ARC TECHNIC	**RAPORT DE EXAMINARE CU ULTRASUNETE GROSIMI** *UT Thickness Measurement Report* **Nr.7 Data: 05.03.2012** Cod F1-01 Ed.2 Rev.0	Page : 1/1
	Autorizatie ISCIR laborator control nedistructiv: **PLPTCR6/TIPE/008/14.06.2010**	

General data / *Date generale*

Client: TUV AUSTRIA ROMANIA	Plant/ *Instalatie.*: ADE	Equipment drawing./ :TANK 305 *Desenul echipamentului:*	S.N./Year *Serie/An* :
Request no. : ..... *Comanda nr. :*		Material : Thickness/*Grosime* : mm	Examination technique /*Tehnica de examinare* : SR EN 14127
Subansamblul / *Assembly :Shell 1÷8; bottom plate ;reinforcement ring of bottom;nozzles;bootom plate;roof plate;,roof columns; reinforcement ring of the roof*			

Examination conditions / *Conditii de examinare*

Instrument/*Aparat:*DM4DL	Serial no./*Serie:*01RRM4		Display resolution/*Rezolutie ecran* ☐ 0.01 mm ■ 0.1 mm		
Measurement range / *Domeniul de masura:* 0.6÷500 mm	Reading mode / *Mod de citire:* Direct/*Directa*				
Probes/*Traductori:* ■ DA301 ☐ DA319 ☐ DA305	Sonic velocity/ *Viteza:* 5920 m/s	Diameter/*Diametru:* ■ Ø10 mm ☐ Ø3 mm	Frequency/ *Frecventa:* 5 MHz	Test piece/ *Etalon:* Type/*Tip:* A3	Couplant/ *Cuplant:* vaselina
Piece surface / Suprafata piesei : ☐ clean metal/*metal curat* ☐ Painted/*vopsit*			Piece temperature /*Temperatura piesei* : 4°C		
Examination was performed according PO.01 procedure / *Examinarea a fost efectuata conform procedurii PO .01*					

Examination result / *Rezultatul examinarii*

Appendix no.1/ *Anexa 1 :measurement values-(*7 pages/*pagini*); Appendix no.2/ *Anexa* 2:drawings-(3 pages/*pagini*)
Measurement points / *Nr. total puncte masurate*: 1248 puncte
Minimal value / *Valoare minima:4,0mm(shell8-plate 8);4,8mm(bottom- plates 23;33);3,0 mm(roof plate); 10,8 mm(roof columns);5,4mm(R10);6,2 mm (bottom plate inside);6,2 mm (bottom plate outside)*
Examination date / *Data efectuarii examinarii* : 05.03.2012
Observatii :

07-03-2012

	Nume si prenume/ *Name*	Autorizatie/*Qualification*		Nivel / *level*	Semnatura/ *Signature*
		CR 6 ISCIR ☐	EN473 ☐		
Operator END / *NDT Operator*	TATU MIHAI	11		☐ ☐ ☐ 2	
Operator END / *NDT Operator*	RADUCANU RICHARD	13		☐ ☐ ☐ 2	
Sef laborator/ *Head of Lab.*	ING.COIPAN CARMEN	5295		☐ ☐ ☐ 2	

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Appendix no. 1 to UT Report no: 7/06.02.2012
TANK 305

SHELL No:1

	PLATE 1									PLATE 2			
	I	II	III	IV	V	VI	VII	VIII	IX	I	II	III	IV
1	9.7	9.8	9.7	9.8	9.9	9.9	9.8	9.8	9.7	9.7	9.7	9.6	9.6
2	9.9	9.9	9.8	9.9	9.9	9.9	9.9	9.3	9.9	9.8	9.8	9.5	9.8
3	9.6	9.6	9.7	9.7	9.5	9.7	9.5	9.5	9.6	9.5	9.6	9.4	9.7

	PLATE 3					PLATE 4							
	I	II	III	IV	V	I	II	III	IV	V	VI	VII	VIII
1	9.8	9.7	9.6	9.7	9.6	9.8	9.7	9.8	9.8	9.7	9.7	9.7	9.8
2	9.8	9.6	9.0	9.8	9.7	9.7	9.9	9.9	9.7	9.8	9.9	9.8	9.5
3	9.5	9.4	9.2	9.7	9.4	9.6	9.6	9.5	9.6	9.7	9.6	9.5	9.7

