

ECP: Logo		Owner/Buyer: Logo		<b>TESTNG KEY FORM</b> <b>* Demand Critical Structural Joints *</b>				Fabricator logo here	
TKF-Nº				Project Name				Job Nº	
Weldment Nº				Filed/Shop Testing				Shop	
Ref.		Ref.		MDMT °C					
EPC-Project Nº				Gov. Code/s		AWS-D1.1_Part-C + AWS-D1.8_Annex-A_§A7 + ASME-V_Art. 2, 5 & 7			
Inspection Requirement Spec.				Ref. Drawing/s				&	
				Weldment Delivery location					

**NCPFIRST**

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Reference Sketch-A		Reference Sketch-B	

**TESTING REQUIREMENTS for RECEIVED MATERIAL**

Item	TYPE	Grade	Material Shape	RT		UT		MPT		LPT	HTr <sup>o</sup>	TEST COUPONS REQUIREMENT					
				Code	%	Code	%	Code	%	%	By Mill	Simulated HT-Cycle	Tensile Test Nº	HB Nº	Kv		
1	Structural Steel	S355J2-M	HEB-300	ASME-V_Art.2	100	ASME-V_Art.5	100	ASME-V_Art.7	100	100	N						
2	Structural Steel	S355J2-M	HEB-200													168	
3	Structural Steel	S355J2-N	HEB-160														
4	Channel Steel	S355J2-N	UPN-100														
5	Angle Steel	S355J2-N															
6	Plate Steel																
7	Forging																
8	Pipe																
9	Casting																
10																	

Tech-Notes (\*) HTr = Heat treatment: which shall noted when required as: (Quenched & tempered = QT), (Normalized = N), (Normalized & tempered = NT), (Thermal Stress Relief = TSR) etc.

**TESTING REQUIREMENTS for PRODUCTION WELDED JOINTS**

Item	Joint Name	NDE (%): Before PWHT				NDE (%): After PWHT				TEST COUPON		Kv		PWHT-Data		
		RT	UT	MPT	LPT	RT	UT	MPT	Ed	HB-Sht-Nº	CVN-sht-Nº	°C	J	°C	H (hrs)	CR (°C/min)
1	Demand Critical	100			100		100		100					600		50 / 10
2	Primary Load Bearing															
3	Secondary Load Bearing															
4	Braces: Ties & Struts															
5	Gussets + Stiffeners															
6	Lifting Lug															
7	Collector-Frame															
8	Pipe Support															
9	CS-Pipe Groove															
10	SS-Pipe Groove															
11	Pipe Shoe															
12	Hand Rails + Ladders															
13	Longitudinal															
14	Vessel: Circumferential															
15	Vessel: Nozzle to Shell															
16	Vessel: Skirt Support															
17																

Tech-Notes CR =Cooling Rate, H = Holding-time, ST = Soak Time, HTr = Heat Treatment, Ed = Eddy Current

Acceptance Criterion According to AWS-D1.1-Part-C + AWS-D1.8-Annex-A\_§A7

**PRODUCTION FORMING DATA**

**PRODUCTION WELD OVERLAY AREAS**

Item	Description	Pos	HTr (d)	Coupon (c)	%Elg. (a)	Forming Thk (b)		Forming Type		Item	Test Method	Joint Name		Notes:
						Actual	Final	Hot	Cold			Circumf.	Longi.	
1		1G	Yes							1	RT/UT/MPT/LPT			Notes: (a) Fibre elongation (Refer to ASME-VIII Div.1 – UCS 85) (b) Actual Thk = Before forming, Final Thk = After forming (c) Test coupons shall be subjected to simulated Heat Treatment (HTr) including intermediate & or final HTr in accordance with ASME-VIII Div.1-UCS 85. (d) Heat treatment after forming shall be noted as: NT = Normalized and Tempered, TSR =Thermal Stress Relief, OT = Quenched and Tempered, N = Normalizing. (e) Unit size are in Millimetres (mm)
2									2	Chemical Test				
3									3	Ferrite Test				
4									4	Defect Removal				
5									5					

Review Code A = Approved as Final, C = Reviewed With Comments, F = For Information Only, R = Rejected,

xx/xx/20xx					
Rev.	Date	Prepared By	Checked By	EPC-Approver	Review-Code
Shop Address					QA/QC - Acceptance Stamp