

Penetrant test report



Report number LW26-0253-01 PT
Customer name AAS STEEL PTY LTD
Address 9 Trade Place Pakenham VIC Australia 3810
Requested by Shan Senn
Purchase Order 01000824
Accredited laboratory LMATS Melbourne Laboratory
Test date 24/02/2026
Job address 13 Paramount Road West Footscray
Job description Visible dye penetrant testing on 350NB header weldments
Identification Job: VMM00120 NEXT DC M3 STAGE 2; Drawing: SDRG-B-0201-8241
Material grade Stainless Steel- Grade not specified
Test specification Client's requirement - Report findings
Test method AS ISO 3452.1:2021-PT - colour contrast
Test designation ISO 3452-2, IICeL2-Colour contrast (visible), solvent removal & developer, L2 sensitivity
Test procedure TP-PT-15 (I2, R1)
Production Stage After fabrication, in-situ
Test area Weld zone & associated HAZ (Refer Table 1 for identification)
Test temperature 18°C to 21 °C approximate range
Equipment L004778 Light meter HoldPeak 881D
Lighting conditions White light illuminance 2655 lx
Surface condition As welded, blended intermittently
Surface preparation Solvent flushed and wiped. Natural evaporation.
Chemicals details

Brand name	Batch No.	Dwell time (Mins.)
MR Chemie MR85	85/2005	Not applicable
MR Chemie MR311-R	221108	20
MR Chemie MR70I	70I/2003	15
MR Chemie MR85	85/2005	Not applicable

Precleaner
Penetrant
Developer
Remover
Approved tester Errol Minnie (ISO 9712 & SNT-TC-1A Level II in VT, RT, MT, PT & UT, ASNT NDT Level III VT, RT)
Other testers Lachlan Hooppell (SNT-TC-1A and AINDT L2 - RT MT PT)
Test results Refer to Table 1 for test area identification and results



Accreditation No. 15840

Accredited for compliance with
ISO / IEC 17025 - Testing

Signatory
Lachlan Hooppell
(SNT-TC-1A and AINDT L2 - RT MT PT)

Report issued on 25/02/2026

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Table 1: Test items identification (provided by the client) and results (All dimensions in mm unless stated otherwise)

Identification	Spool No.	Weld No.	Description	Discontinuities
North end	Spool 1	1	Bottom header	No relevant indications detected
North end	Spool 1	2	Bottom header	No relevant indications detected
North end	Spool 1	3	Bottom header	No relevant indications detected
North end	Spool 1	4	Bottom header	No relevant indications detected
North end	Spool 1	5	Bottom header	No relevant indications detected
North end	Spool 1	6	Bottom header	No relevant indications detected
North end	Spool 2	1	Bottom header	Linear porosity/ overlap/ lack of fusion at 12-5 o'clock position when facing north
North end	Spool 2	2	Bottom header	Porosity at 3-4, 11, and 12 o'clock position when facing east
North end	Spool 2	3	Bottom header	Overlap at 9 o'clock position when facing west
North end	Spool 2	4	Bottom header	No relevant indications detected
North end	Spool 2	5	Bottom header	Lack of fusion at 9 o'clock position when facing west
North end	Spool 2	6	Bottom header	Porosity at 9 o'clock position, overlap at 4 o'clock and 7-8 o'clock position when facing north

Test restrictions

Restricted access to 5-7 o'clock position of weld between header and grating, could not adequately apply dye and developer in these positions in-situ

Comments

Refer to attached images

Test, inspection process specific notes

- This test method cannot detect sub-surface discontinuities or surface opening discontinuities covered with coating.

Normative general notes

1. Test and inspection items may be discarded after 6 weeks, unless alternative arrangements are made with LMATS.
2. Samples, identification of samples and all job specific details were supplied by the client. The test results relate only to the items tested or sampled.
3. Any stated nominal pipe sizes and nominal thickness of the material were provided by the client.
4. Where applicable, the Measurement Uncertainty (MU) applies to the test results as per LMATS procedure. MU can be obtained by contacting one of LMATS ISO 17025 accredited laboratories.

5. Acceptance criteria is applied from the test specification. If the test specification does not include acceptance criteria, then the test or inspection results should be referred to a competent authority for further action.