	PLATE 5									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.7	9.8	9.7	9.7	9.6	9.7	9.7	9.7	9.8	9.7
2	9.6	9.6	9.8	9.6	9.8	9.9	9.5	9.8	9.9	9.1
3	9.7	9.7	9.9	9.8	9.4	9.4	9.5	9.6	9.6	9.4

	PLATE 6									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.7	9.6	9.8	9.6	9.7	9.6	9.8	9.7	9.7	9.6
2	9.8	9.8	9.9	9.7	9.5	9.5	9.7	9.8	9.8	9.8
3	9.5	9.7	9.5	9.9	9.4	9.3	9.6	9.5	9.3	9.6

	PLATE 7									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.7	9.6	9.7	9.7	9.8	9.7	9.6	9.8	9.8	9.7
2	9.8	9.8	9.8	9.7	9.9	9.8	9.7	9.5	9.9	9.6
3	9.6	9.6	9.5	9.6	9.4	9.7	9.5	9.6	9.7	9.5

	PLATE 8									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.6	9.8	9.7	9.7	9.8	9.9	9.8	9.9	9.7	9.7
2	9.7	9.7	9.6	9.6	9.7	9.6	9.7	9.8	9.8	9.8
3	9.8	9.5	9.6	9.5	9.7	9.7	9.7	9.7	9.6	9.6

	PLATE 9									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.7	9.8	9.8	9.7	9.8	9.7	9.8	9.8	9.7	9.8
2	9.8	9.7	9.7	9.8	9.6	9.6	9.7	9.7	9.7	9.9
3	9.6	9.4	9.5	9.6	9.4	9.6	9.4	9.4	9.7	9.5

	PLATE 10									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.8	9.8	9.8	9.8	9.9	9.7	9.9	9.9	9.8	9.9
2	9.8	9.8	9.8	9.9	9.9	9.7	9.9	9.9	9.9	9.9
3	9.5	9.5	9.5	9.7	9.8	9.8	9.9	9.8	9.5	9.6

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	PLATE 11									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.8	9.8	9.9	9.9	9.8	9.8	9.8	9.8	9.9	9.8
2	9.9	9.8	9.9	9.9	9.8	9.9	9.9	9.9	9.8	9.8
3	9.8	9.7	9.7	9.7	9.8	9.5	9.7	9.7	9.6	9.5

	PLATE 12									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.9	9.9	9.8	9.9	9.8	9.9	9.8	9.8	9.9	9.8
2	9.9	9.8	9.9	9.6	9.8	9.6	9.8	9.9	9.8	9.7
3	9.4	9.7	9.4	9.8	9.5	9.5	9.6	9.7	9.5	9.9

	PLATE 13									
	I	II	III	IV	V	VI	VII	VIII	IX	X
1	9.9	9.8	9.9	9.8	9.8	9.8	9.8	9.8	9.8	9.8
2	9.8	9.8	9.7	9.9	9.8	9.8	9.8	9.9	9.9	9.9
3	9.5	9.6	9.6	9.8	9.6	9.3	9.2	9.8	9.5	9.8

SHELL 2

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
8.2	8.3	8.6	8.2	8.3	8.0	8.0	8.2	8.2	8.1	8.0	8.1	8.0	8.0	8.0

PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
8.0	8.2	8.1	8.2	8.2	8.1	8.1	8.0	8.2	8.1	8.2	8.3	8.3	8.3	8.4

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
8.2	8.2	8.2	8.3	8.1	8.3	8.2	8.3	8.3	8.2	8.2	8.2	8.2	8.3	8.3

PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
8.3	8.4	8.2	8.3	8.4	8.4	8.2	8.0	8.2	8.2	8.3	8.3	8.1	8.2	8.2

SHELL 3

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.5	7.5	7.3	7.4	7.4	7.4	7.3	7.0	7.3	7.3	7.2	7.3	7.3	7.3	7.3

PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.3	7.4	7.2	7.2	7.3	7.3	7.3	7.2	7.1	7.2	7.5	7.5	7.6	7.6	7.6

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.6	7.6	7.8	7.8	7.6	7.7	7.6	7.8	7.7	7.7	7.3	7.4	7.5	7.5	7.5

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PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.5	7.5	7.4	7.4	7.4	7.4	7.4	7.4	7.4	7.5	7.5	7.4	7.5	7.3	7.3

