THE MATERIALS JOINING EXPERTS

Appendix 1.6.2
Girth Weld Inspection
Exxon Weld, 12-in. Pipe

Static UT Images at
Metallographic Cross-Section
Locations

THE MATERIALS JOINING EXPERTS

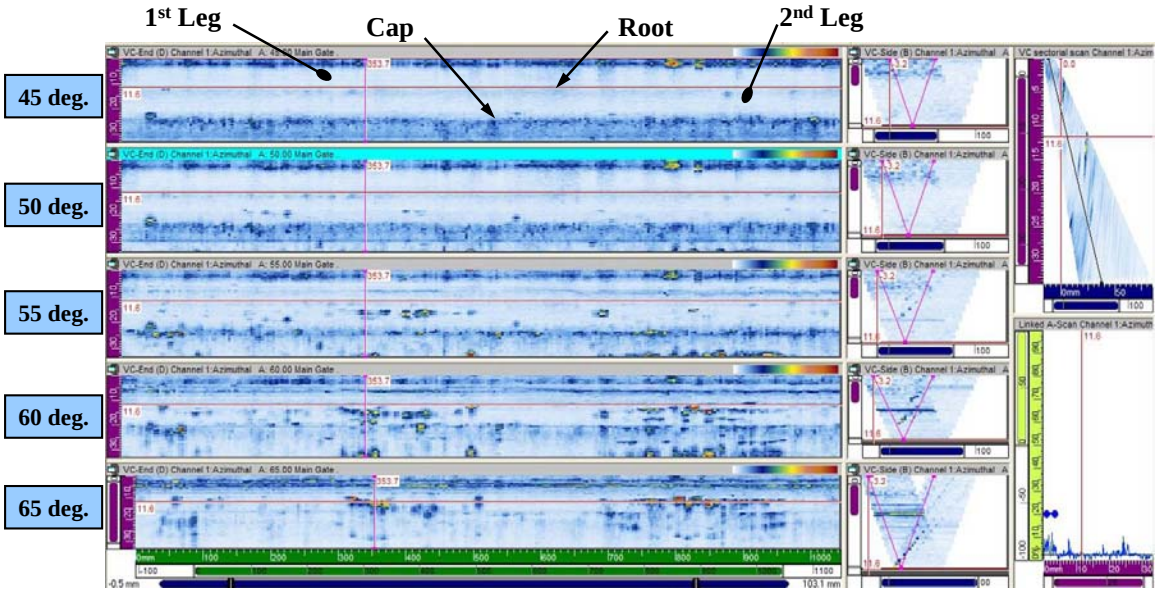
Overview

- 12.75-inch (324-mm) diameter OD pipe having a 0.45 -inch (11.4-mm) wall thickness
- Girth weld containing flaws provided by sponsor

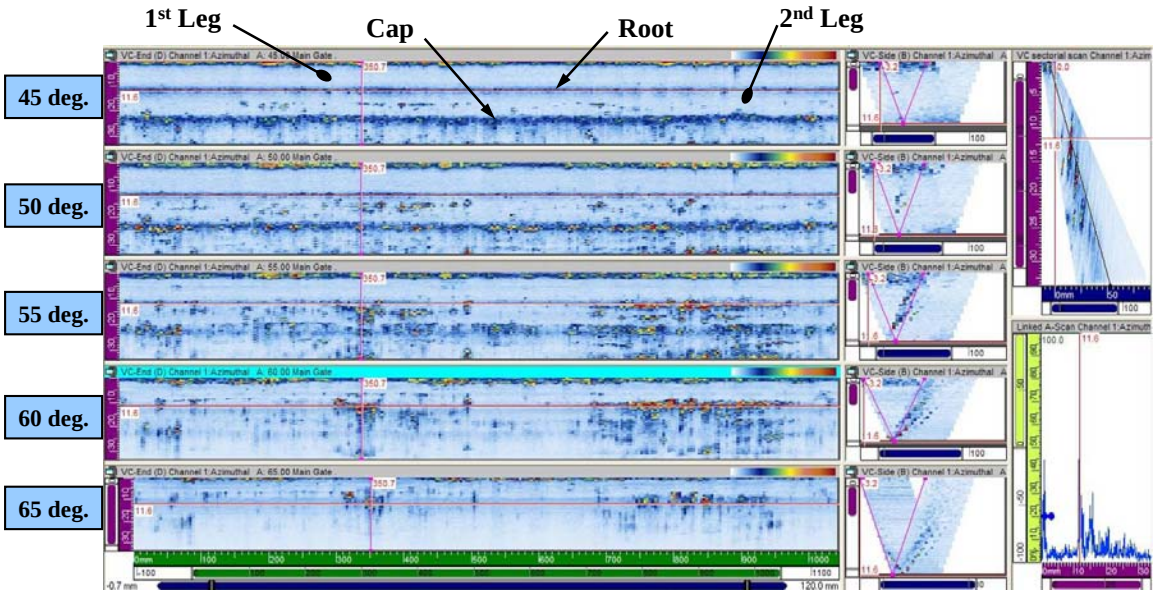
12-inch Diameter Pipe Sample

THE MATERIALS JOINING EXPERTS

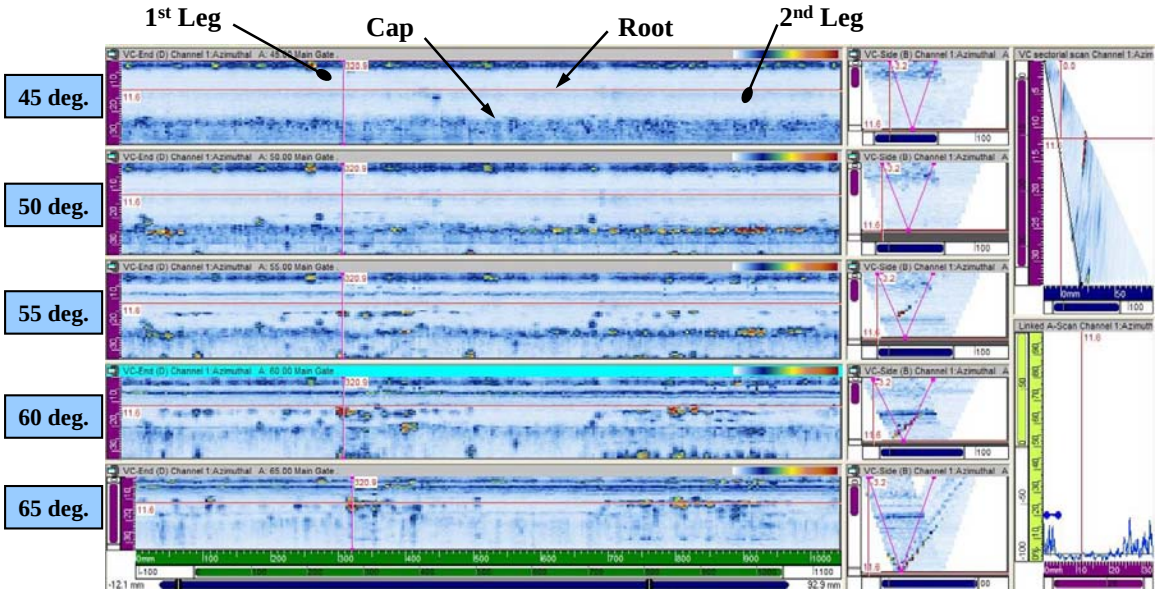
PA 4 MHz US Scan (12-in. Dia.)



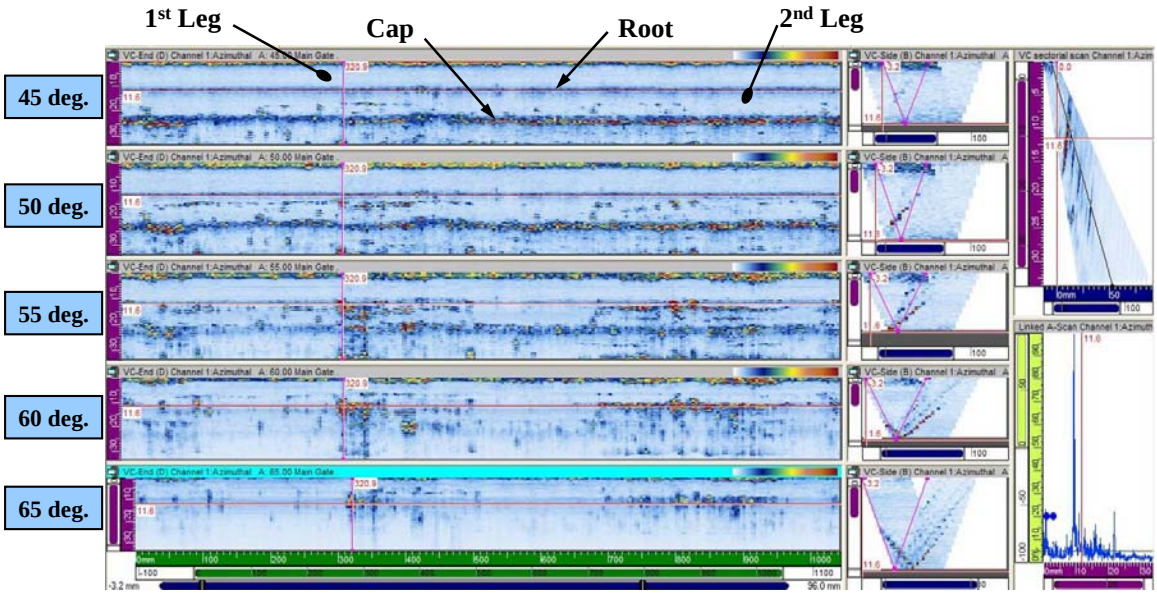
PA 7 MHz US Scan (12-in. Dia.)



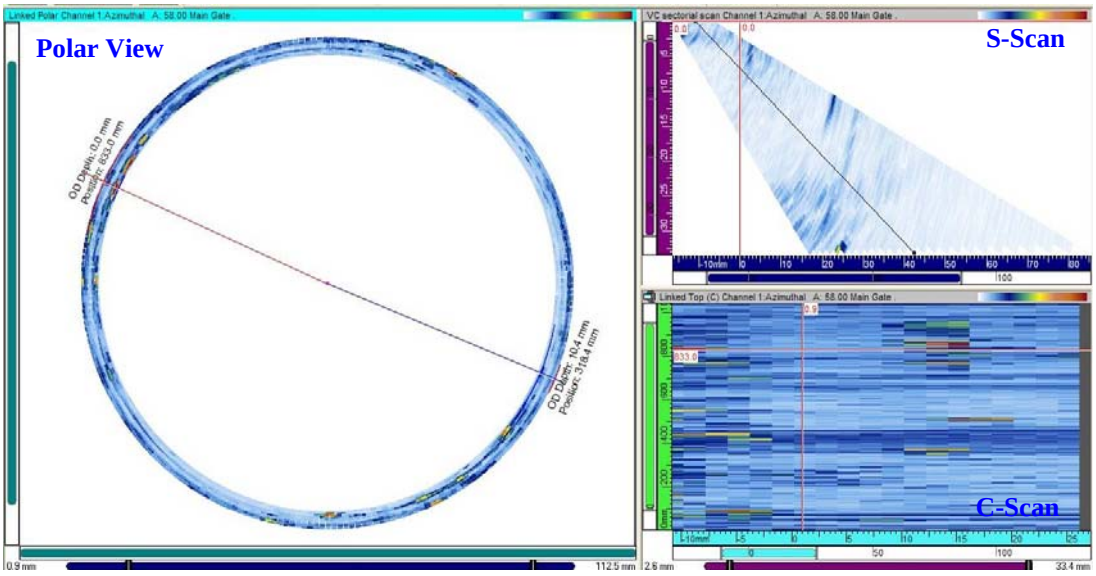
PA 4 MHz DS Scan (12-in. Dia.)