6. Refer to the attached revision notes if this report has been revised. This report shall not be reproduced except in full without approval of the issuing laboratory to ensure that parts of a report are not taken out of context. The client or their representatives shall not edit this report.

7. LMATS or its professional indemnity insurance provider do not indemnify the contents within this report or the conformity of a tested product unless the invoice for the reported work is paid in full within the agreed credit terms. Reports will be revoked if the invoice for the completed work is not paid in full.

Abbreviations used in this report

A - No discontinuities detected

CP - Crater Pipe

F - Failed

IC - Copper Inclusion

IO - Oxide Inclusion (wagon tracks)

KL - Longitudinal crack

LP - Incomplete root Penetration

NRRD - No Recordable Reflections Detected

p.d. - Processing / film Defects

PU - Uniform Porosity

SGI - Incompletely filled Groove

SMH - Hammer Mark

SSP - Spatter

SXP - Excessive Penetration

BT - Burn (melt) Through

DNC - Does Not Comply

GP - Gas Pore

IL - Linear Inclusion (slag line)

IT - Tungsten Inclusion

KT - Transverse crack

LR - lack of Root fusion (missed edge)

NUSID - No unacceptable Surface Indications Detected

PG - Localized Porosity

RP - Report findings

SGS - Shrinkage Groove

SMT - Tool Mark (chipping mark)

SUC(e) - Undercut External

WH - Worm Hole

C - Comply

EC - Elongated Cavity (hollow bead)

HiLo - Linear misalignment

IN - Inclusion

KC - Crater crack

LI - lack of Inter-run fusion

LS - lack of Side fusion

P - Passed

PL - Linear Porosity

SED - Excessive Dressing (underflushing)

SMG - Grinding Mark

SRC - Root Concavity (Suck back)