PLATE 13				
1	2	3	4	5
7.3	7.2	7.3	7.4	7.3

SHELL 4

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.1	6.9	6.6	7.2	6.8	6.5	6.5	6.5	6.6	6.6	6.7	6.9	6.5	6.9	6.8

PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.5	6.7	6.4	6.6	6.5	6.5	6.4	6.5	6.6	6.5	6.5	6.6	6.5	6.6	6.7

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.1	7.0	7.1	7.0	7.0	7.5	7.4	6.7	6.6	6.5	6.8	6.6	6.8	6.6	6.7

PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.7	6.6	6.5	6.6	6.5	6.6	6.5	6.6	6.7	6.7	6.8	6.4	7.8	7.5	7.5

SHELL 5

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.7	5.8	5.9	5.6	5.4	5.6	5.5	5.8	5.9	5.4	5.8	5.7	5.6	5.5	5.4

PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.6	5.5	5.3	5.4	5.4	5.5	5.7	5.5	5.6	5.6	5.5	5.7	5.5	5.9	5.7

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.7	5.9	5.6	5.7	5.4	6.0	5.9	5.8	5.9	5.9	5.8	5.6	5.8	5.9	6.1

PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.8	5.9	5.9	5.8	5.7	5.8	5.9	5.8	5.8	5.9	5.7	5.8	5.8	5.7	5.9

PLATE 13				
1	2	3	4	5
6.0	5.9	6.0	5.7	5.6

SHELL 6

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.1	6.0	5.8	5.7	5.6	5.5	5.6	5.5	5.6	5.5	5.6	5.3	5.5	5.5	5.7

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PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.4	5.5	5.2	5.4	5.5	5.4	5.8	5.7	5.3	5.7	5.8	5.7	5.6	6.0	5.9

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.8	5.8	5.4	5.9	5.8	6.0	6.1	6.0	5.8	5.7	5.8	6.0	5.7	5.9	5.8

PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.8	5.9	5.7	5.8	5.4	5.7	5.8	5.6	5.4	5.3	5.9	6.2	6.0	5.7	5.5

PLATE 13					PLATE 14					PLATE 15				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.6	5.8	5.9	5.4	5.5	6.0	6.1	5.4	5.6	5.7	5.4	5.7	5.5	5.6	5.9

SHELL 7

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.9	5.6	5.9	5.2	4.9	4.8	5.0	5.4	5.3	4.8	4.5	4.8	4.7	5.1	5.0

PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.5	4.7	4.4	4.8	4.9	4.5	4.6	4.8	4.9	4.2	4.4	4.7	5.5	5.1	5.0

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.5	4.1	4.8	4.7	4.6	4.2	4.5	5.4	5.2	5.0	5.1	5.3	5.1	5.1	5.0

PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
5.2	5.2	5.1	5.0	4.7	5.2	5.1	5.2	5.0	4.8	5.2	5.1	5.3	5.3	5.2

SHELL 8

PLATE 1					PLATE 2					PLATE 3				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.9	5.0	5.3	5.0	4.7	5.0	4.9	5.9	5.6	5.5	5.3	4.8	4.9	5.7	4.8

PLATE 4					PLATE 5					PLATE 6				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.9	4.5	4.5	4.7	4.6	4.7	4.9	5.0	4.8	4.6	4.3	4.4	4.2	4.3	4.6

PLATE 7					PLATE 8					PLATE 9				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.3	4.6	5.1	4.2	4.5	**4.0**	4.6	4.4	4.7	5.1	4.4	4.6	4.5	4.8	5.1

PLATE 10					PLATE 11					PLATE 12				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
4.8	4.6	4.9	5.3	5.1	4.9	5.2	5.1	4.2	4.3	4.3	4.6	4.5	4.7	4.5

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Appendix no. 1 to UT Report no: 7/06.02.2012
TANK 305

PLATE 40					PLATE 41					PLATE 42				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.1	6.0	5.9	6.2	6.4	6.4	7.6	7.5	7.6	7.1	6.5	6.2	6.6	6.4	6.5

PLATE 43					PLATE 44					PLATE 45				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.0	6.1	6.1	5.9	6.4	6.4	6.4	6.1	6.2	6.2	6.7	6.6	6.8	6.8	6.4