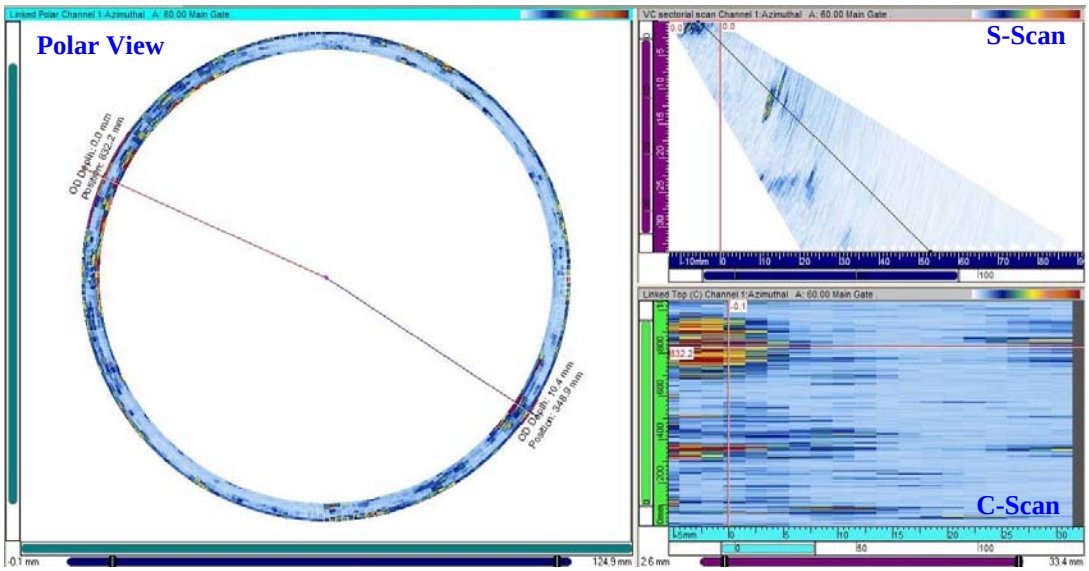
PA 7 MHz DS Scan (12-in. Dia.)



