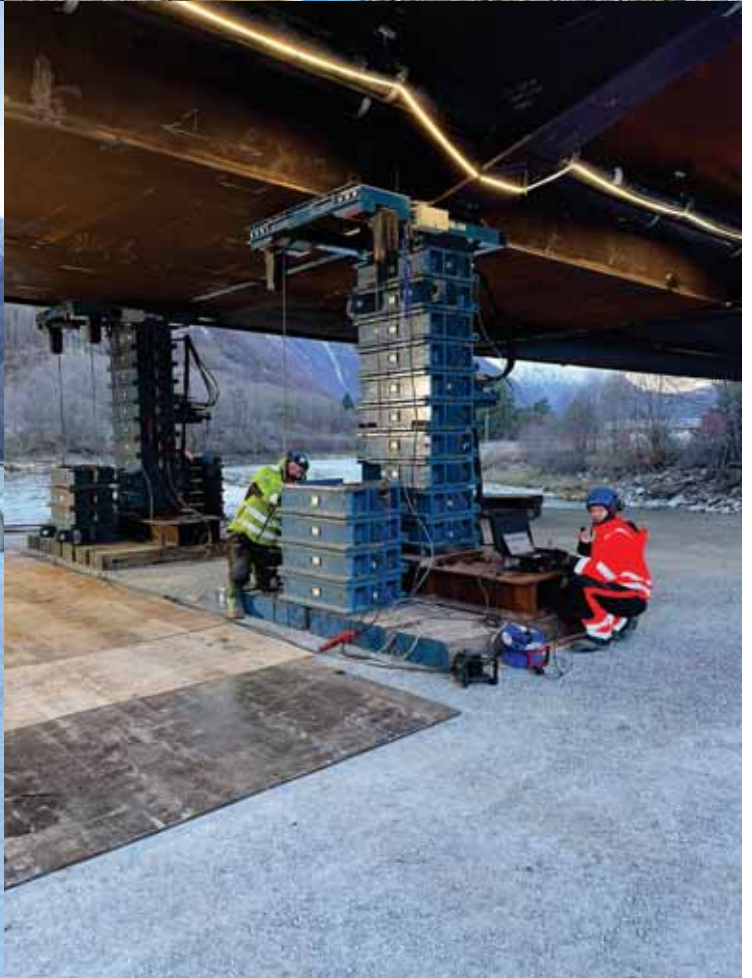
# S-22-11727 - Installation of Elverhøy Bru Sunndalen





