



G&S Stainless Services – Ballybinaby, Dundalk, Co. Louth

Tel +353 (0)42 937 7840

DYE PENETRANT TEST REPORT

Report Details			
Report Composed By:	Gerry Doran	Date:	20/07/2020
Type of Report:	Dye Penetrant Test		
Report Objective:	Visual inspection to check for surface breaking defects		

Client/Company Details			
Company:	Arron Chemicals	Contact	
Address:	Monksland Industrial Estate, Athlone, Co. Roscommon, N37 DN24, Ireland	Phone:	+353 90 644 5700
		Fax:	
		Email:	

Details	
Description:	Sump 2
Serial Number:	
Drawing Number:	Sump 2 - 1850x1210mm

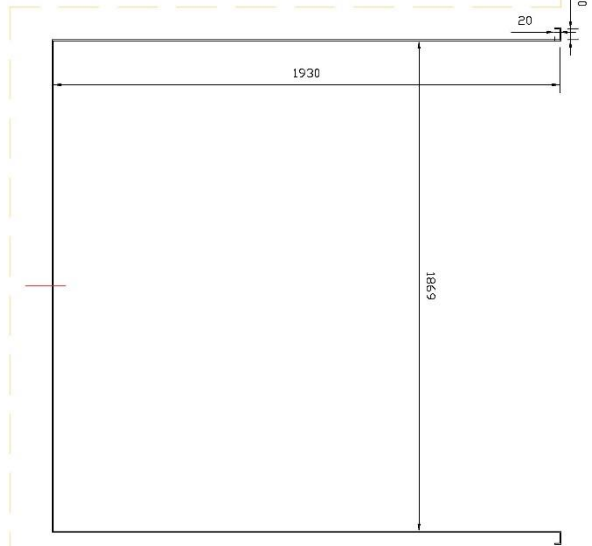
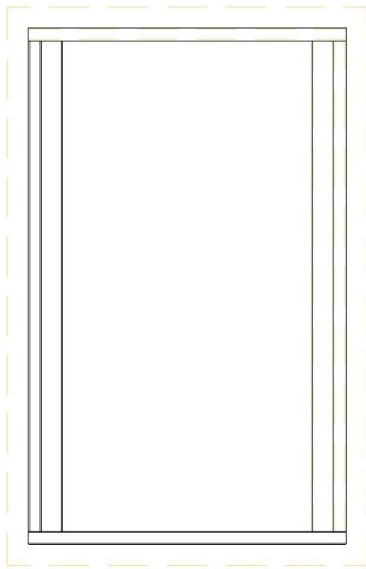
Test Information			
Test Composed By:	Richie Faughey	Test Date:	20/07/2020
Penetrant Used:	Ambersil - Flaw Detector Penetrant 2 (High Visible Red Dye)		
Developer Used:	Ambersil - Flaw Detector Developer 3 (White Powder Coating)		
Test Duration:	25 Minutes		

Test Procedure	
<ul style="list-style-type: none">The weld face being examined was cleaned to remove all dirt, grease etc. with cleaning agents prior to applying the penetrant.Penetrant was applied to the weld face and allowed to 10mins dwell time.Excess penetrant was removed by wiping with a dry, clean cloth.Developer was applied to the other weld face and allowed to 10mins dwell time.Weld face was visually examined for defects.	
Test Results	
Satisfactory/ Non-Satisfactory	Satisfactory

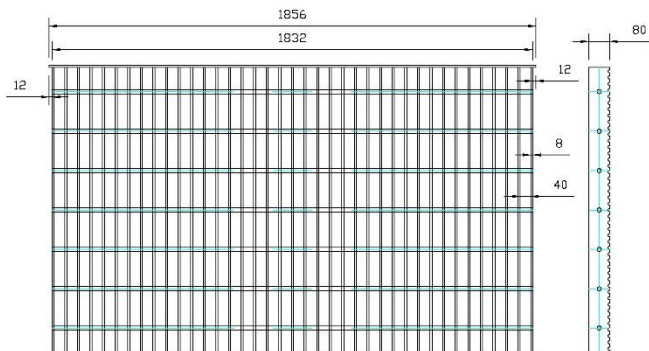
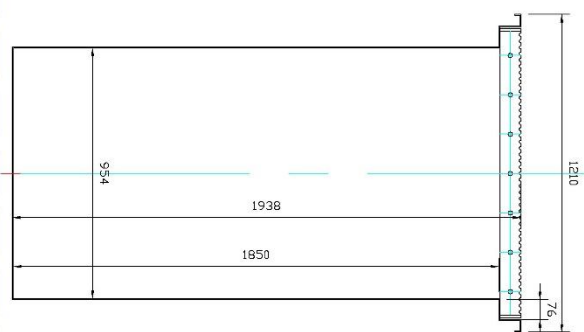
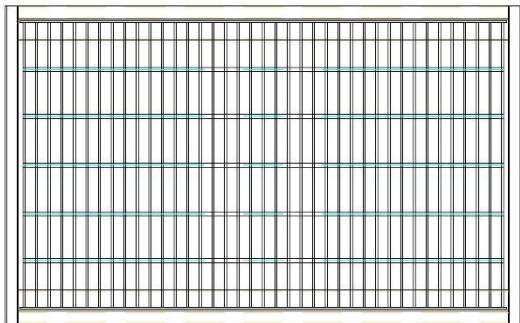
The signature of the company's representative indicates their agreement and understanding of the non-compliances and observations found and that are the subject of this report. This report is to certify that the equipment above was subjected to a dye penetrant test and during the test there was no evidence of leakage or weakness.

