

Magnetic Particle Inspection Report

Nina Yang
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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:	MPH-EXX-0425-Rev2

SPECIMEN DATA

Material:	ASTM A516 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-MPI003	Material Dimension:	24" OD x 0.625" WT

MPI DATA

Equipment Used:	Magnaflux Y-2 AC Yoke	Contrast Paint:	WCP-2 White Contrast Paint
Serial Number:	Y2-2025-0197	Batch 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)	Batch No:	INK-BLK-0452
Illumination:	UV-A Light - 1200 µW/cm² at 15 inches	Inspection methods:	Wet
Sensitivity:			

RESULT

Identification	Joint Number	Welder	Dimension:	Result
Pipe Spool A21	WJ-021	AB1234	24" OD x 0.625" WT	Comply
Pipe Spool A21	WJ-022	AB1234	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" OD x 0.750" WT	Comply
Support Bracket C4	WJ-072	GH3456	12" OD x 0.375" WT	Comply

REMARKS/ TEST RESTRICTIONS:

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

Magnetic Particle Inspection Korean Edition

IM Harris



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