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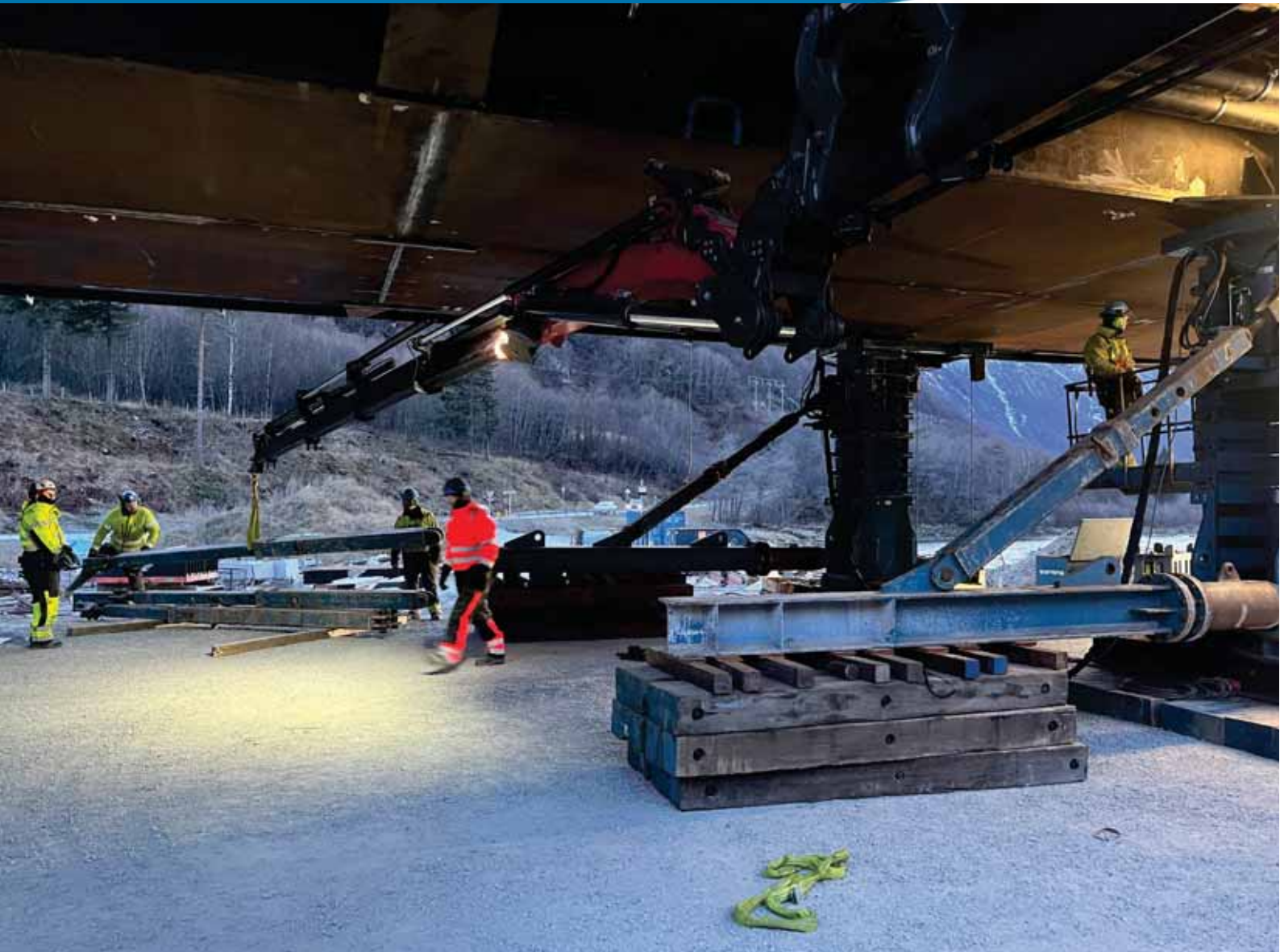
# S-22-11727 - Installation of Elverhøy Bru Sunndalen





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STATENS VEGVESEN UTBYGGING  
5008 Bergen  
Norway

DNV AS  
DNV AS Energy Systems  
Environmental Loading &  
Response-4100-NO  
Veritasveien 1

**Date:**  
08.03.2024

**Our reference:**  
1129139 – VO2

**Your reference:**  
[Your Ref]

Tel: +4767579900

## **Vedlegg til Prodtexs erfaringsrapport fra Elverhøy bru**

### **Introduksjon og bakgrunn:**

DNV har på oppdrag fra Statens Vegvesen (SVV), fulgt byggeprosessen av Elverhøy med fokus på teknologikvalifisering av lasersveising for brobygging. Denne rapporten beskriver aspekter DNV vil trekke frem som viktige i Prodtex' erfaringsrapport (Erfaringsrapport Elverhøy-bru – Prodtex, rev 0). Hensikten med dette vedlegget er å vurdere Prodtex aktiviteter opp mot kvalifiseringsbasis, beskrevet i DNV rapport 2022-3224 Rev1. DNV har ikke vært involvert i hele prosessen, men har gitt råd på områder som kvalifisering, kvalitetskontroll og kvalitetssikring av lasersveis og på kvalitetsaspekter som blir påvirket av at lasersveising er benyttet som sveisemetode. Rapporten er derfor begrenset til disse aspektene, og ment å leses i sammenheng med Prodtex erfaringsrapport for Elverhøy bru.

### **Kvalifisering av sveiseprosedyrer:**

Elverhøy bro nyter godt av tidligere erfaringsoppbygging av laser/lasehybridsveising av broer. Her har Prodtex utnyttet denne erfaringen i sin produksjonsplanlegging, og sveiseplaner. Men siden ingen prosjekter er like så har det vært nødvendig å kvalifisere noen nye sveiseprosedyrer for å dekke alle forbindelser.

I tillegg til tidligere kvalifiserte prosedyrer for YA og Åfjord/Frønes er følgende sveiser laser/laser-hybrid.