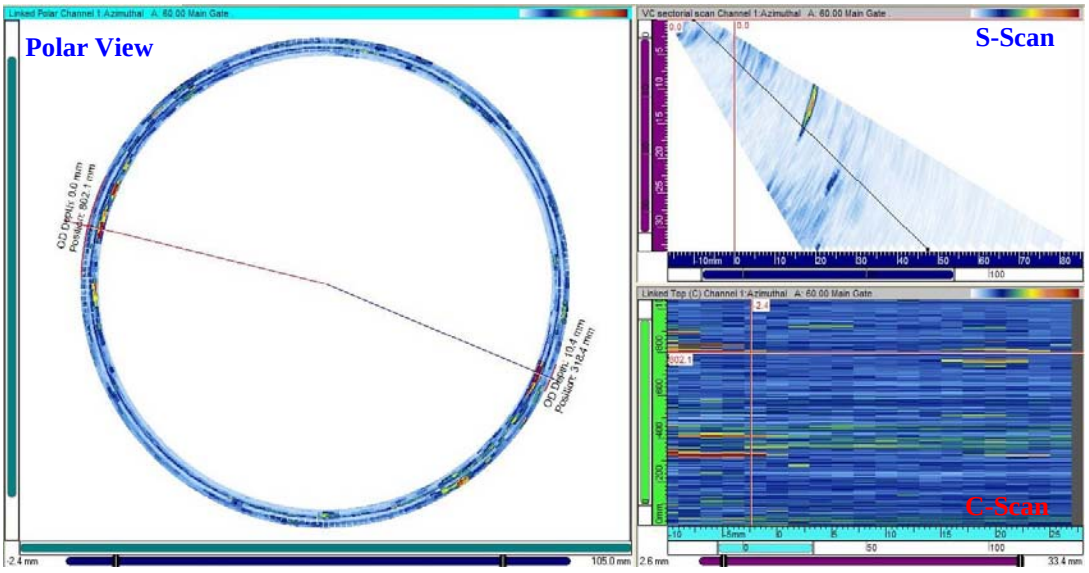
PA 4 MHz US Scan



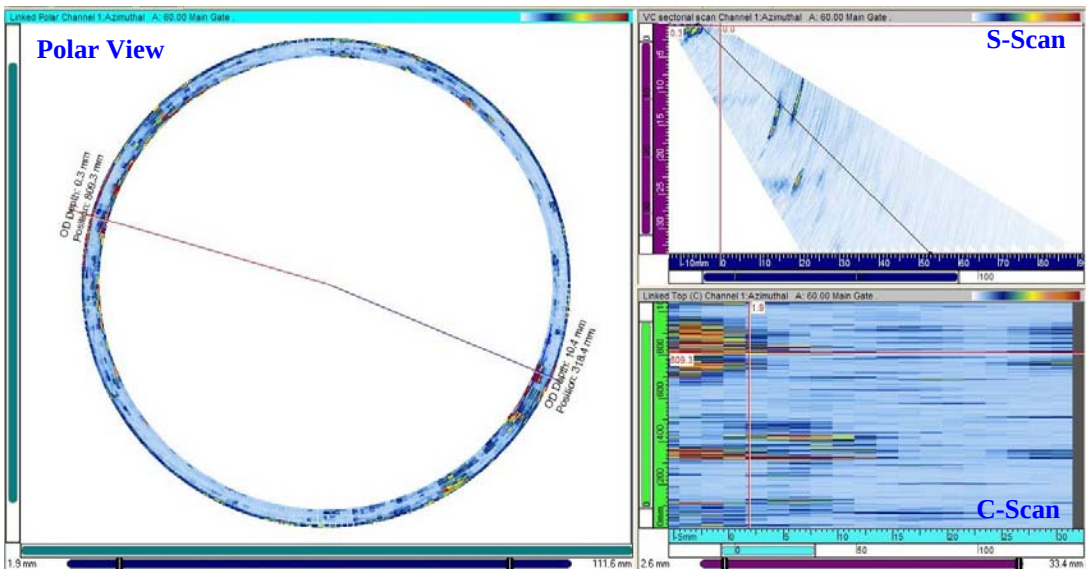
PA 7 MHz US Scan



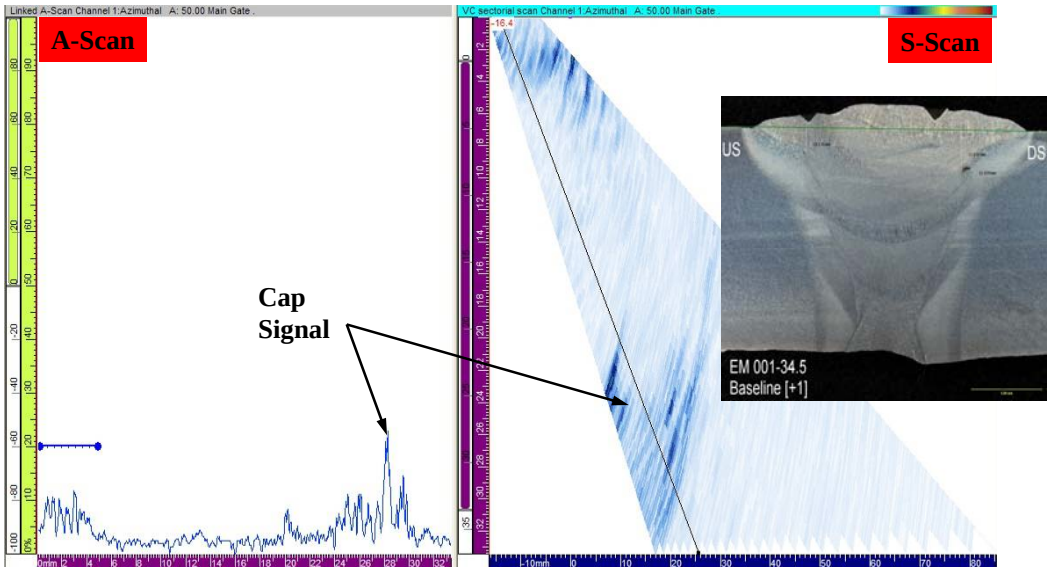
PA 4 MHz DS Scan



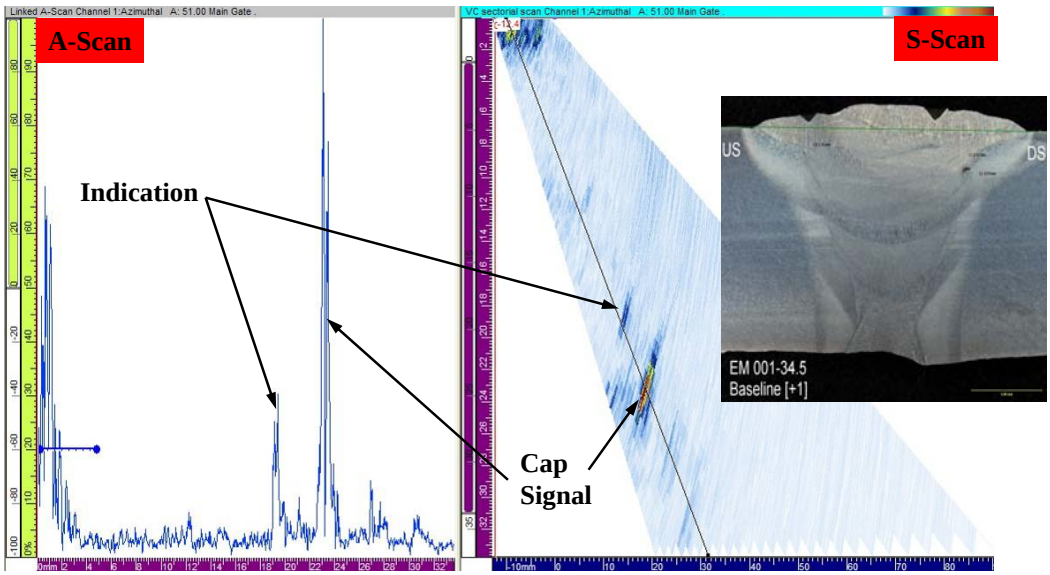
PA 7 MHz DS Scan



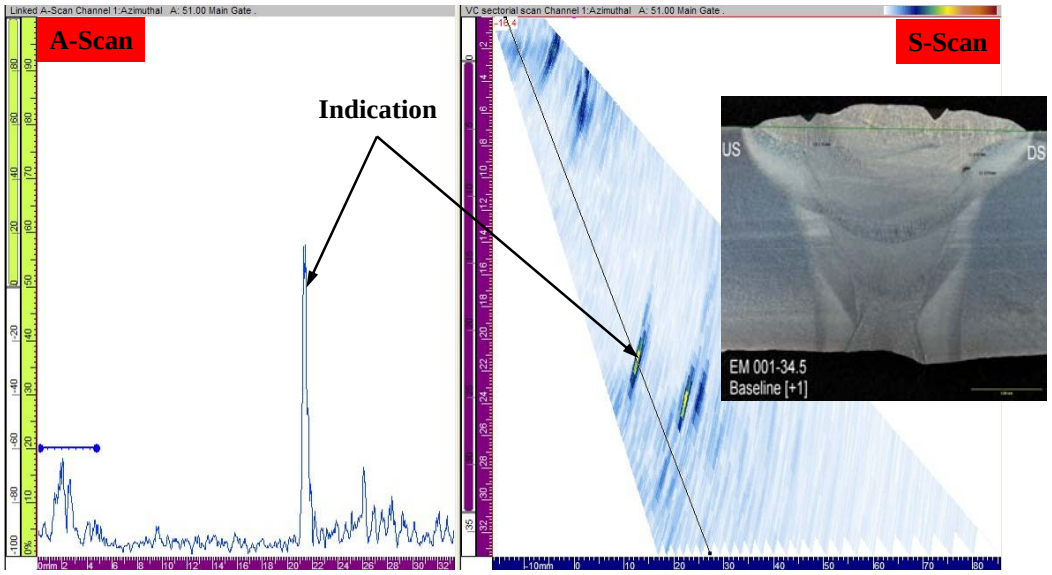
Location 34 US – PA4 64/21, FD 20



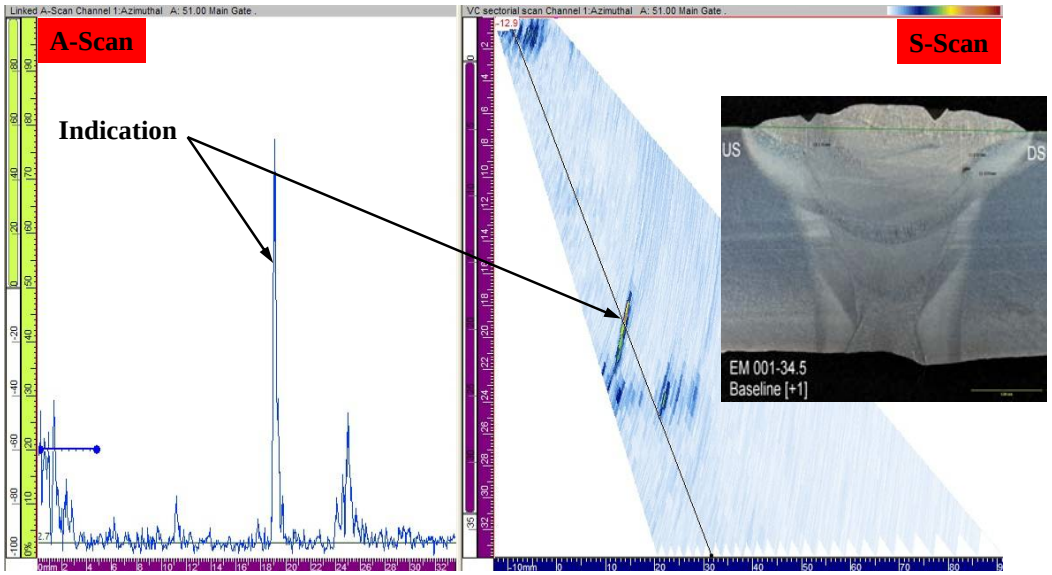
Location 34 US – PA7 60/16, FD 20



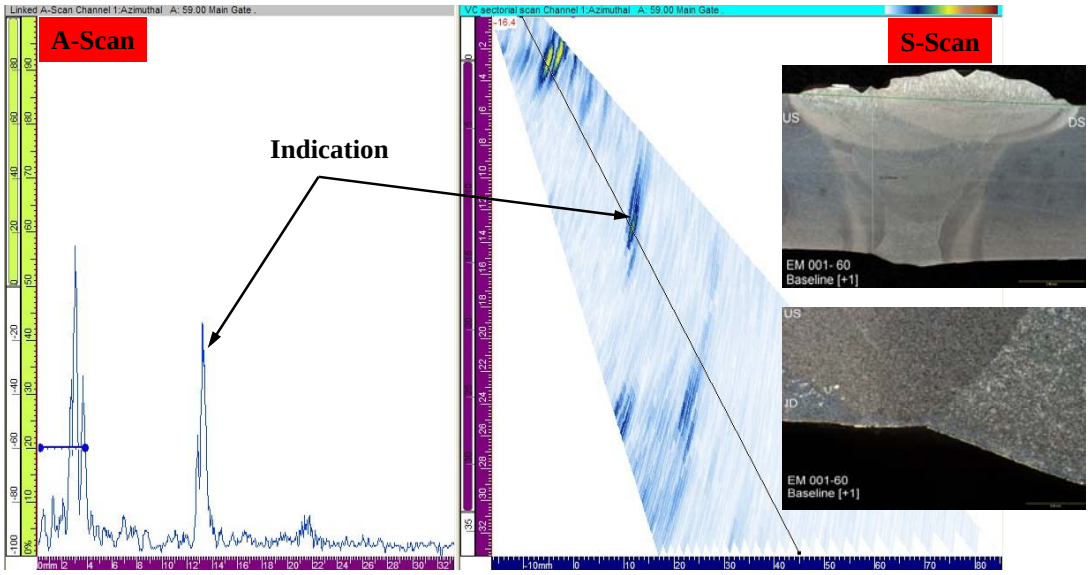
Location 34 DS – PA4 64/21, FD 20



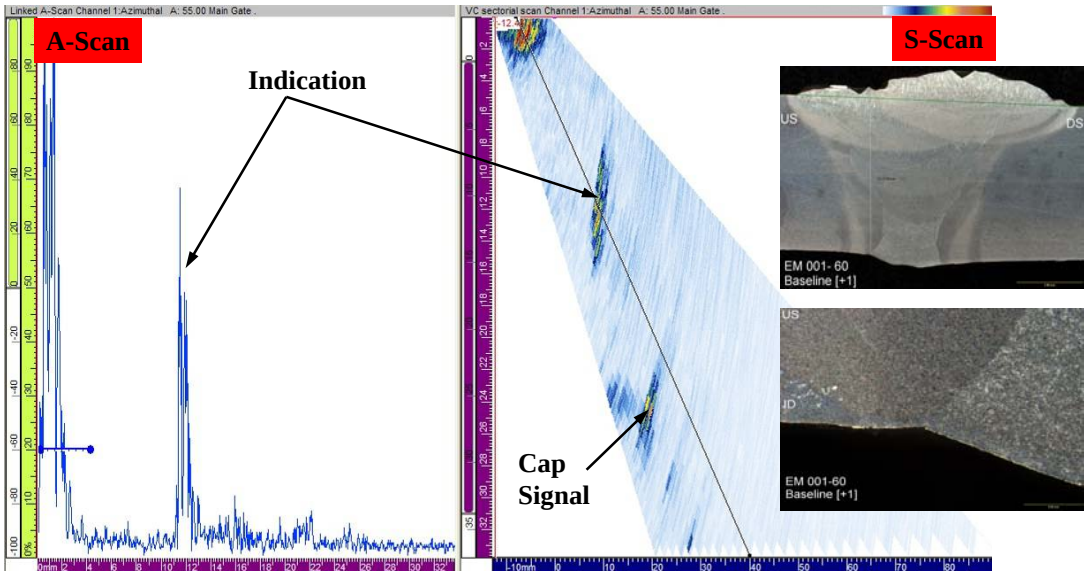
Location 34 DS – PA7 60/16, FD 20



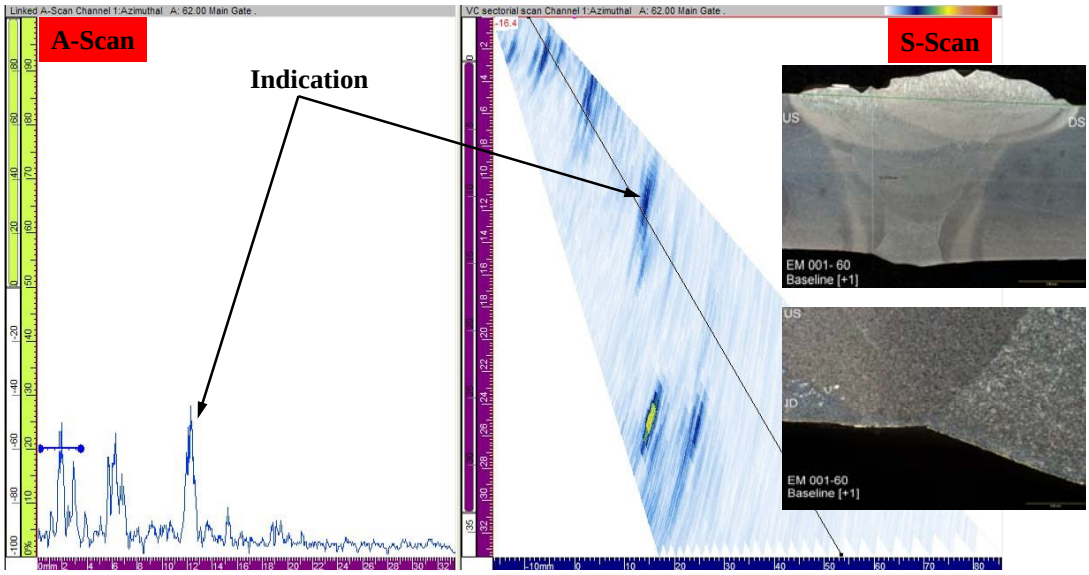
Location 60 US – PA4 64/21, FD 20



Location 60 US – PA7 60/16, FD 20



Location 60 DS – PA4 64/21, FD 20



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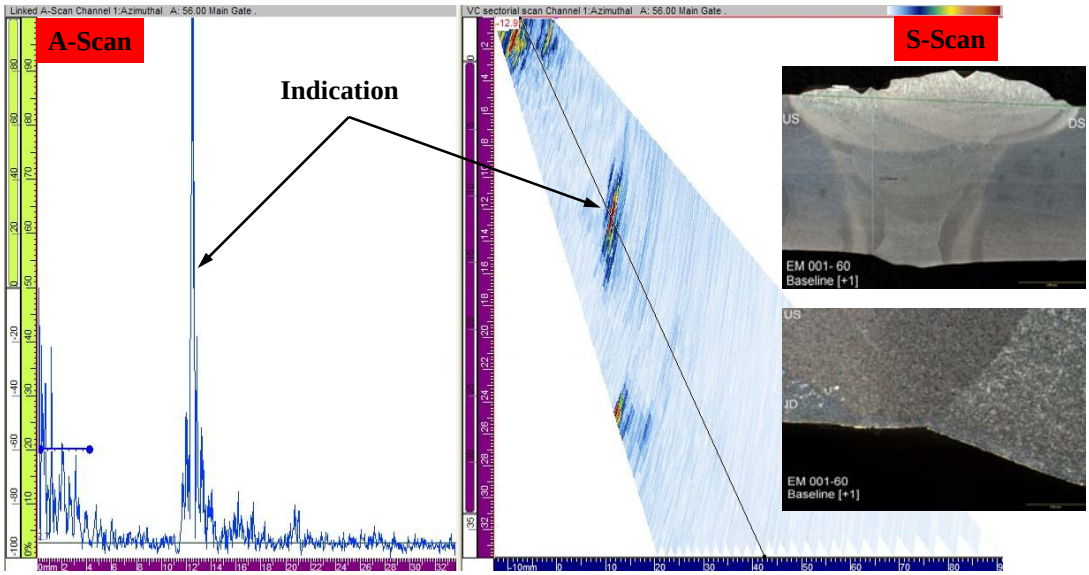
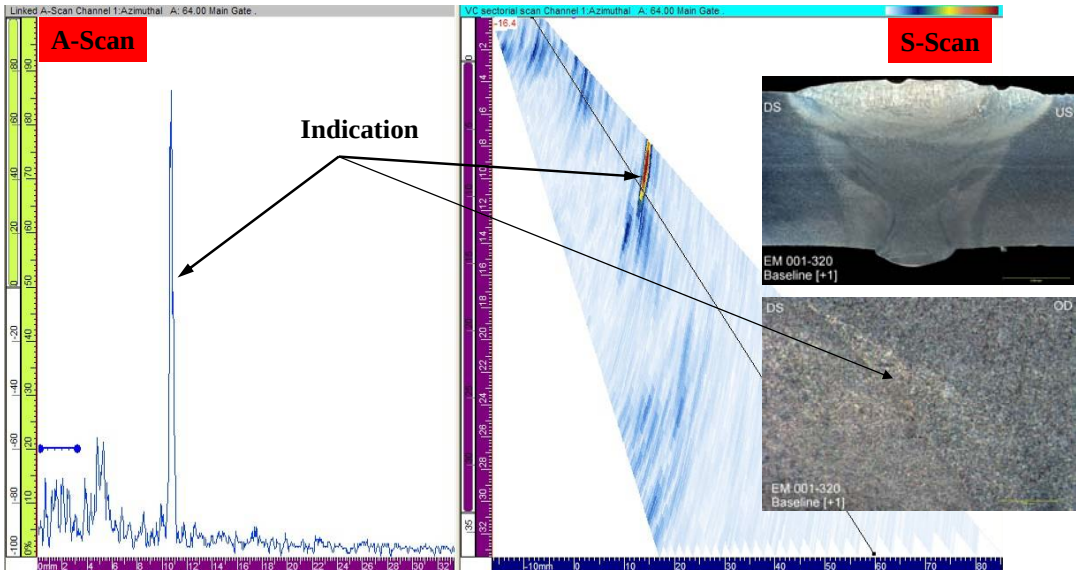
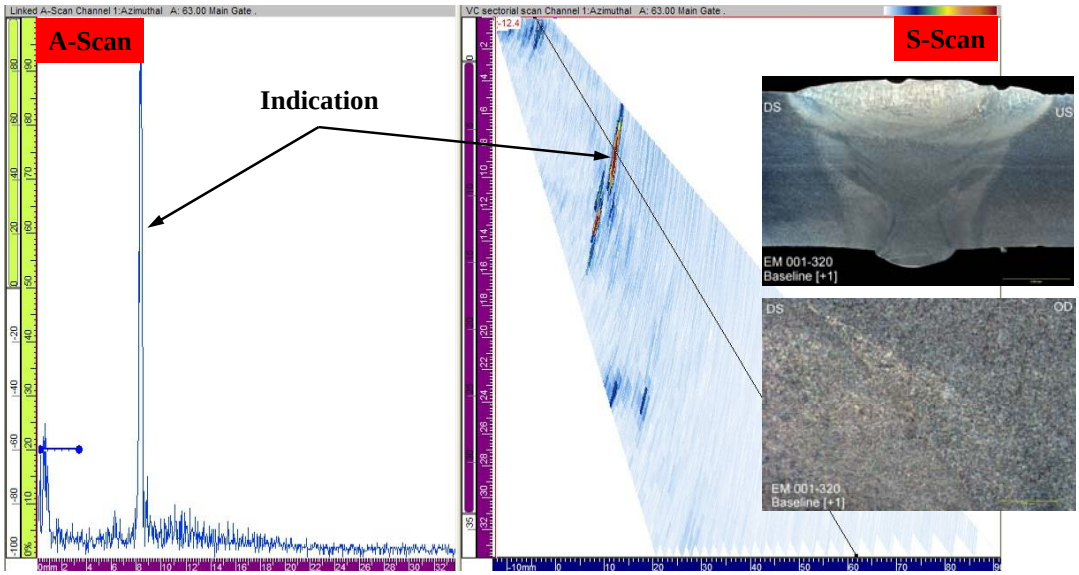


