

GOTHENBURG FIRST ENTRY REPORT No 22156.



TEKNISKA RÖNTGENCENTRALEN AB

STOCKHOLM GÖTEBORG MALMÖ SUNDSVALL

checked 27/58

S.

Uppdragsgivare:

AB. Lindholmens Varv,
GÖTEBORG

Intyg:

G 2790

Marine boiler 141 P 25. Manufacturing number 3135.Investigation carried out on the 19/12 1955 - 10/1 1956.

On the instructions of AB. Lindholmens Varv an x-ray examination has been made of the welded joints on a marine boiler 141 P 25 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 any 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, 0,3 1,0, 1,3, 1,6 and 2,0 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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<u>Circumferential weld 1</u>		
1-2		
2-3	Very few blowholes	5
3-4		5
4-5		5
5-6	Very few blowholes	5
6-7		5
7-8		5
8-9		5
9-10		5
10-11		5
11-12		5
12-13		5
13-14		5
14-15		5
15-16	Very few blowholes	5
16-17		5
17-18		5
18-19		5
19-20		5
20-21		5
21-22		5
22-23		5
23-24		5
24-25		5
25-26	Very few blowholes	5
26-27		5
27-28		5
28-29		5
29-30		5
30-31		5
31-32		5
32-33	Very few blowholes	5
33-34		5
34-1		5

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

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

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Longitudinal welds

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

Göteborg January 17 th 1956.

TEKNISKA RÖNTGENCENTRALEN AB.

Sture Schütz

(Sture Schütz)



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