Tester/Assessor		Reviewer	
Print Name:		Print Name:	
Signature:		Signature:	
Date:		Date:	

Drawing - Sump 2 - 1850x1210mm



4MM 2B 316
QTY: 1N/O.



Material Certificate



		MILL CERTIFICATE BS EN 10204/3.1 CERTIFICAT DE RECEPTION NF EN 10204/3.1 ABNAHMEPRUEFZEUGNIS DIN EN 10204/3.1		N-Nr-N 20K0017460-01 V01																																																																																																							
Correspondence address: Aperam Genk Swinnenwijnweg 5, Poort Genk 7523 3600 Genk, Belgium Tel. +32 (0)89 30 21 11		Certified acc. PED 2014/68/EU Annex I 4.3 by Certification Body 0036 of TUV SUD Industrie Service GmbH with cert.No.:314/2007/MUC. Renounced of counter signature agreed by TUV SUD (05/2007). Approved acc. AD 2000-Merkblatt W0/TRD 100 by TUV SUD Industrie Service GmbH. Confirmation letter from TUV SUD Industrie Service GmbH of 07/05/2010 about the uniformity of coils acc. AD 2000 W2 4.1.1																																																																																																									
Manufacturer's works order number N° de la commande usine productrice Werksauftragsnummer 80580266/05-00605/007/05		Surveyor's mark Cachet de l'expert Stempel des Werkssachverständigen 		Purchaser and/or consignee Client et/ou destinataire Besteller und/oder Empfänger Shorti Stainless Steel Limited Annacotty Business Park Limerick IRELAND																																																																																																							
Product - Produit - Erzeugnis SHEETS, COLD ROLLED, FINISH 2 B TOLES, LAMINEES A FROID, FINI 2B BLECHE, KALTGEWALZT, GEGLUEHT, GEBEIZT, LEICHT NACHGEWALZT		Steel designation Désignation de l'acier Stahlbezeichnung EN 10028-7-2016 1.4404 / 1.4401 EN 10088-2-2014 1.4404 / 1.4401 EN 10088-4-2009 1.4404 / 1.4401 ASTM A 240-2018 TYPE 316L / 316 ASME SA 240-2019 TYPE 316L / 316		Product delivery condition Etat de livraison du produit - Lieferzustand Solution treated: Hypertemper: Lösungsgegl+abgeschreckt: 1050 °C Forced air-water/air forced-eau Gebläse Luft-Wasser																																																																																																							
Identification of the product Identification du produit - Identifizierung des Erzeugnisses MELTED IN BELGIUM, MADE IN BELGIUM		Dimensions Dimensions - Abmessungen Thickness Epaisseur - Stärke 4.00 mm Width Largeur - Breite 2000.00 mm Length Longueur - Länge 4000.00 mm		Number of pieces Nb de pièces - Stückzahl 8 Net weight Poids net - netto Gewicht 2022 KG																																																																																																							
CHEMICAL ANALYSIS - ANALYSE CHIMIQUE - CHEMISCHE ZUSAMMENSETZUNG																																																																																																											
<table border="1"> <thead> <tr> <th></th> <th>C</th> <th>Si</th> <th>Mn</th> <th>Ni</th> <th>Cr</th> <th>Mo</th> <th>Ti</th> <th>N</th> <th>S</th> <th>P</th> <th></th> <th></th> <th></th> <th></th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>Required - Exigé - %mini</td> <td>0.030</td> <td>0.75</td> <td>2.00</td> <td>10.00</td> <td>16.50</td> <td>2.00</td> <td></td> <td>0.100</td> <td>0.015</td> <td>0.045</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Exigé - %maxi</td> <td></td> <td></td> <td></td> <td>13.00</td> <td>18.00</td> <td>2.50</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Cast Analysis</td> <td>0.024</td> <td>0.55</td> <td>1.33</td> <td>10.05</td> <td>16.57</td> <td>2.02</td> <td></td> <td>0.028</td> <td>0.003</td> <td>0.035</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>Analysis coulée</td> <td>C71</td> <td>C72</td> <td>C73</td> <td>C74</td> <td>C75</td> <td>C76</td> <td>C77</td> <td>C78</td> <td>C79</td> <td>C80</td> <td>C81</td> <td>C82</td> <td>C83</td> <td>C84</td> <td>C85</td> <td>C86</td> </tr> <tr> <td>Analysis Schmelze</td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>							C	Si	Mn	Ni	Cr	Mo	Ti	N	S	P							Required - Exigé - %mini	0.030	0.75	2.00	10.00	16.50	2.00		0.100	0.015	0.045							Exigé - %maxi				13.00	18.00	2.50											Cast Analysis	0.024	0.55	1.33	10.05	16.57	2.02		0.028	0.003	0.035							Analysis coulée	C71	C72	C73	C74	C75	C76	C77	C78	C79	C80	C81	C82	C83	C84	C85	C86	Analysis Schmelze																
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Positive material identification carried out : OK Tests de vérification de la conformité de la nuance fournie : OK Verwechslungsprüfung wurde durchgeführt : OK																																																																																																											
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Room temperature - Température ambiante - Raumtemperatur Test temperature (°C): Yield or proof strength Limite d'élasticité Dehngrenze MPa Tensile Strength Résistance à la traction Zugfestigkeit MPa Elongation after fracture Allongement après rupt. Bruchdehnung % Hardness Dureté Haerte Yield or proof strength Limite d'élasticité Dehngrenze MPa Tensile str. Résist. MPa Zugfestigkeit Bruchdehnung %																																																																																																											
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Location of the sample (1) Emplacement de l'échantillon Lage des Probenabschnittes 1. Front - Début - Anfang 2. Back - Fin - Ende 3. Middle - Milieu - Mitte Direction of the test pieces (2) Orientation des éprouvettes Probenrichtung T. Transverse - Travers - Quer L. Longitudinal - Long - Längs																																																																																																											
The delivery is in accordance with the order La fourniture est conforme aux exigences de la commande Die Lieferung entspricht den Bestellbedingungen Packing list Avis d'expédition Lieferschein/Nummer 2020035351-605 Marking, inspection and measurement : without objection Contrôle de marquage, d'aspect et de dimensions : satisfaisants Prüfung der Stempelung, des Oberflächenaspekts und der Abmessungen : ohne Beanstandung Organisation inspection Organisme et/ou service contrôle Überwachungsabteilung Quality Department 27/4/2020 The inspector Le responsable Der Werkssachverständige D. Raemaekers																																																																																																											