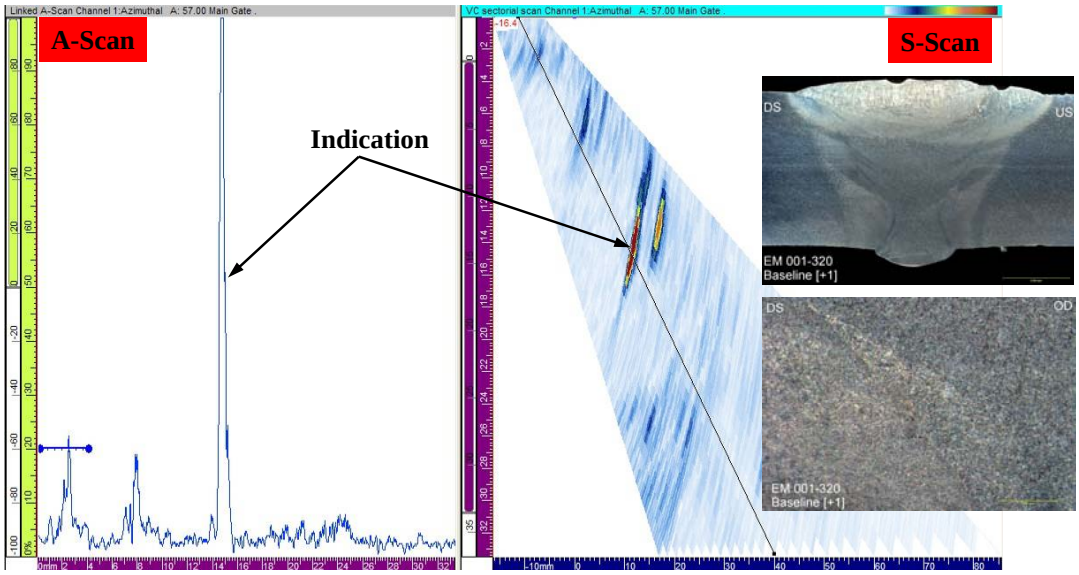
Location 320 US – PA4 64/21, FD 20



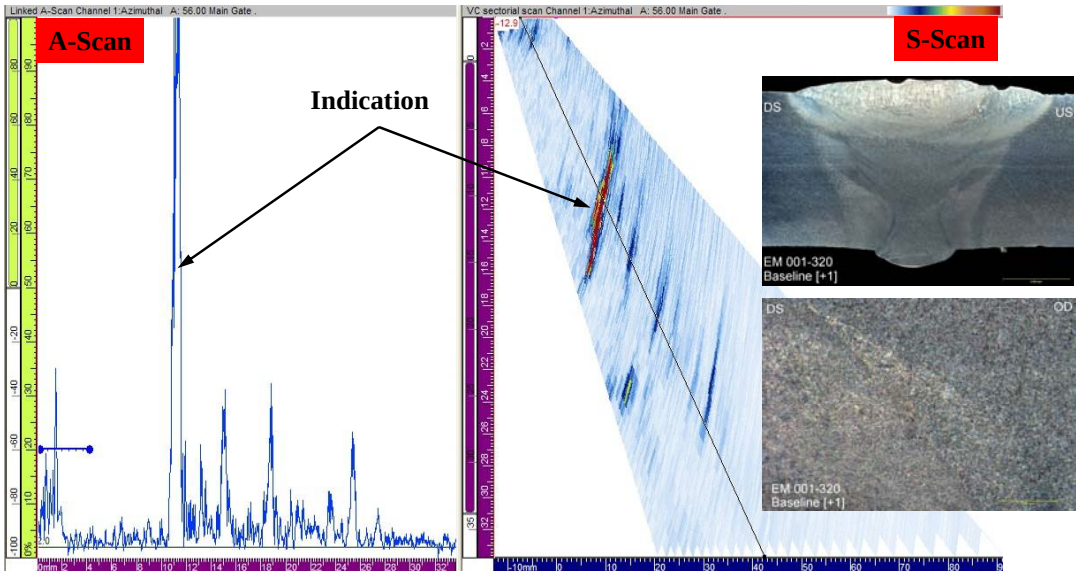
Location 320 US – PA7 60/16, FD 20



Location 320 DS – PA4 64/21, FD 20



Location 320 DS – PA7 60/16, FD 20



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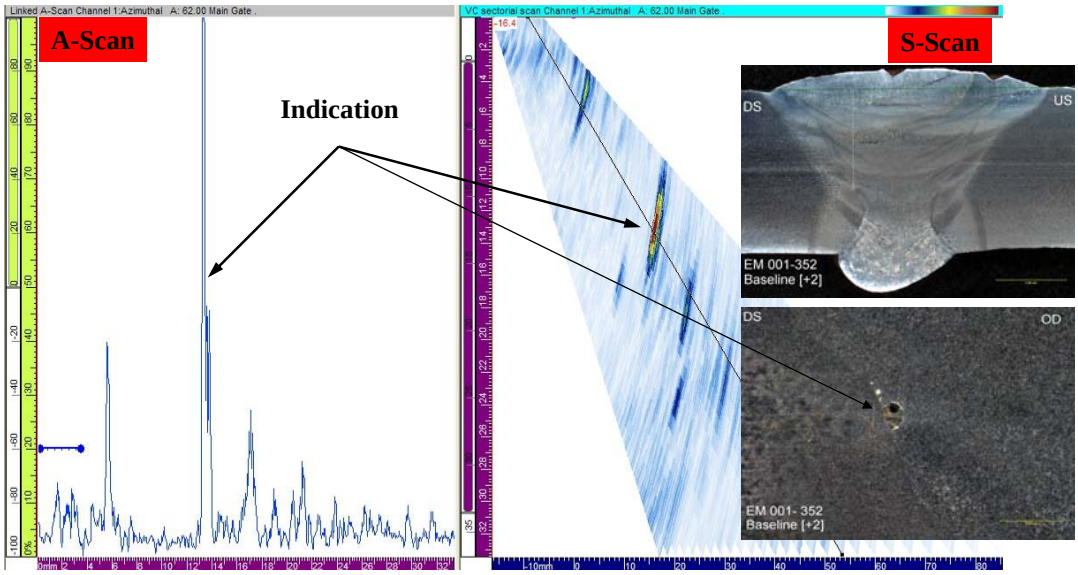

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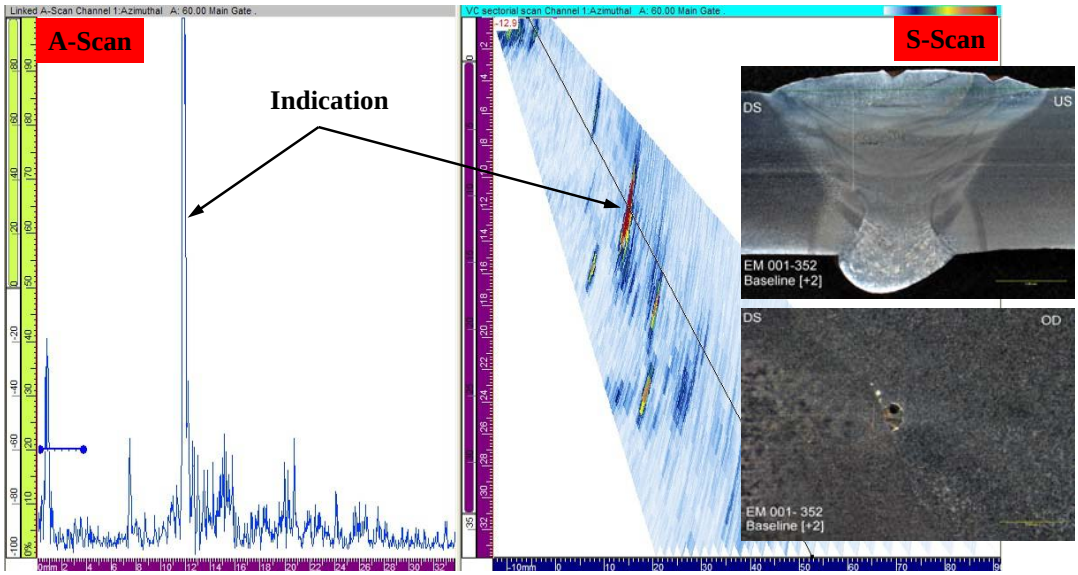

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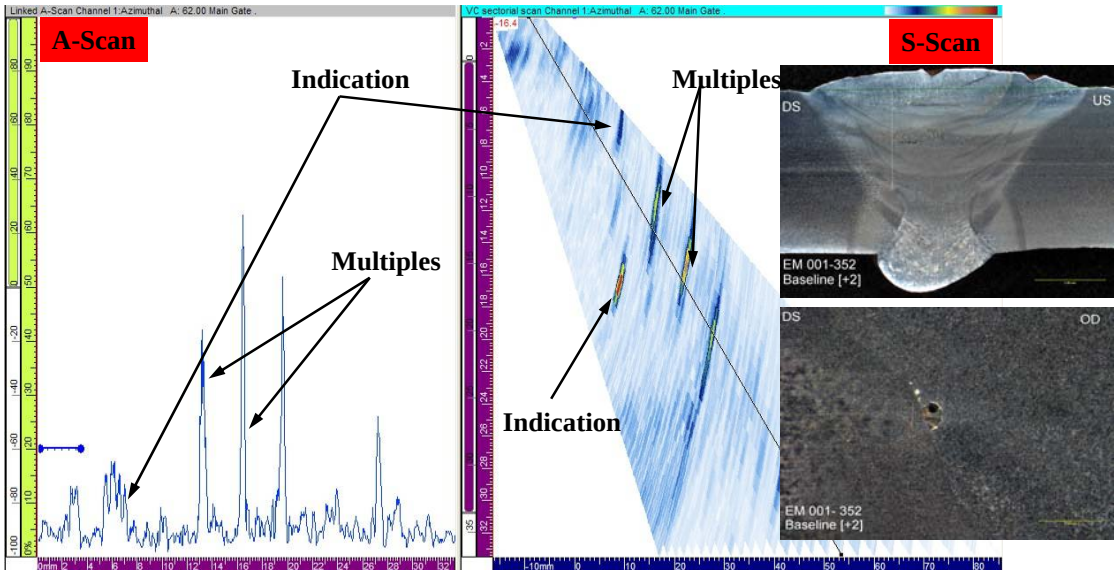
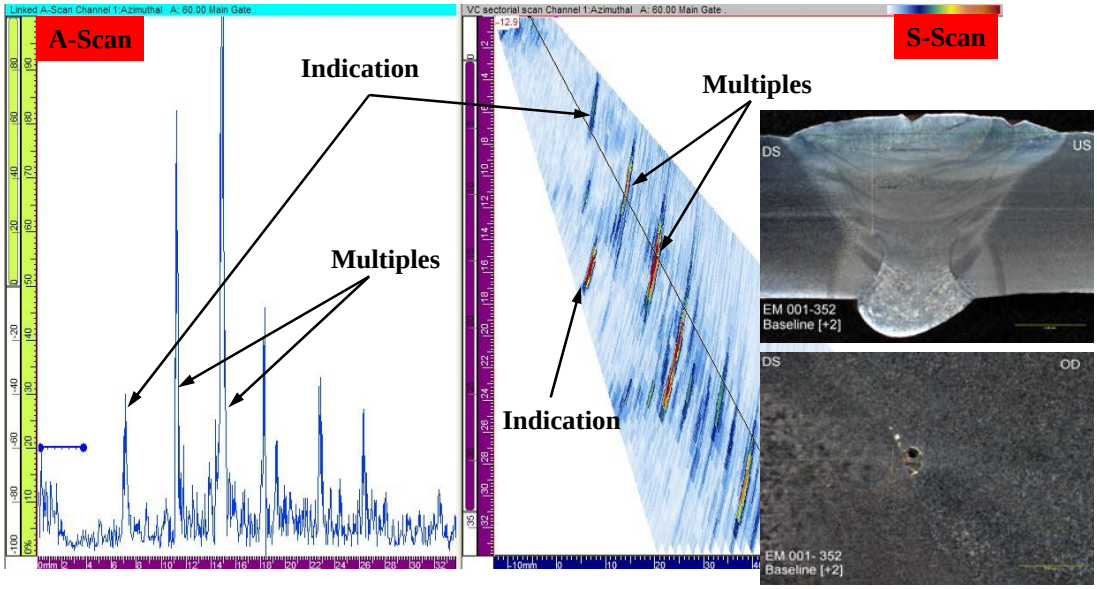