PLATE 46					PLATE 47					PLATE 48				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.6	6.7	6.4	6.6	6.2	5.9	6.4	6.6	6.4	6.6	5.2	5.9	5.5	6.2	6.4

PLATE 49					PLATE 50					PLATE 51				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.2	6.6	6.5	6.1	6.2	6.4	6.4	6.1	6.3	5.9	6.7	6.6	6.9	7.1	6.4

PLATE 52					PLATE 53					PLATE 54				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
6.1	6.0	5.9	6.2	6.3	7.1	6.4	7.6	7.5	7.1	7.5	7.1	7.4	7.3	7.1

PLATE 55					PLATE 56					PLATE 57				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.7	7.4	7.0	7.5	7.1	6.9	7.4	7.3	7.9	7.8	7.4	7.3	7.5	7.2	7.6

PLATE 58					PLATE 59					PLATE 60				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.7	7.8	7.5	7.7	7.8	7.8	7.7	7.4	7.6	7.5	7.6	7.7	7.5	7.3	7.8

PLATE 61					PLATE 62					PLATE 63				
1	2	3	4	5	1	2	3	4	5	1	2	3	4	5
7.8	7.7	7.6	7.5	7.4	8.3	8.1	7.9	7.8	7.6	7.3	7.2	7.1	7.4	7.3

PLATE 64					PLATE 65				
1	2	3	4	5	1	2	3	4	5
7.4	7.3	7.1	6.9	7.1	7.0	7.3	7.4	7.4	7.2

ROOF PLATE

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
4.3	4.3	4.8	4.4	5.6	4.7	4.1	4.1	4.0	4.3	4.3	4.0	4.2	3.8	4.0	4.2	4.1

18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
3.8	3.8	**3.0**	3.2	4.7	3.6	3.4	3.8	3.8	3.3	**3.0**	3.5	3.4	3.6	3.6	3.4	3.7

35	36	37	38	39	40	41	42	43	44	45	46	47	48	49	50	51	52
3.9	3.1	3.7	3.5	3.5	3.6	3.8	3.1	3.7	5.2	3.8	3.6	4.4	5.0	3.7	3.7	3.8	3.9

ROOF COLUMNS

	I	II
A	10.9	**10.8**
C	11.3	11.2
E	11.2	11.0
G	**10.8**	10.9

NOZZLES

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NOZZLES

	R7 DN350	R8 DN200	R9 DN100	R10 DN200	R11 DN200	GV1 DN400	GV2 DN400
A	9.5	7.3	6.7	5.5	7.3	10.7	10.6
C	10.1	7.2	6.5	**5.4**	7.5	10.0	10.8
E	10.3	7.0	6.2	5.6	7.2	10.3	10.7
G	9.8	6.9	6.1	5.8	7.5	10.1	10.5

REINFORCEMENT PLATES FOR THE EACH NOZZLE

R7	R8	R9	R10	R11	GV1	GV2
6.8	6.6	6.5	6.5	**6.4**	9.0	9.4

BOTTOM PLATE INSIDE

1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
6.4	6.5	6.8	6.6	**6.2**	7.3	7.7	7.9	6.9	6.8	6.3	6.5	6.6	7.4	7.5	7.8	7.6

18	19	20	21	22	23	24	25	26	27	28	29	30	31	32	33	34
7.5	8.0	8.1	8.2	7.9	7.0	7.3	7.5	7.6	7.8	7.7	7.4	7.8	7.6	7.9	8.0	8.2

BOTTOM PLATE OUTSIDE

1	2	3	4	5	6	7	8
6.5	6.7	7.0	7.3	7.4	7.9	7.1	**6.2**

OBSERVATII: - La Roof Plate s-au executat masuratorile aleatoriu de pe schela si scara de incendiu;