SUC(I) - Undercut Internal

REVOKED



Image 1 of 13 - Bottom header spool 1- north end



Image 2 of 13 - Bottom header spool 2 W1



Image 3 of 13 - Spool 2 W1- 130mm linear porosity



Image 4 of 13 - Spool 2 W1- 130mm overlap/ lack of fusion; 10mm porosity



Image 5 of 13 - Bottom header spool 2 W2 & W3



Image 6 of 13 - Spool 2 W2- 5mm porosity x 3



Image 7 of 13 - Spool 2 W2- 90mm linear porosity & poor stop/start



Image 8 of 13 - Spool 2 W3- 10mm overlap & poor stop/start



Image 9 of 13 - Spool 2 W3- 7mm overlap



Image 10 of 13 - Bottom header spool 2 W4, W5 & W6



Image 11 of 13 - Spool 2 W5- 20mm overlap/ lack of fusion

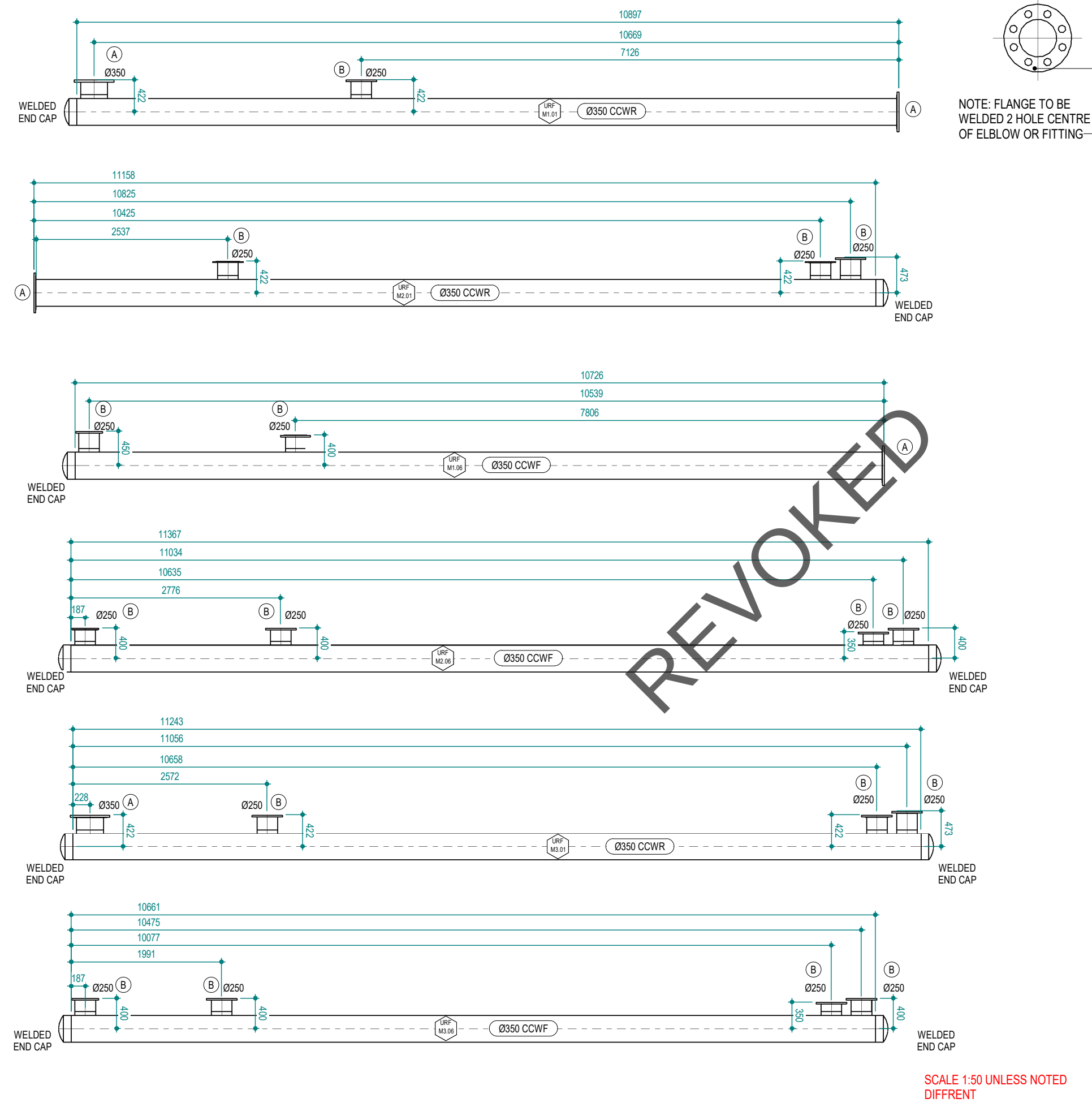


Image 12 of 13 - Spool 2 W6- 70mm overlap/ lack of fusion; 10mm poor restart; 10mm porosity



Image 13 of 13 - Spool 2 W6- 20mm overlap/ lack of fusion

REVOKED



MATERIAL LIST				
CODE:	QTY:	SIZE:	DESCRIPTION OR CUTTING LENGTH:	END TREAT:
A	5	Ø350	TABLE 'E' FLANGE	
B	17	Ø250	TABLE 'E' FLANGE	
PIPE SPEC: STAINLESS STEEL GRADE 304 SCHEDULE 10				
SYMBOL ABBREVIATIONS				
WELDER			DATE	
MATERIAL AS LISTED				
DIMENSIONS CHECKED				
CHECK FOR SQUARE				
CHECK CONFIGURATION				
IDENTIFICATION CHECK				
MATERIALS ORDERED BY			☐	SITE
			☐	WORKSHOP
DATE REQUIRED				
 talented people... sustainable solutions Melbourne (Head Office) 11 Corporate Avenue Rowville, VIC 3178 T: +61 3 9751 4222 Sydney Level 5 113 Wicks Road Macquarie Park, NSW 2113 T: +61 2 8047 4610 Adelaide 85 Ormond Street Hindmarsh, SA 5007 T: +61 8 7969 6677 D&E Air Conditioning Pty Ltd www.de-air.com.au E: drafting@de-air.com.au ABN: 24 158 631 979 ACN: 158 631 979 ARC: #AU29715 Perth 23 Wheeler Street Belmont, WA 6104 T: +61 8 6247 5970 Geelong 36-39 Industrial Place Breakwater, VIC 3219 T: +61 3 5229 2200 Brisbane 16 Container Street Tingalpa, QLD 4173 T: +61 7 3175 4999				
JOB: VMM00120 NEXT DC M3 STAGE 2				
DATE: 08.09.25		REF.DRG.NO: SDRG-B-0201-8241		
DRAWN: T.MOSER		SKETCH NO: URF-B1-M-CCW-001		FC-1