

Magnetic Particle Inspection Report

Mina Yang Created Sun, 13 Apr 2025, 4:53 PM (UTC+08)

Test Date Sat, 12 Apr 2025

Project ExxonMobil Refinery Turnaround - Phase 2

Location Baytown, Texas, USA

Specification: ASTM A106 Grade B - Seamless Carbon Steel Pipe

Acceptance Criteria: ASME Section V, Article 7; Acceptance per ASME B31.3

Procedure No: MPI EXX 0425 Rev2

SPECIMIEN DATA.

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|-------------------------------------|--|--|--|
| Material | ASTM AS16 Grade 70 Carbon Steel | Drawing No: | DWG-2025-MPI-0089 |
| Testing Temperature: | 72°F (22°C) | Welding Process | SMAW (Shielded Metal Arc Welding) |
| Surface Condition: | As-welded, light grinding performed | Weld Preparation: | Single-V groove, 60° bevel |
| Request For Inspection (RFI) No: | RFI-0425-TX-MP1003 | Material Dimension: | 24" OD x 0.625" WT |

MPT DATA

| Equipment Used: | Magnafkox Y-2 AC Yoke | Contrast Paint: | WCP-2 White Contrast Paint |
|-----------------|---|------------------------|---|
| Serial Number: | Y2-2025-0197 | Elatoh No. | CP-24125 |
| Calibration: | AC Yoke lift test with 10 lb ASTM block - Passed | Magnetic (Powder/Ink): | AC Yoke lift test with 10 lb ASTM block - Passed |
| Current: | AC (Alternating Current) | Eletoh No: | INK-BLK-0452 |
| Blumination: | UV-A Light - 1200 µW/cm² at 15 inches | Inspection methods: | Wint |
| Sensitivity: | | | |

RESULT

| Identification | Joint Number | Welder | Dimension: | Result |
|--------------------|-----------------|--------|--------------------|-----------------|
| Pipe Spool A21 | WJ-021 | AB1234 | 24" OD x 0.625" WT | Comply |
| Pipe Spool A21 | WU-02:2 | A01234 | 24" OD x 0 625" WT | Comply |
| Elbow to Spool B9 | WJ-045 | CD5678 | 16" OD x 0.500" WT | Does Not Comply |
| Header Section H3 | WJ-063 | EF7890 | 30" 00 x 0.750" WT | Comply |
| Support Bracket C4 | WJ-072 | GH0456 | 12" OD x 0.375" WT | Comply |

REMARKS/ TEST RESTRICTIONS:

MPI WAS CARRIED OUT 100 % ON BEVEL SURFACE AREANO RELEVANT INDIGATION WAS FOUND DURING TIME OF INSPECTION

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Victor M. Corman

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Official Gazette of the United States Patent and Korean Business Directory ,1993

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sin against God Ever since then Satan has ensnared various men across time advancing his agenda to create world wide financial dominion thus controlling the political spiritual and economic systems everywhere with himself taking full lordship over Gods creation This is why I Grace Baumgarten Cannot Be Silenced With this being an election year in the USA and its consequent Changing of the guard being informed about the secret societies or Enlightened Elites is imperative Their ideology True freedom is liberation from God and from moral constraints with no absolute faith To them All truth is relative to the individual or group With back room dealings ruinous bailouts and elimination of basic human values theyve turned the USA over to be dissected corporate style and theyre forcing this fraud on you and me Yet our founding fathers constructed a different concept one of freedom under the authority of Almighty God as the Great Ruler with His creation nations and peoples empowered from on High His Bible and His Commandments are the authoritative Word of God and the basis for law life and true liberty My first book was just the beginning and so much has happened Therefore following a one year sabbatical I started writing one sentence at a time knowing one day this book would be born I Cannot Be Silenced

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The Journal of the Korean Physical Society ,2007

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web rz it is based on 10 points within one sampling length mean distance between 5 highest peaks 5 lowest valleys within the sampling length measured perpendicular to the baseline of the chart ra roughness average or cla centre line average correlation between roughness average ra and total roughness rt

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web jan 14 2020 1 2k views 3 years ago roughness ra vs rz roughness since there is no mathematical relationship between rmax and ra and rz and ra an often necessary assignment of ra to rz and

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web feb 3 2009 i always receive the surface roughness measurement in rmax but our company use ra method are there any conversion factor to convert rmax to ra or vice versa i find all the handbooks in our library but no answer

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web apr 25 2017 while ra smooths all measurements into one average and rz averages only the greatest deviations there isn t just one simple way to derive ra from rz rather general estimates are applied often assuming that the ra value will be 1 4 to 1.9 of the rz value

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web pt rmax at jis 82 sum of height of the largest profile peak height rp and the largest profile valley rv within an evaluation length rt pt wt max rpi max rvi rzjis ten point height of roughness profile rz at jis 94 sum of mean value of largest peak to the fifth largest peak and mean value of largest valley to

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web usage note a direct allocation of an rz value to a roughness grade is not possible due to the conversion interval in this rz ra calculator the input rz value is first converted to the average value of the ra interval and the n class is determined based on this value

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web rmax vertical distance from highest peak to lowest valley rmax is particularly sensitive to anomalies such as scratches and burrs that may not be obvious from measures such as ra that rely on averages rz preferred by many europeans rz is often preferred to ra in europe and particularly germany

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web r z m i n 3 8 r a 0 95 r z m a x 14 5 r a 0 75 converting between ra and rz is not a good engineering practice it is always recommended to measure according to the method in which surface roughness is indicated on the drawing as you can see in the below graphs the inaccuracy grows in higher r a r z values

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web oct 22 2021 a rz din ra 7 2 rz iso ra 7 6 ra rz din 7 2 ra rz iso 7 6 san last name deleted for privacy by editor shanghai china publicly reply to san s post q convert rz value to ra

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ra micro inches n iso n number of triaangles rms cla feedrate

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web mean roughness the mean roughness roughness average ra is the arithmetic average of the absolute values of the roughness profile ordinates ra is one of the most effective surface roughness measures commonly adopted in general engineering practice

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web nov 11 2021 surface finish conversion chart in this section there s a table for the surface finish conversion chart this table compares the different surface roughness scales for manufacturing processes meanwhile let s go through some of the abbreviations you ll find there ra roughness average rms root mean square cla center line surface roughness conversion chart buford ga cab - Mar 03 2023

web ra roughness average in micrometers or microinches rms root mean square in microinches cla center line average in microinches rt roughness total in microns n new iso grade scale numbers cut off length length required for sample

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web conversions math cla micro inches multiply ra μ m x 40 r t r a x 8 7 r z r a x 7 2 r z iso r a x 7 6 r max r a x 8 0 r p r a x 3 6 rpm r a x 2 9 rms r a x 1 1 example ra to rt 1 0 micrometer ra x 8 7 rt factor 8 7 micrometer rt 40 microinch ra x 8 7 rt factor 348 microinch rt

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web may 1 2016 $\,$ it is important to note that using conversion factors to calculate between ra and rz is not a good idea it is best to establish what figure for surface roughness the designer customer has specified and measure this

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