Location 352 DS – PA7 60/16, FD 20



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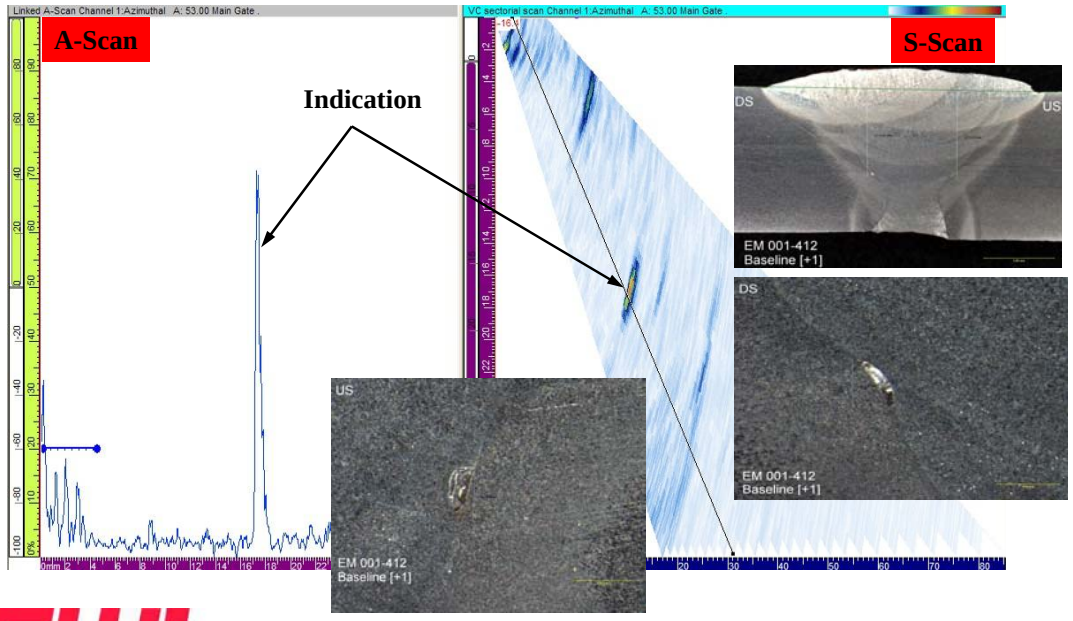

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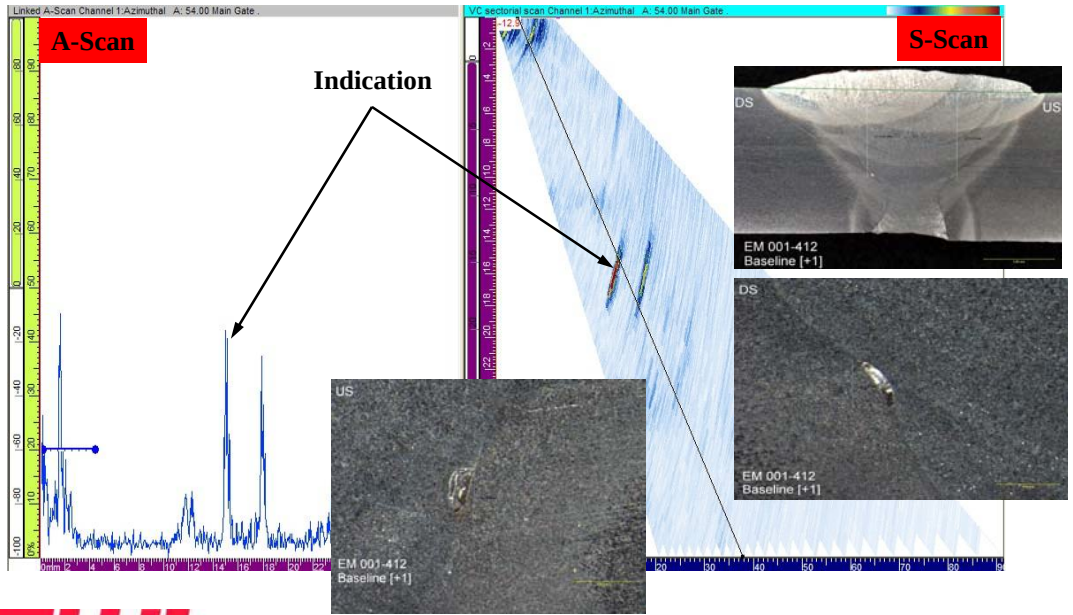

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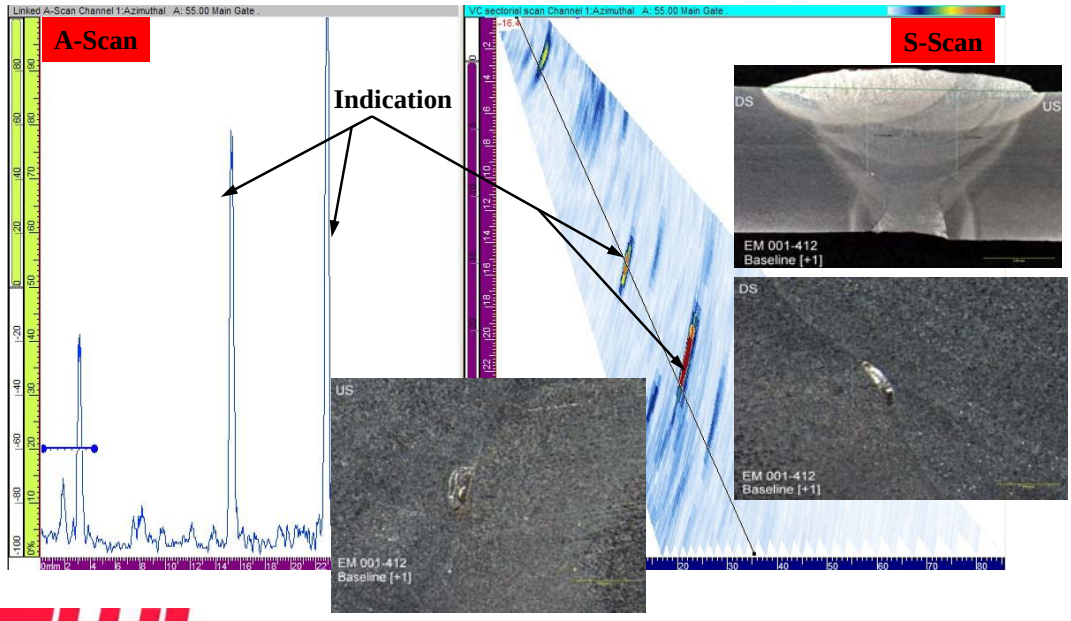

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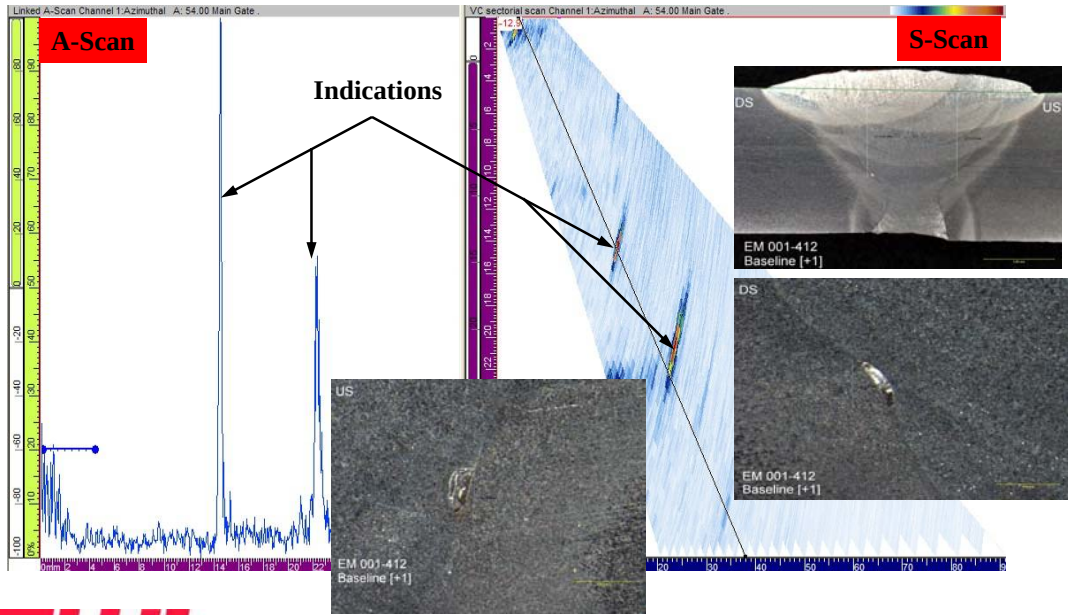

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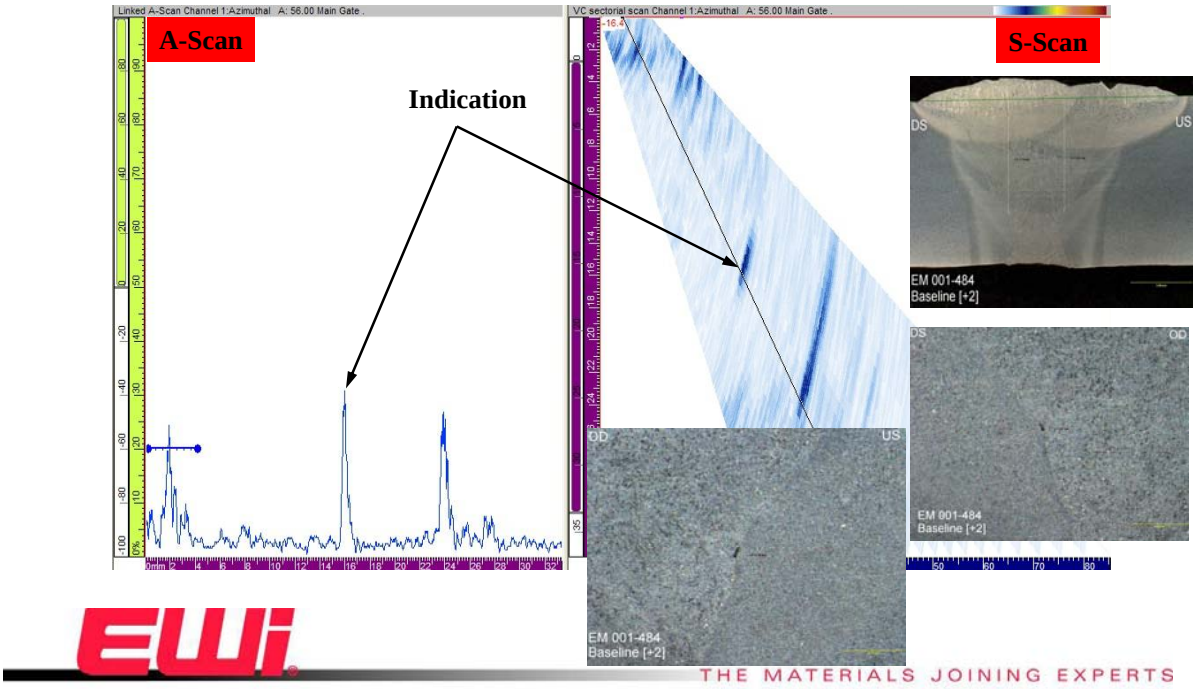