Nota : Se interzice reproducerea partiala a acestui document fara acordul scris al S.C. ARCTECHNIC COM. S.R.L. /
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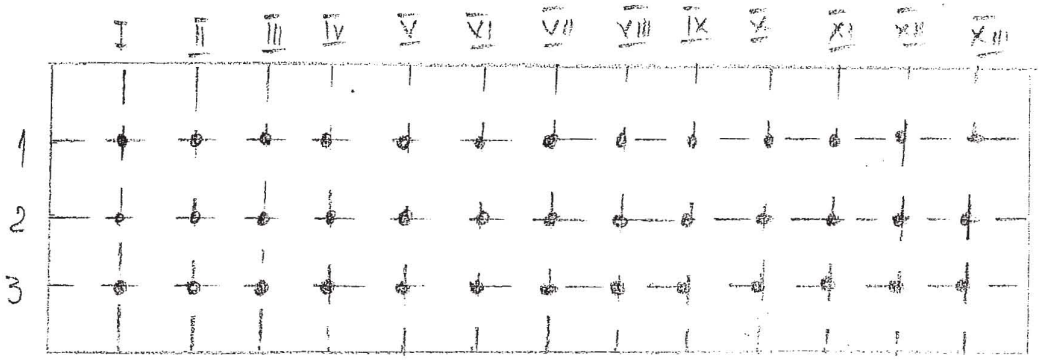
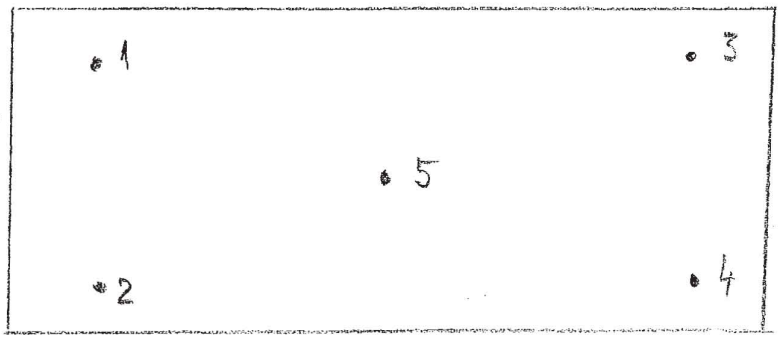
SHELL No. 1