- Topp-plate top-plate – 16-16 butt full gjennombrenning
- Topp-plate mot side – 16-16 t-forbindelse delvis gjennombrenning med baksveis
- Topp-plate mot stiver – 16-20 t-forbindelse, Delvis gjennombrenning fra hver side 8+8mm innbrenning.

Sveiseprosedyrene ble kvalifisert gjennom sveiseprosedyrekvalifiseringen, etter krav definert i kvalifiseringsbasis.

### **Betraktninger rundt bruken av laser/laser-hybrid sveis:**

Det har vært benyttet lapweld med lasesveis på langsgående sveis bunnplate mot flens. Denne sveiseforbindelsen har vært benyttet på tidligere prosjekter med god erfaring. Det er imidlertid vanskelig å kontrollere denne sveiseforbindelsen med ndt, men visuelt så avdekkes det raskt når det ikke er full gjennombrenning.

Øvrige gode erfaringer med bruk av lasersveis er at det blir langt bedre og dypere innbrenning som medfører både raskere sveis med færre lag, samt at man unngår å sveise bunnstreng på tosidig sveis hvilket er meget tidsbesparende.

Det var ikke alle sveisene i konstruksjonen som ble lagd med lasersveising, men bruken av lasersveis muliggjør konstruksjon på andre tilkomstbetingelser. I dette prosjektet gjorde designet at det ikke var tilkomst på innsiden når

montasjesveis ble lagt mellom elementene. Det ble derfor vurdert bruk av permanent stålbacking som tiltak for å sikre god kvalitet på enside-sveis. Det ble derfor gjort analyser og vurderinger i forhold til bruk av permanent stålbacking på langsgående sveiser i ribbedekket (montasjesveiser). Max spenninger oppnås kun ved svært urealistiske kjøremønstre og utnyttelsen av sveisen tåler derfor at ikke full tilkomst for volumetrisk kontroll av rot kan foretas. Det poengteres at tverrgående sveiser ikke kan sveises med stålbacking da det her vil føre til kapasitetutnyttelse som overstiger anbefalingene. Denne vurderingen har vært gjort i samarbeid med Norconsult sine utnyttelsesberegninger samt utmattingsanalysen. Det har også vært lagt til grunn av sveising med stålbacking vanskeliggjør full volumetrisk inspeksjon av rotområdet med ultralyd. Dermed vil sannsynligheten for å avdekke sveisefeil i sveiserot bli begrenset. Bruk av stålbacking er dog en etablert teknikk innen bygg og anlegg, men bør kun benyttes etter spesiell vurdering.

DNV har vært på site for å inspisere sveising med permanent stålbacking. Det ble gitt generelle råd for å sikre god kvalitet og foreslått spotcheck med UT av 3.part, men totalt sett ble det ikke rettet kommentarer på kvalitet.

### **Ikke-destruktiv prøving (NDT) og omfang:**

Volumetrisk NDT på lasersveiser og laser hybrid sveiser er identifisert som en utfordring i kvalifiseringsbasis. Grunnen er at sveisegeometriene, gir vanskelige forhold for ultralydprøving (UT) og radiografisk prøving (RT) på grunn av den bratte fugevinkelen. Sveisegeometriene er derfor vurdert nøye for å redusere test-omfang for Elverhøy bru:

- T-forbindelser anses i prosjektet som sveis med delvis gjennombrenning eller kilsveiser, selv om sveiseprosessen i realiteten kan ha opp mot full gjennombrenning. Sveiser med full gjennombrenning skal etter Håndbok R762 testes med UT, under antagelsen at sveiser med full gjennombrenning også ser større spenninger. I sveisene mot toppdekket ble det antatt delvis gjennombrenning, og Prodtex brukte sveiseparametere som gav i praksis full gjennombrenning, og dette gjorde det mulig å inspiserer sveisene på baksiden for å bekrefte at det var tilstrekkelig innbrenning. I tillegg gjorde Prodtex sveisetester på kuponger. Utfallet av det ble at det ble gjort en konservativ antagelse i design, og Prodtex gjorde gode tiltak i produksjon for å sikre at det var god gjennombrenning, selv om volumetrisk NDT var en utfordring.
- Lap welds ble ikke inspisert med volumetrisk NDT. Lapwelds beregnet med konservative antagelser i design og støttet av materialtesting. En risiko med lapwelds er at hvis det er for stort mellomrom mellom de to platene som skal sveises sammen, kan det flytende metallet i sveisebadet flyte inn i mellom de to platene, og eventuelt føre til ufullstendig binding. Materialtesting viste i midertid at hvis det skulle være et lite mellomrom metallet flyte utover og bidra til et større bindene areal og dermed en noe økt styrke. Overflate NDT vil detektore evt sprekkdannelse som er åpen til overflaten (på og rundt sveiseråk). Lapwelds er satt i en kritikalitetsklasse som ikke krever volumetrisk NDT i Håndbok R762.
- Buttsveis ble inspisert med visuell NDT, overflate NDT på alle sider (MT), og volumetrisk NDT fra oversiden (UT), etter kritikalitetsklassen i Håndbok R762. For å sikre at det ikke er rot-defekter ble det gjort MT og VT på understiden etter sveising. DNV verifiserte sveising og testing på et utvalgt testomfang ved hjelp av PAUT, rapport vedlagt. Testomfanget testet lasersveis som hadde blitt inspisert av Protex og ikke hadde blitt reparert. Verifikasjonen fant ingen uakseptable defekter.

Basert på vurderingene gjort på NDT og inspeksjon kan følgene anbefalinger gis:

- I den første perioden av produksjonen, mens man justerer inn sveisemaskinene burde NDT utføres på et større omfang av sveisene. Når man ser at hyppigheten på sveisefeil reduseres og at prosessen går stabilt, kan inspeksjonen trappes ned fordi reproduserbarheten på robotsveis er god under kontrollerte forhold, som det er i en fast produksjonslinje. Inspeksjon kan ikke fjernes helt, da dette skal kunne oppdage det hvis noe uforutsett skjer med utstyr og produksjon.





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- Vanlig manuell ultralyd prøvning kan benyttes på butt sveiser i lasersveis og laser-hybrid sveis, men det anbefales at det gjøres verifikasjon på et utvalg ved hjelp av avansert UT (PAUT e.l.) for å bekrefte metoden. Det anbefales at overflate inspeksjon og visuell inspeksjon utføres på undersiden i tillegg til oversiden av sveisen for å detektere rotfeil.
- T-forbindelser sveist med laser og laser hybrid sveis, bør gjøres med konservative antagelser i design hvis ikke innbrenningsdybden kan bekreftes med definerte tiltak (f.eks. volumetrisk NDT, produksjonstesting, visuell inspeksjon). For sveis med full gjennombrenning skal også sveisen inspiseres for sveisefeil, og inspeksjonsmetoden bør derfor verifiseres som anbefalt for buttsveiser.

### Konklusjon:

Prodtex viser i Elverhøy bru prosjektet at de kan levere sveiste konstruksjoner med lasersveiser i høy kvalitet. Prodtex har etter flere bruprosjekter gjort seg gode og verdifulle erfaringer med bruk av laser- og laserhybrid sveis for å øke produktiviteten. Den økende produksjonshastigheten har gitt utfordringer rundt utførelse av NDT (holdetid og inspeksjonsforhold). For å overkomme dette kreves god logistikk i produksjonsflyten og det ser ut til at Prodtex har gjort gode erfaringer som ivaretar dette. Kvalitetsmessig oppnår lasersveis og laserhybridsveis egenskaper som er i tråd med Håndbok R762 og gjeldende standarder. Det er også erfart at laser og laserhybrid ikke er egnet til alle type forbindelser og det må derfor kombineres med konvensjonell MIG-sveising. God planlegging av sveiserekkefølge og størrelse på seksjoner er også viktig, og det har vist seg at sveisekrymp kan bli større enn antatt og må ivaretas slik at nøyaktighet på dimensjoner blir riktig.

Funn gjort i løpet av prosjektet anses å støtte opp om teknologiens kapabilitet som beskrevet i kvalifiseringsbasis, DNV rapport 2022-3224.

Med vennlig hilsen  
for DNV AS

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- Vedlagt rapport på PAUT verifikasjon av butt sveis med lasersveis hos Prodtex 07.08.2023





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