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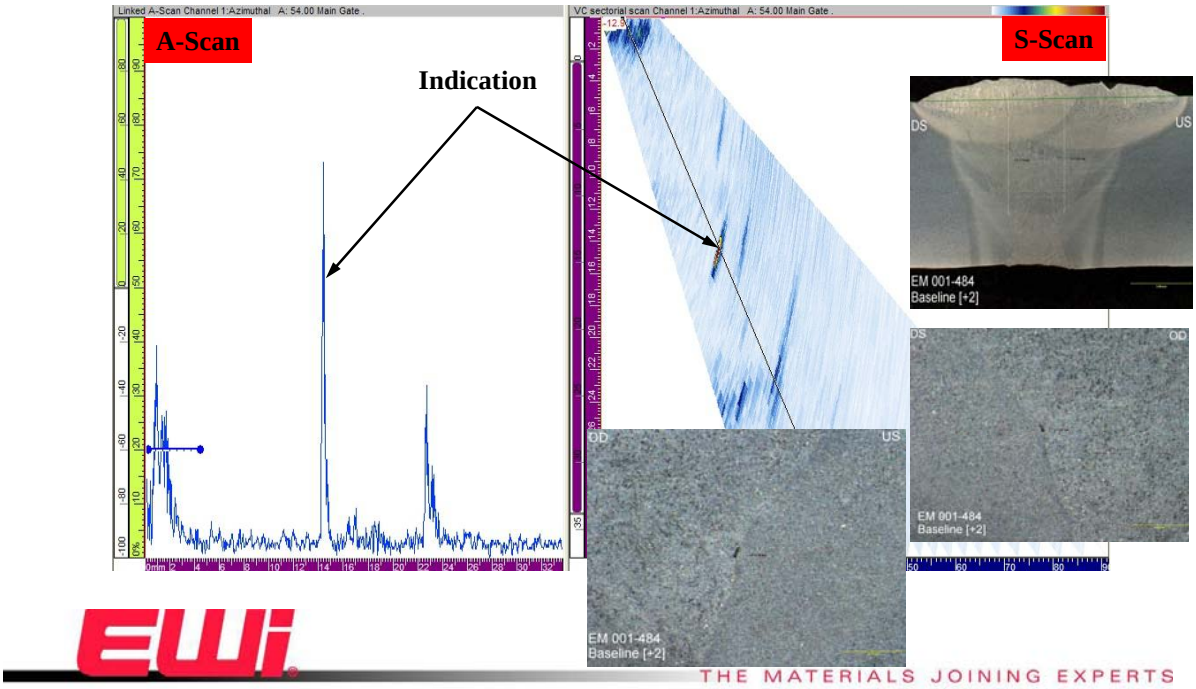
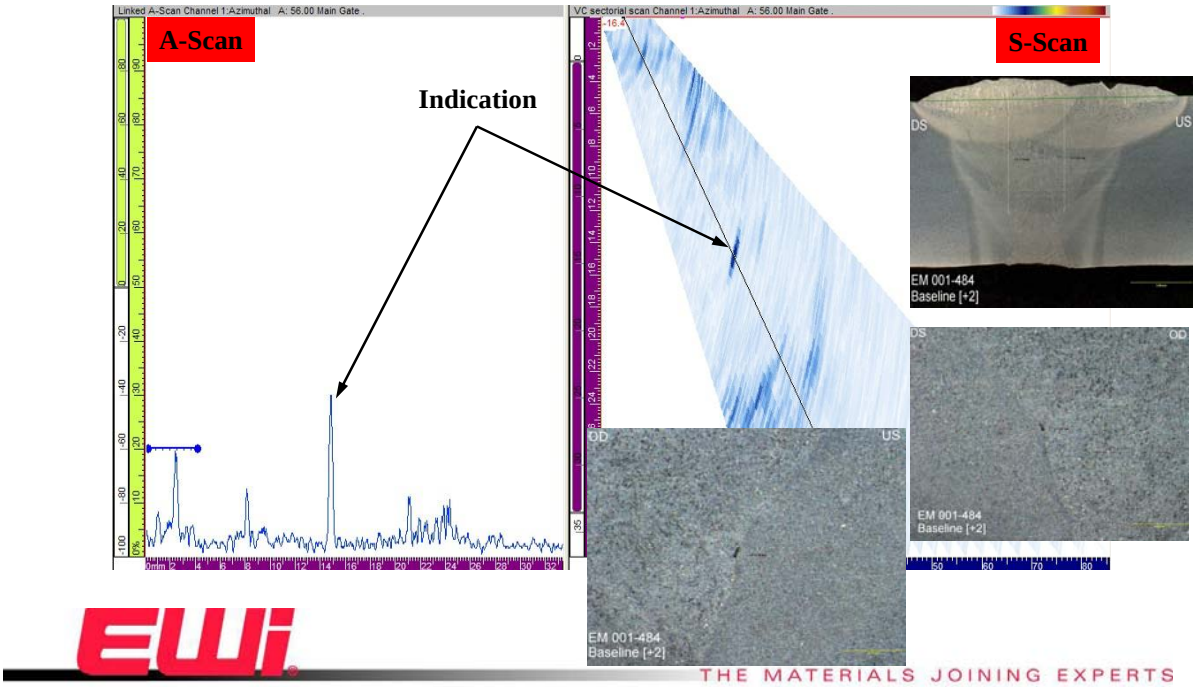
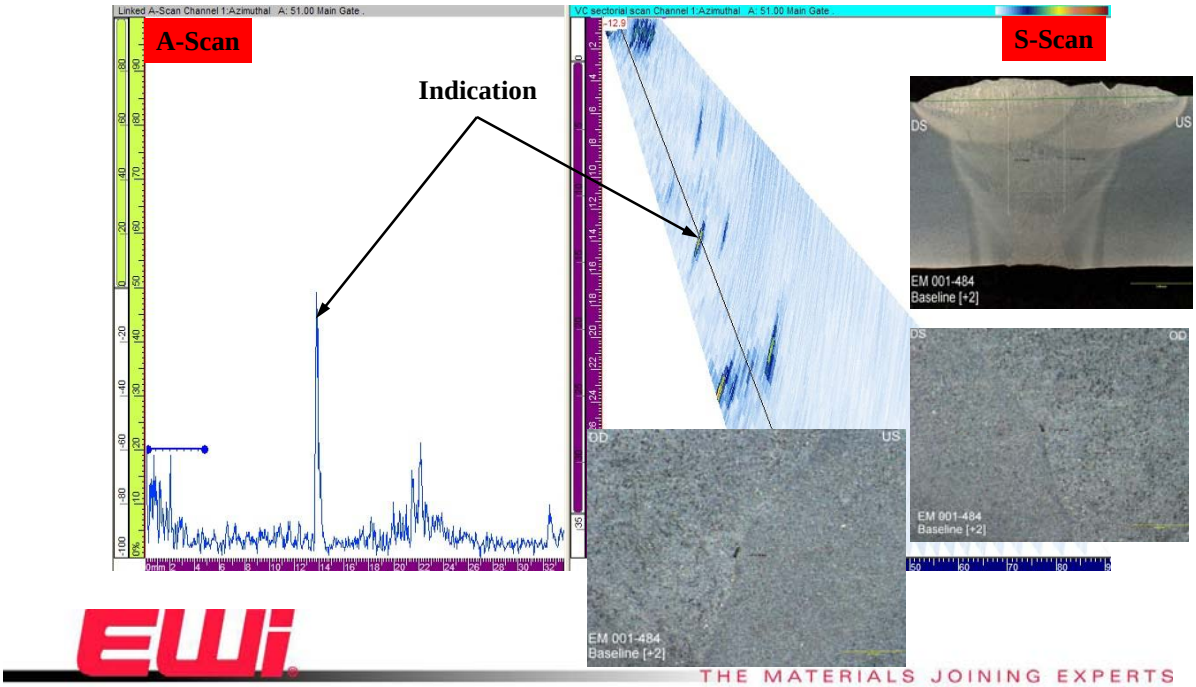


Location 484 DS – PA4 64/21, FD 20



Location 484 DS – PA7 60/16, FD 20



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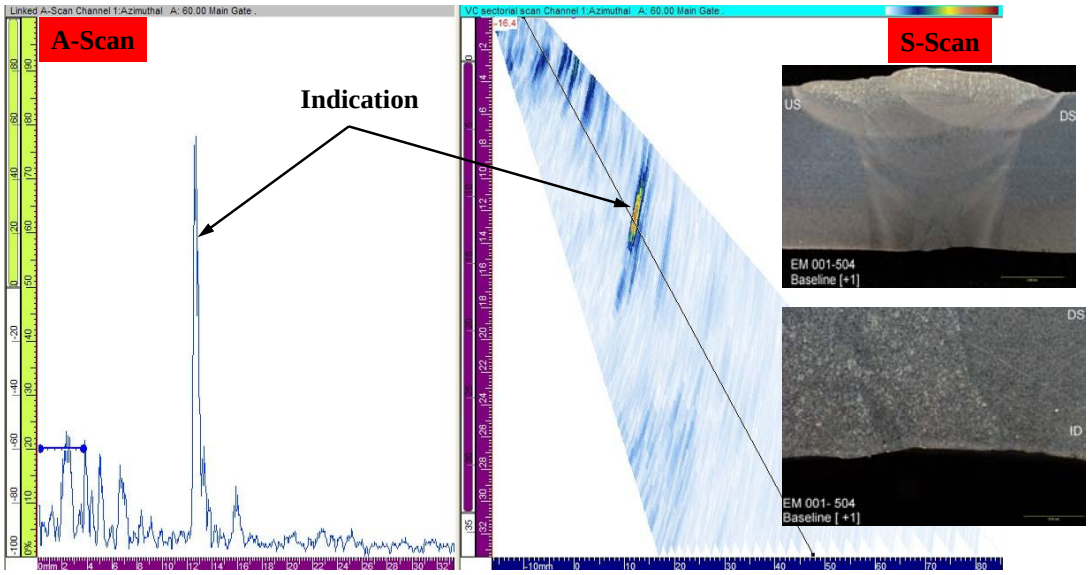

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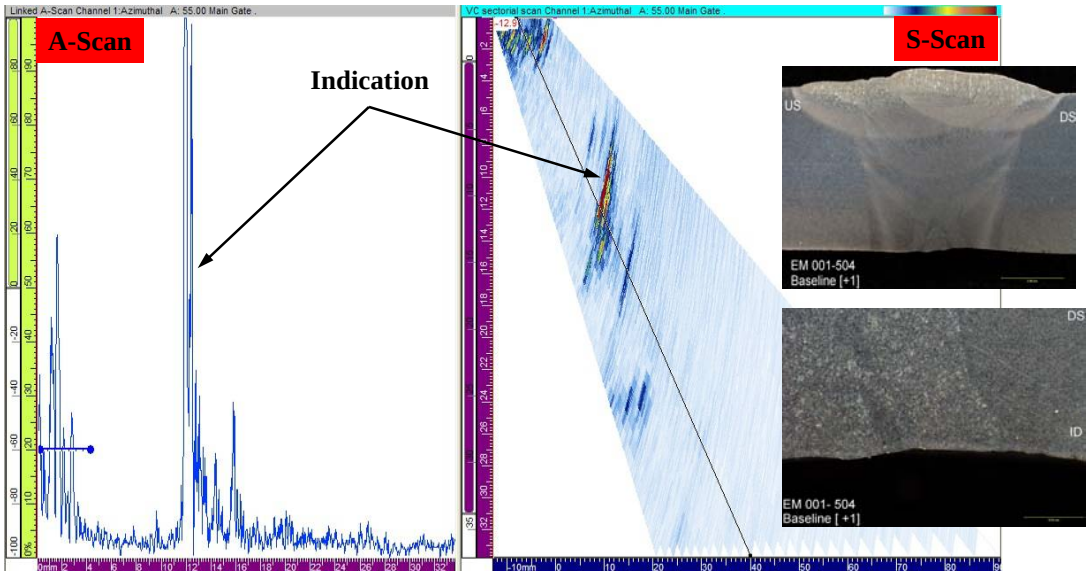