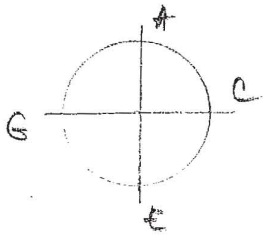
grid 500 × 500 mm



SHELL No.2 TO SHELL No. 8

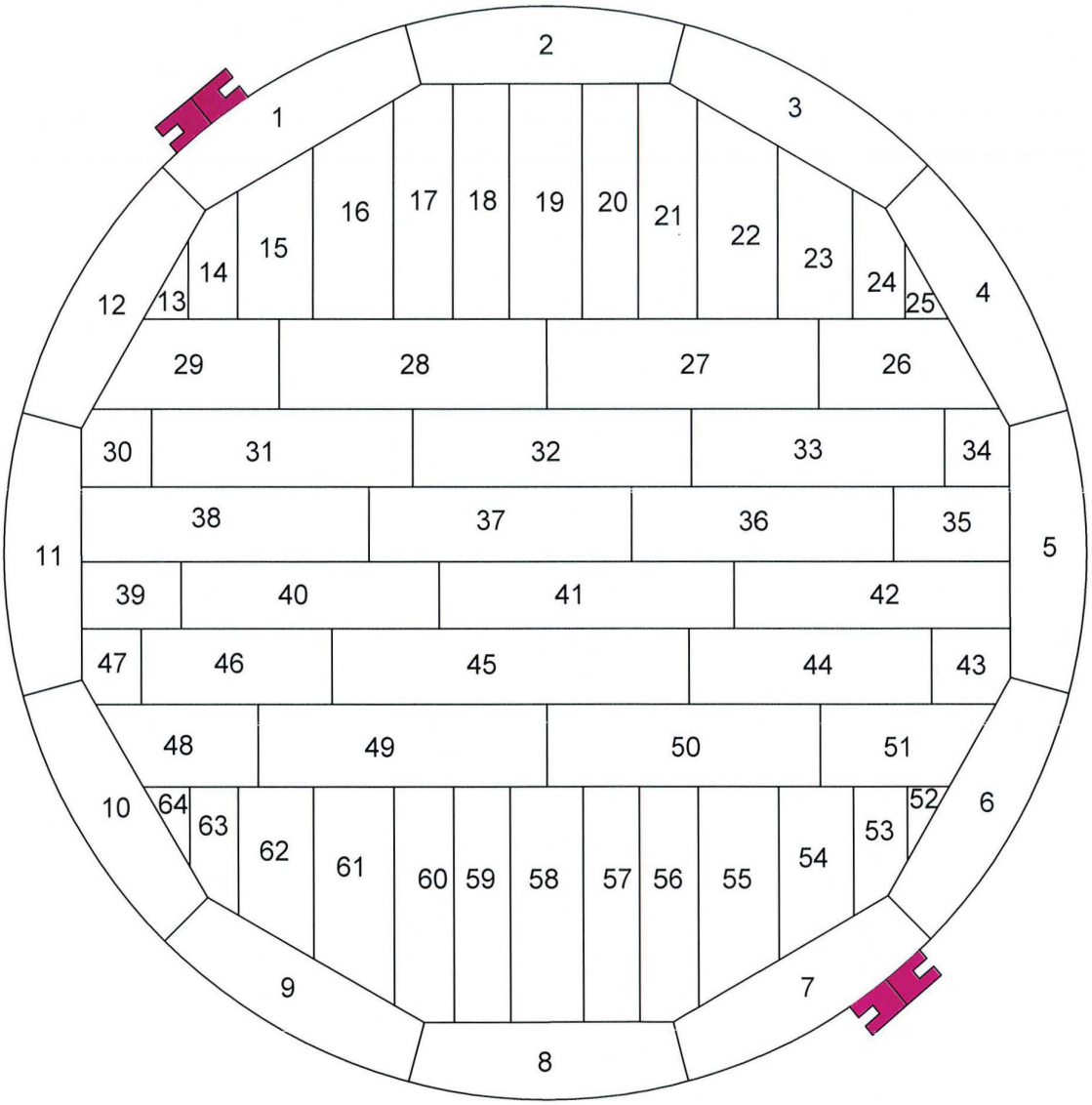


NOZZLE



S.C. ARCTECHNIC CCM S.R.L.
LABORATOR NDT
J29/1407/2007; RO 19580146

