



FE/GK **TEKNISKA RÖNTGENCENTRALEN AB**

STOCKHOLM GÖTEBORG MALMÖ

checked 21/9 55

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Uppdragsgivare: AB Lindholmens Varv
Göteborg

Intyg: G 2620

Marine boiler 141 P 20. Manufacturing number 3110.

Investigation carried out on 1/9-16/9-55.

On the instructions of AB Lindholmens Varv an x-ray examination has been made of the welded joints on a marine boiler 141 P 20 constructed in the workshops. The investigation covered all longitudinal and circumferential welds.

The films taken were marked with the number of the boiler and with serial film numbers in accordance with the accompanying film list. The films overlap one another by a few centimetres. At the same time a number has also been photographed at each end of the film in such a way that the first number is also shown at the end of any preceding film and the last number at the beginning of following film.

For the purpose of checking any faults the wire scale TRC Fe II has also been photographed. The dimensions of the wire are 0.5, 0.6, 0.8, 1.0, 1.3, 1.6 and 2.9 mm.

The films have been classified in accordance with a classification scale graduated from 5 to 1, in which 5 represents the highest and 1 the lowest classification. For pressure containers in general a classification figure 3 is required.

An examination of the films taken has given the following results:



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Circumferential weld 1

Film

1-2	Very few blowholes	5
2-3	Blowholes	4
3-4	-	5
4-5	Very few blowholes	5
5-6	Very few blowholes	5
6-7	Very few blowholes	5
7-8	-	5
8-9	Very few blowholes	4
9-10	Blowholes, small slag inclusions	4
10-11	Blowholes, small slag inclusions	4
11-12	Blowholes	5
12-13	Very few blowholes	5
13-14	Very few blowholes	5
14-15	Very few blowholes	4
15-16	Blowholes	4
16-17	Blowholes	4
17-18	Very few blowholes, small slag inclusions	4
18-19	Blowholes	4
19-20	Very few blowholes, small slag inclusion	4
20-21	Blowholes, small slag inclusions	4
21-22	Very few blowholes, small slag inclusion	4
22-23	Blowholes, small slag inclusions	3
23-24	Very few blowholes, small slag inclusions	4
24-25	Blowholes	4
25-26	Blowholes, slag inclusions	3
26-27	Blowholes	4
27-28	Blowholes	4
28-29	Very few blowholes	5
29-30	Blowholes	4
30-31	Very few blowholes	5
31-32	Blowholes, small slag inclusion	4
32-33	-	5
33-34	Very few blowholes	5
34-35	Blowholes	4
35-36	Blowholes, small slag inclusions	4
36-1	Blowholes	4



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3.

Circumferential weld 2.

Film		
1-2	Blowholes	3
2-3	-	5
3-4	Very few blowholes	5
4-5	Blowholes, small slag inclusions	4
5-6	Very few blowholes	5
6-7	Blowholes	4
7-8	Very few blowholes	5
8-9	Very few blowholes	5
9-10	Blowholes	4
10-11	Blowholes	4
11-12	Blowholes	4
12-13	Blowholes, small slag inclusions	3
13-14	Very few blowholes	5
14-15	Very few blowholes, short root defect	3
15-16	Very few blowholes, small surface fault	5
16-17	Blowholes	3
17-18	Blowholes, small slag inclusions	4
18-19	-	5
19-20	-	5
20-21	Blowholes	3
21-22	Very few blowholes	5
22-23	Very few blowholes, small slag inclusions	4
23-24	Very few blowholes, small slag inclusions between the runs	4
24-25	Slag inclusions between the runs	3
25-26	Slag inclusions between the runs	3
26-27	Very few blowholes, short root defect	3
27-28	Small slag inclusions between the runs	4
28-29	Small slag inclusions	4
29-30	-	5
30-31	Very few blowholes, small slag inclusions	4
31-32	Slag inclusions	3
32-33	Very few blowholes	5
33-34	Elongated blowholes, small slag inclusions	3
34-35	Blowholes, small slag inclusions	4
35-36	Very few blowholes	5
36-1	Very few blowholes, small slag inclusions	4



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Circumferential weld 3.Film

1-2	Very few blowholes	5
2-3	Blowholes	4
3-4	-	5
4-5	Very few blowholes	5
5-6	Very few blowholes, small slag inclusion	4
6-7	Very few blowholes	5
7-8	Very few blowholes, small slag inclusion	4
8-9	Very few blowholes	5
9-10	Very few blowholes, small slag inclusions	4
10-11	Blowholes, small slag inclusions	4
11-12	Very few blowholes, slag inclusions	4
12-13	Blowholes	4
13-14	Blowholes	4
14-15	-	5
15-16	Blowholes	4
16-17	Very few blowholes	5
17-18	Very few blowholes	5
18-19	Very few blowholes, small slag inclusions	4
19-20	Blowholes, small slag inclusions	4
20-21	Very few blowholes, small slag inclusions	4
21-22	Very few blowholes, small slag inclusion	4
22-23	Blowholes, small slag inclusions	4
23-24	Very few blowholes	5
24-25	-	5
25-26	Very few blowholes, small slag inclusions	4
26-27	Very few blowholes, small slag inclusion	4
27-28	Blowholes, slag inclusions	3
28-29	Very few blowholes, small slag inclusions	4
29-30	Blowholes, small slag inclusions	4
30-31	-	5
31-32	Very few blowholes, small slag inclusions	4
32-33	-	5
33-34	Small slag inclusions	4
34-35	Blowholes, small slag inclusions	4
35-36	Blowholes, small slag inclusions	3
36-1	Blowholes, slag inclusions	3

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Longitudinal welds

Film

1-2	-	5
2-3	-	5
3-4	Very few blowholes	5
4-5	Blowholes in circumferential weld	4
6-7	Very few blowholes	5
7-8	Blowholes	4
8-9	Very few blowholes	5
9-10	Blowholes, small slag inclusions	4
11-12	Small slag inclusions	4
12-13	-	5
13-14	Very few blowholes, small slag inclusion	4
14-15	-	5
16-17	Very few blowholes	5
17-18	-	5
18-19	Very few blowholes	5
19-20	-	5
21-22	Very few blowholes	5
22-23	Blowholes, small slag inclusions	4
23-24	Small slag inclusions	4
24-25	Very few blowholes	5
26-27	Very few blowholes, small surface fault	5
27-28	Very few blowholes	5
28-29	Very few blowholes	5
29-30	Very few blowholes, small slag inclusions	4

Gothenburg, September 17th 1955.

TEKNISKA RÖNTGENTRALLEN AB

Fred Ekelöf

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