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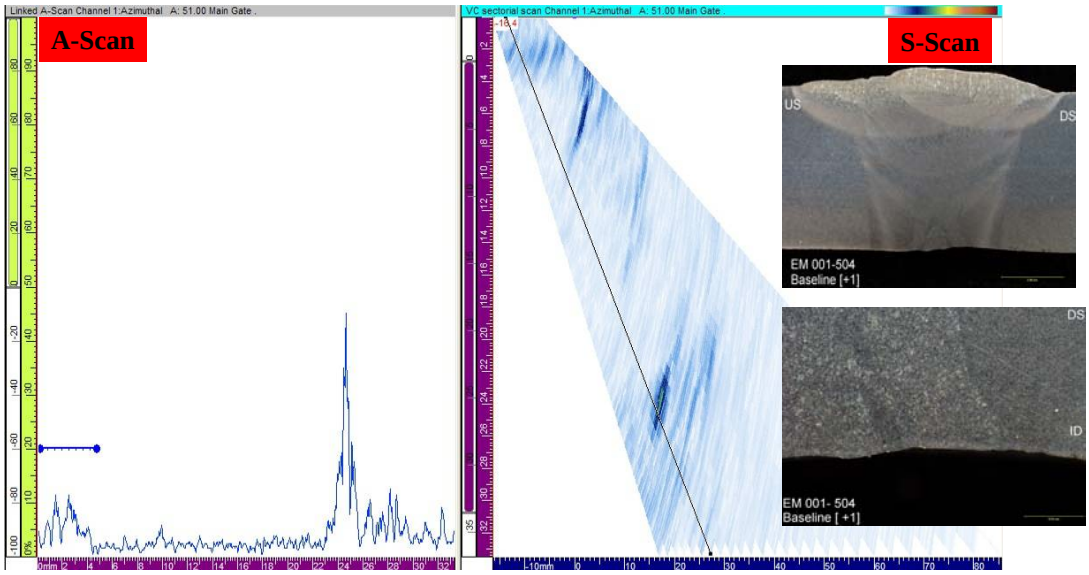

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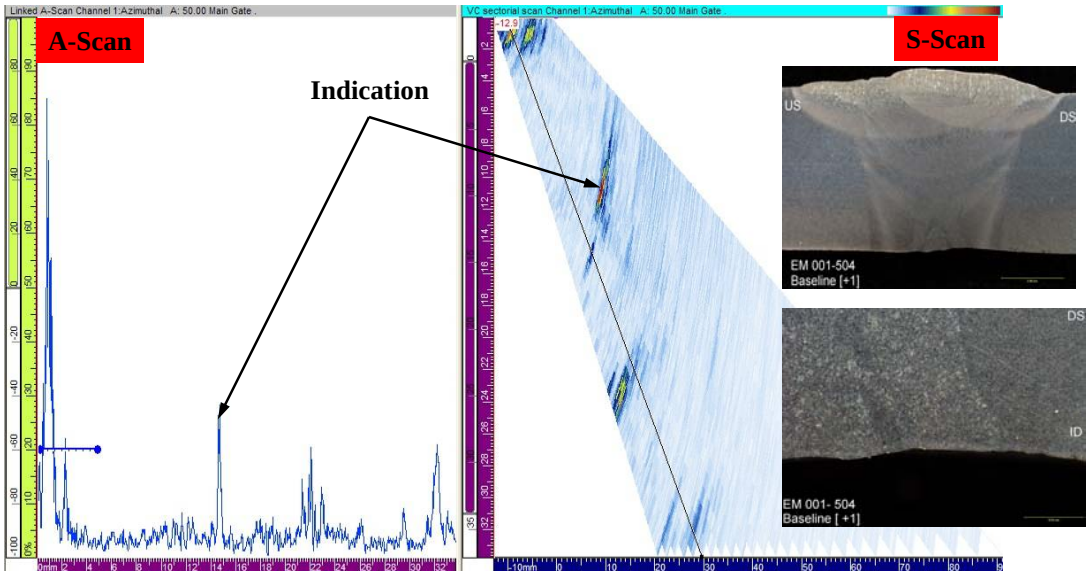

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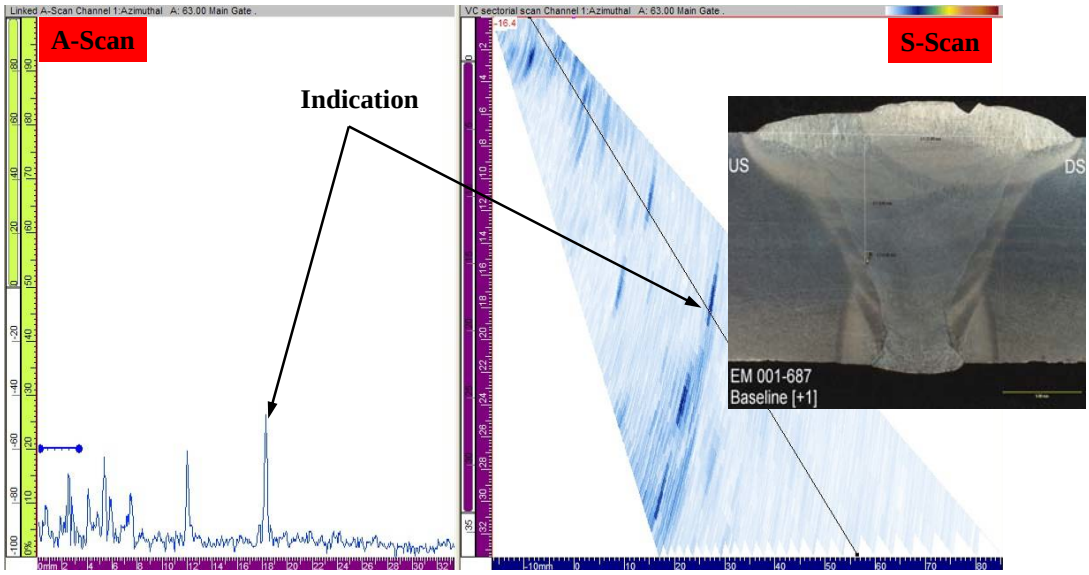
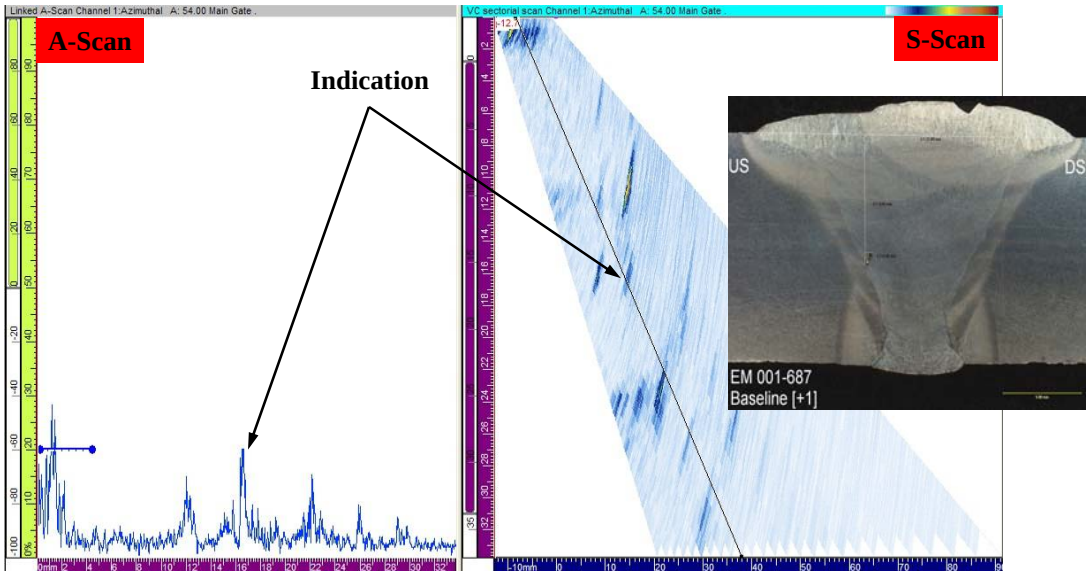


Location 687 US – PA7 60/16, FD 20



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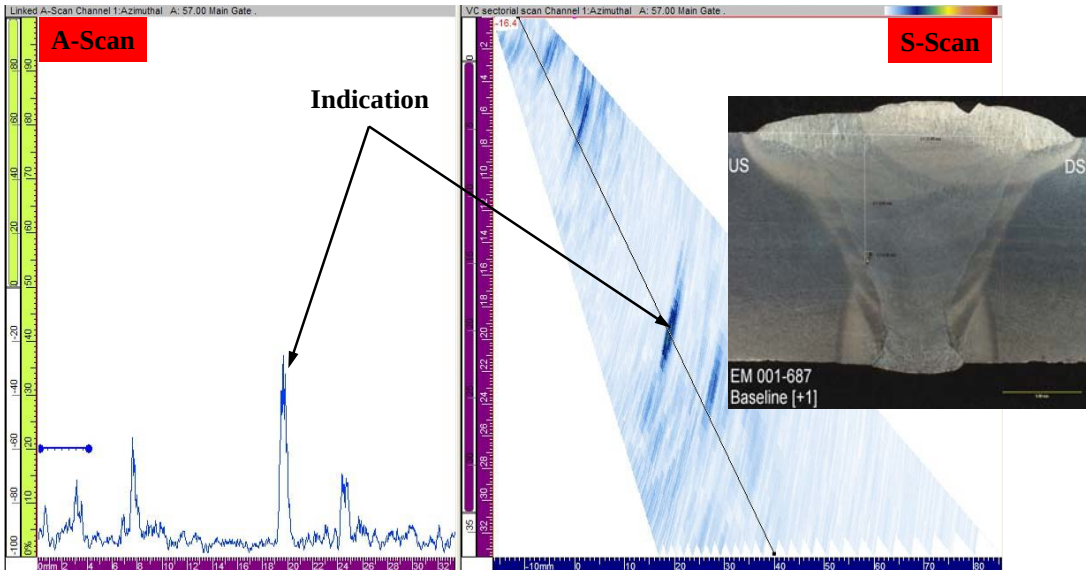
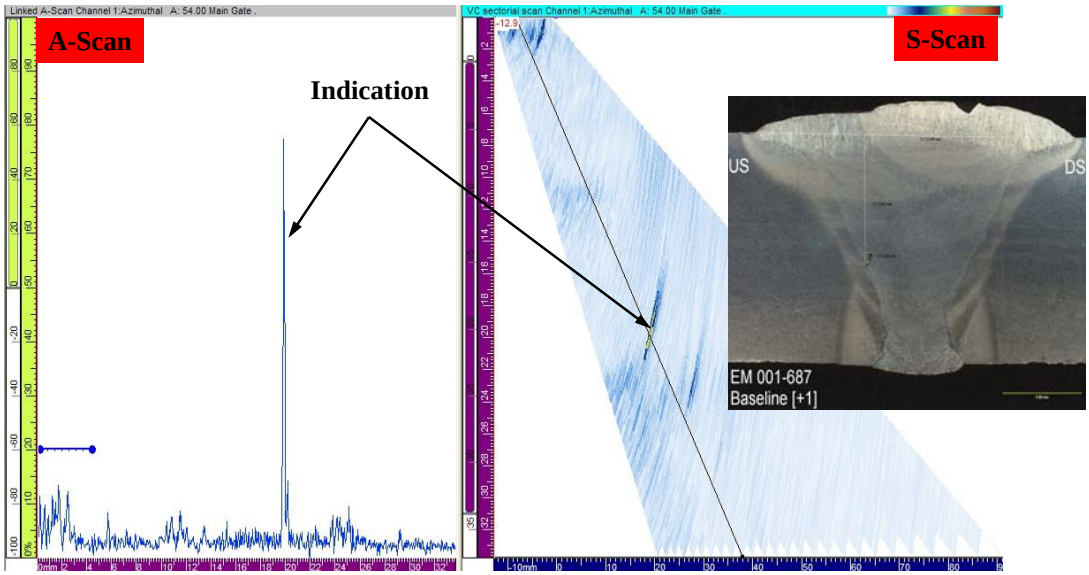