Tank T 305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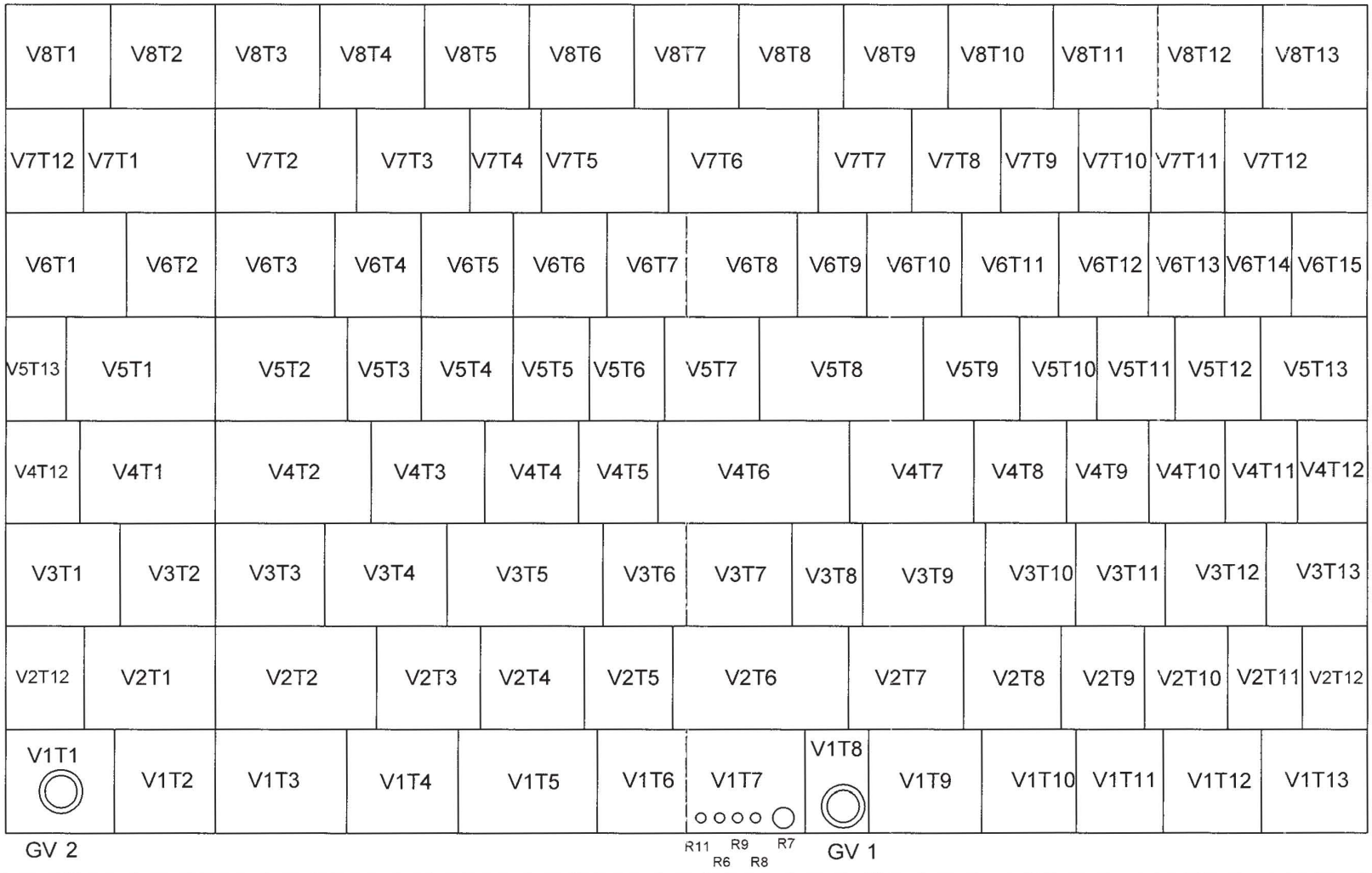
Tank T 305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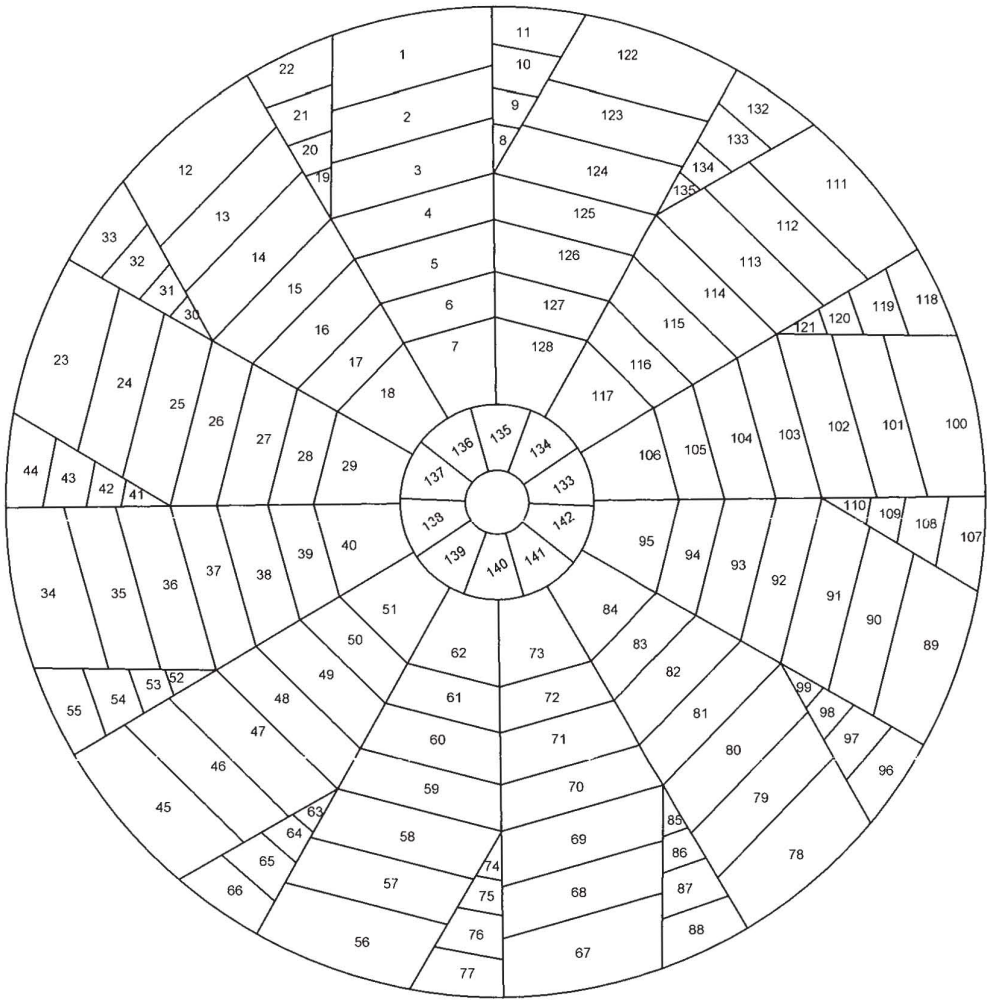