Image 1



Image 2




Welding Codes

 ENGINEERING INSPECTION SPECIALISTS LIMITED	Document No. WQT 9606-1 – 17 - 01	Certificate No.	Revision
	Welder Qualification Certificate		20-10018

Designation:	BS EN ISO 9606-1 141 P FW FM5 S t6 PB sl	
WPS No:	SR FW PB 6mm TIG	
Welder's Name:	DANIEL CIEPLINSKI	
Identification:	VERIFIED	
Date of Birth	VERIFIED	
Client:	G & S STAINLESS HACK BALLS CROSS, DUNDALK, Co. LOUTH	
Code / Test Standard:	BS EN ISO 9606-1:2017	
Job Knowledge:	NOT TESTED	
Supplementary Fillet Weld Test:	-	

	Weld Test Details	Range of Approval
Welding Process(es)	141 TIG Welding with Solid Filler Material	141, 142, 143 & 145
Transfer Mode:	-	-
Product Type (Plate or Pipe):	Plate	Plate & Pipe
Type of Weld:	Fillet	Fillet
Parent Material Group(s):	8.1	1-11
Filler Material Group(s):	FM5	FM5
Filler Material (Designation):	Solid (S)	S M
Shielding Gases:	PURESHIELD ARGON	-
Auxiliaries (e.g. Backing Gases):	-	-
Type of Current and Polarity:	DC-	-
Material Thickness (t) (mm):	6mm	≥3mm
Deposited Thickness (s/z) (mm):	≥4mm	-
Outside Pipe Diameter (mm):	-	D≥500 mm(Fixed pipes) & ≥75mm (Rotating - PA,PB)
Welding Position:	PB	PA PB (Fillet Weld)
Welding Details:	Single Layer - sl	sl

Type of Test	Performed & Acceptable	Not Required	Report No
Visual	<input checked="" type="checkbox"/>	<input type="checkbox"/>	10017
Radiographic Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Ultrasonic Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Fracture Test	<input checked="" type="checkbox"/>	<input type="checkbox"/>	10017
Bend Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Notch Tensile Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Macroscopic Exam	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
MPI Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
DPI Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Other	<input type="checkbox"/>	<input checked="" type="checkbox"/>	

Examiner or Test Body: EIS Limited
Date of Test: 08/07/2020
Date of Issue: 09/07/2020
Location: Louth & Dublin
Name of Examiner: Luke O'Hara
Signature: 

Validity of Approval Until: 07/07/2023



Revalidation in Accordance to: 9.3 a) 3 Years

Prolongation for Approval by Examiner or Test Body for the following 2 years. Ref 9.3 (b)

Date	Signature	Position or Title

Prolongation for approval by employer/co-ordinator for the following 6 months

Date	Signature	Position or Title



Directors: P. Dunne, M. Dunne, J. Byrne, A. Fitzgerald
Company Reg. No. 342482. Reg. Office: Unit 734, Northwest Business Park, Kilshane Drive, Blanchardstown, Dublin 15, D15 F8PW
V.A.T. No: IE 6362482U

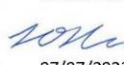


 ENGINEERING INSPECTION SPECIALISTS LIMITED	Document No. WQT 9606-1 – 17 - 01	Certificate No.	Revision
	<h2 style="margin: 0;">Welder Qualification Certificate</h2>		20-10021 0

Designation: BS EN ISO 9606-1 141 P FW FM5 S t6 PB sl WPS No: SR FW PB 6mm TIG Welder's Name: ROBERT RAJZER Identification: VERIFIED Date of Birth: VERIFIED Client: G & S STAINLESS HACK BALLS CROSS, DUNDALK, Co. LOUTH Code / Test Standard: BS EN ISO 9606-1:2017 Job Knowledge: NOT TESTED Supplementary Fillet Weld Test: -	
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	Weld Test Details	Range of Approval
Welding Process(es)	141 TIG Welding with Solid Filler Material	141, 142, 143 & 145
Transfer Mode:	-	-
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Filler Material Group(s):	FM5	FM5
Filler Material (Designation):	Solid (S)	S M
Shielding Gases:	PURESHIELD ARGON	-
Auxiliaries (e.g. Backing Gases):	-	-
Type of Current and Polarity:	DC-	-
Material Thickness (t) (mm):	6mm	≥3mm
Deposited Thickness (s/z) (mm):	≥4mm	-
Outside Pipe Diameter (mm):	-	D≥500 mm(Fixed pipes) & ≥75mm (Rotating - PA,PB)
Welding Position:	PB	PA PB (Fillet Weld)
Welding Details:	Single Layer - sl	sl

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Visual	<input checked="" type="checkbox"/>	<input type="checkbox"/>	10017
Radiographic Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Ultrasonic Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Fracture Test	<input checked="" type="checkbox"/>	<input type="checkbox"/>	10017
Bend Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Notch Tensile Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Macroscopic Exam	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
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DPI Test	<input type="checkbox"/>	<input checked="" type="checkbox"/>	
Other	<input type="checkbox"/>	<input checked="" type="checkbox"/>	

Examiner or Test Body: EIS Limited
 Date of Test: 08/07/2020
 Date of Issue: 09/07/2020
 Location: Louth & Dublin
 Name of Examiner: Luke O'Hara
 Signature: 
 Validity of Approval Until: 07/07/2023



Revalidation in Accordance to: 9.3 a) 3 Years

Prolongation for Approval by Examiner or Test Body for the following 2 years. Ref 9.3 (b)

Date	Signature	Position or Title

Prolongation for approval by employer/co-ordinator for the following 6 months

Date	Signature	Position or Title



Directors: P. Dunne, M. Dunne, J. Byrne, A. Fitzgerald
 Company Reg. No. 342482. Reg. Office: Unit 734, Northwest Business Park, Kilshane Drive, Blanchardstown, Dublin 15, D15 F8PW
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