Tank T 305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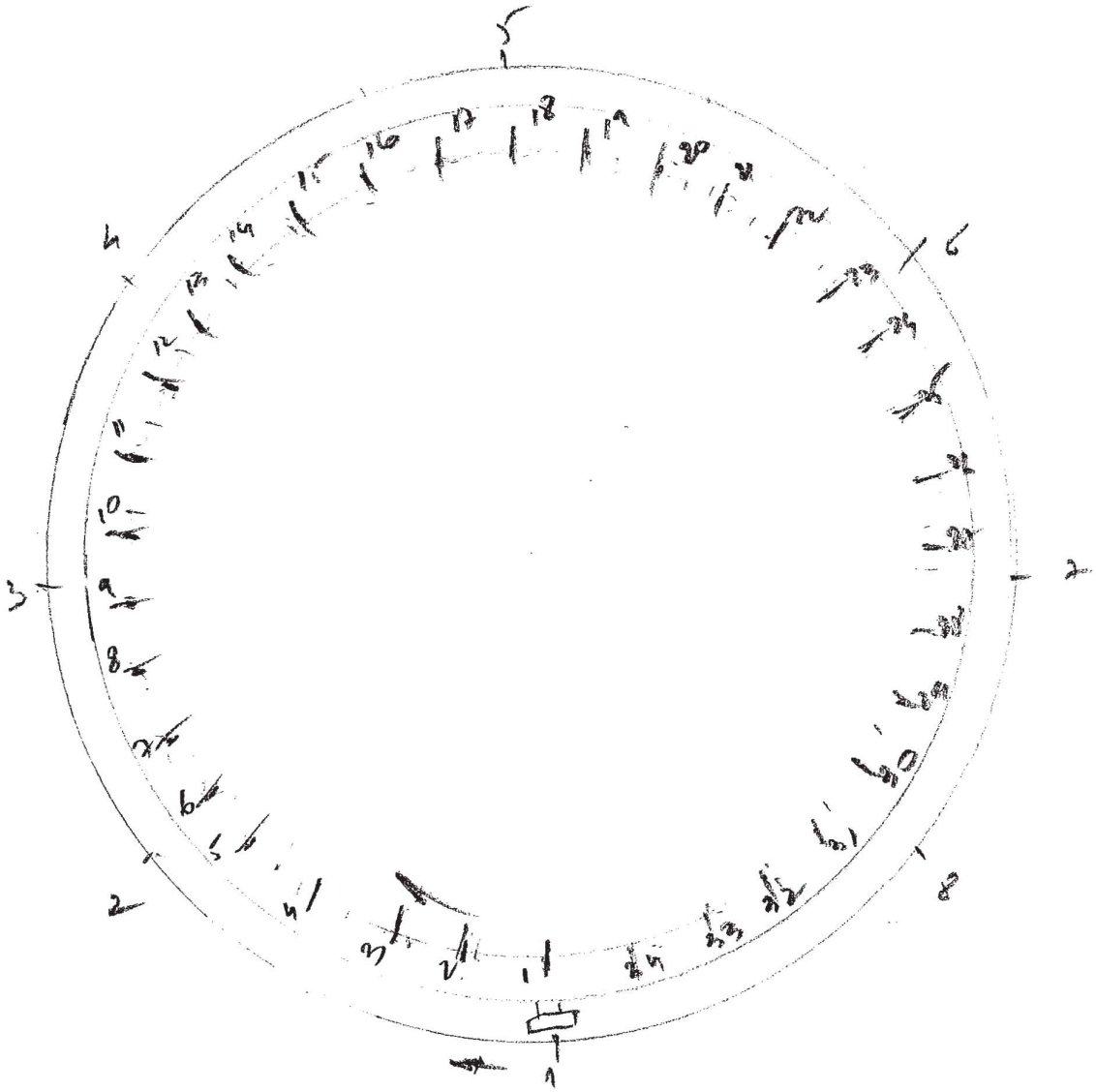
BOTTOM PLATE inside & outside

T305



Obs. The bottom plate outside is an extra
return door to (Cryogenics now)