Location 687 DS – PA7 60/16, FD 20



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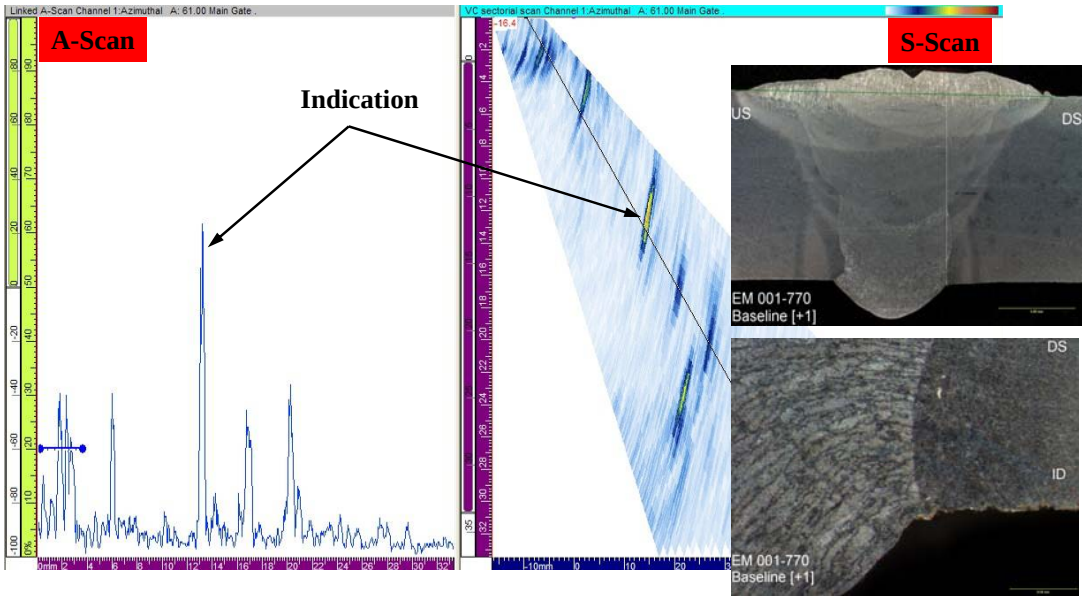
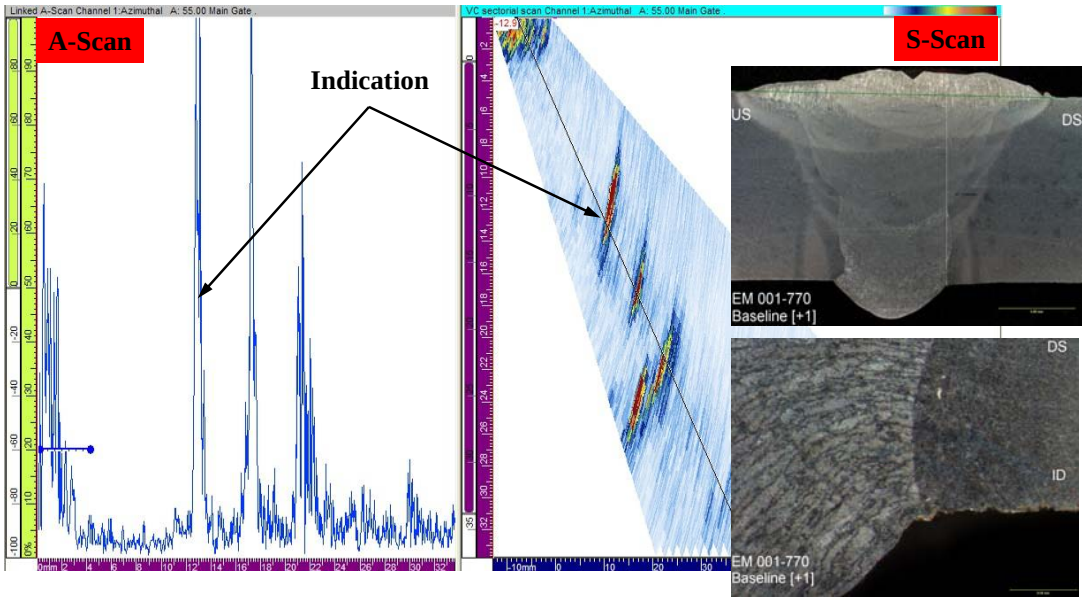
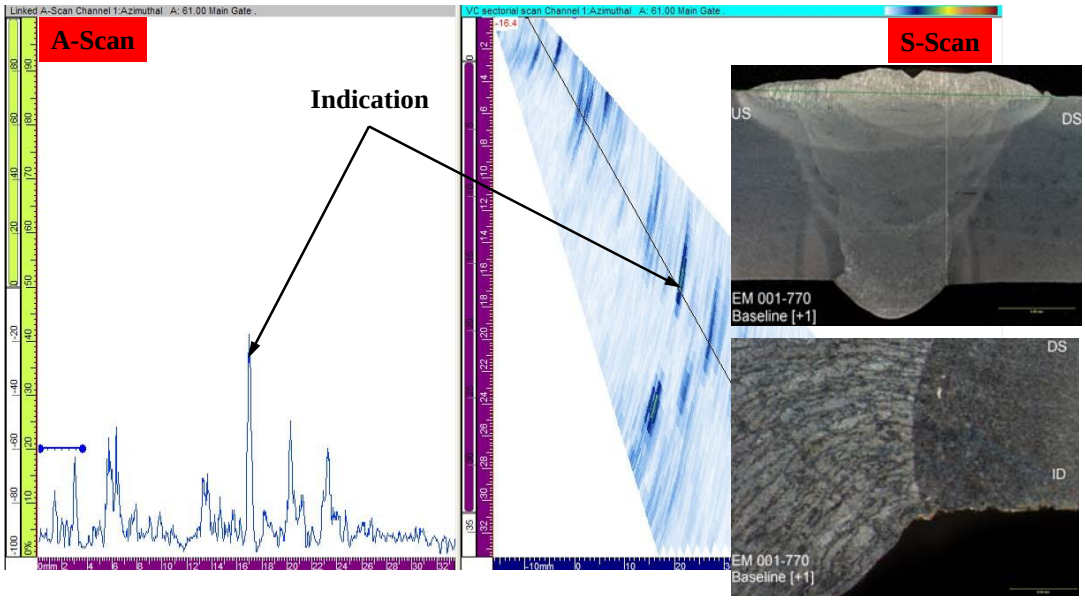


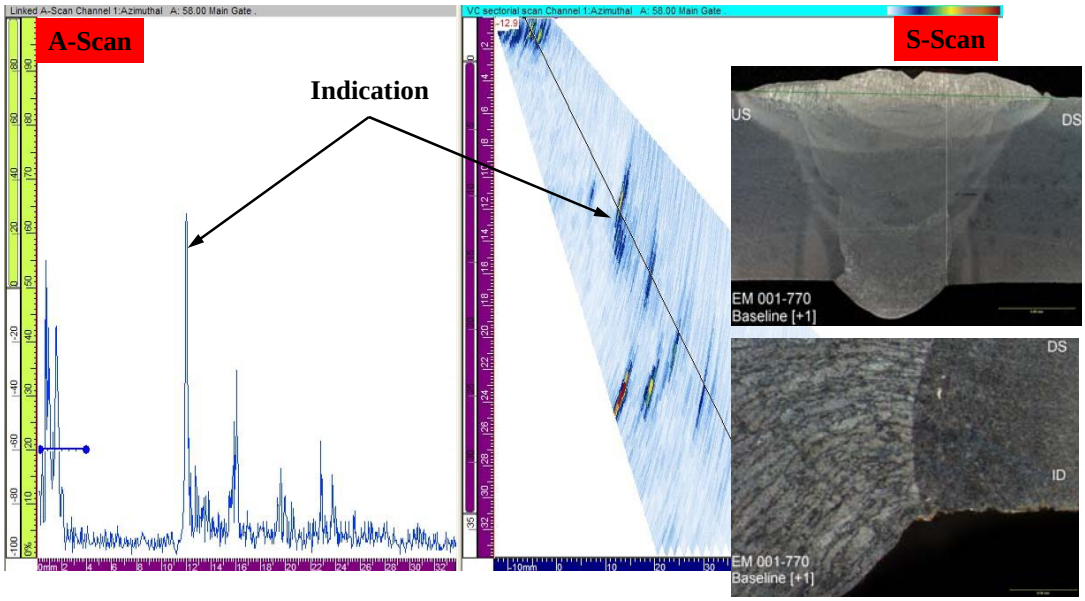
Location 770 US – PA7 60/16, FD 20



Location 770 DS – PA4 64/21, FD 20



Location 770 DS – PA7 60/16, FD 20



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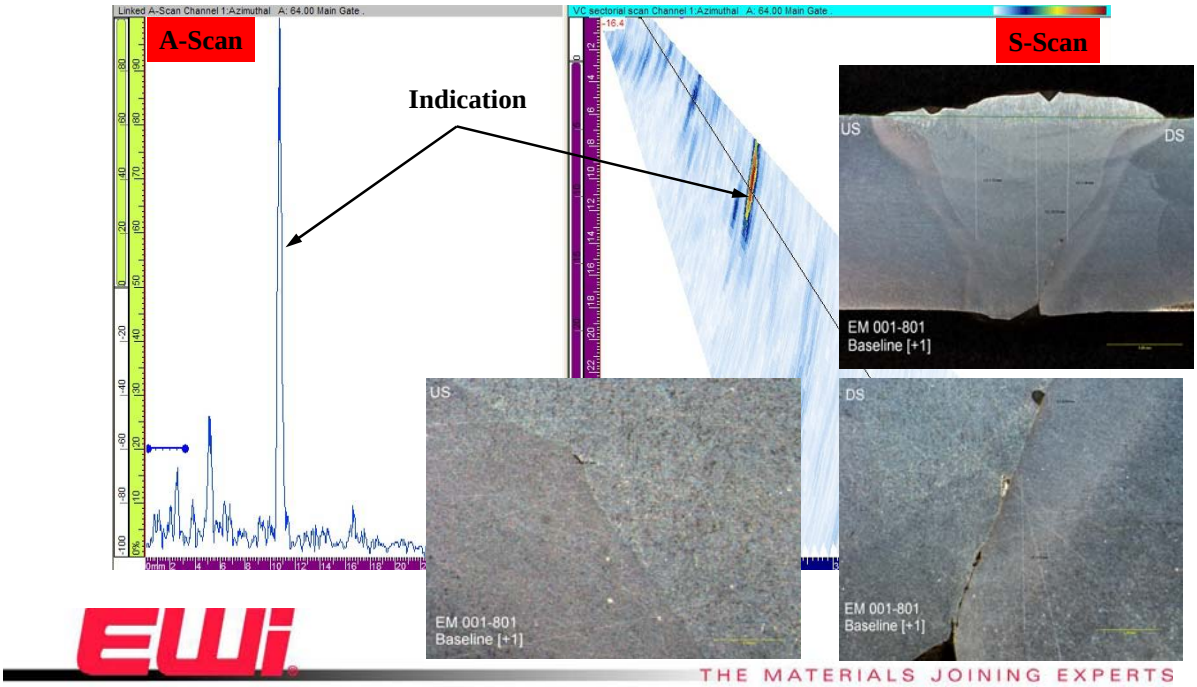

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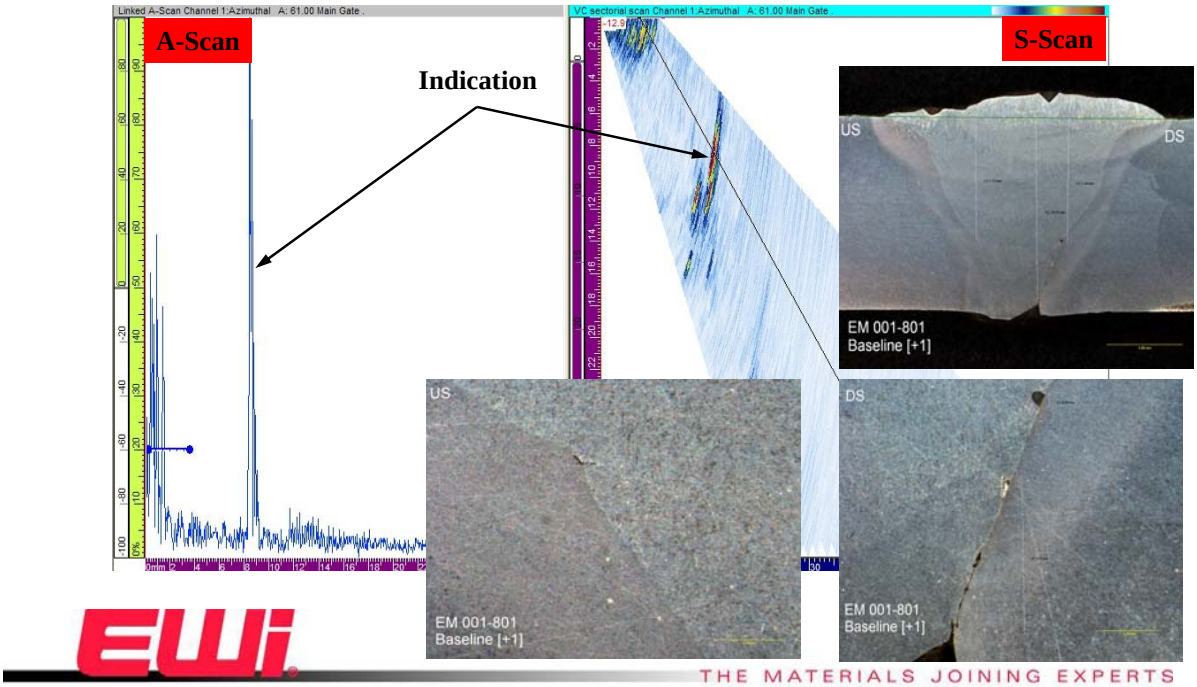

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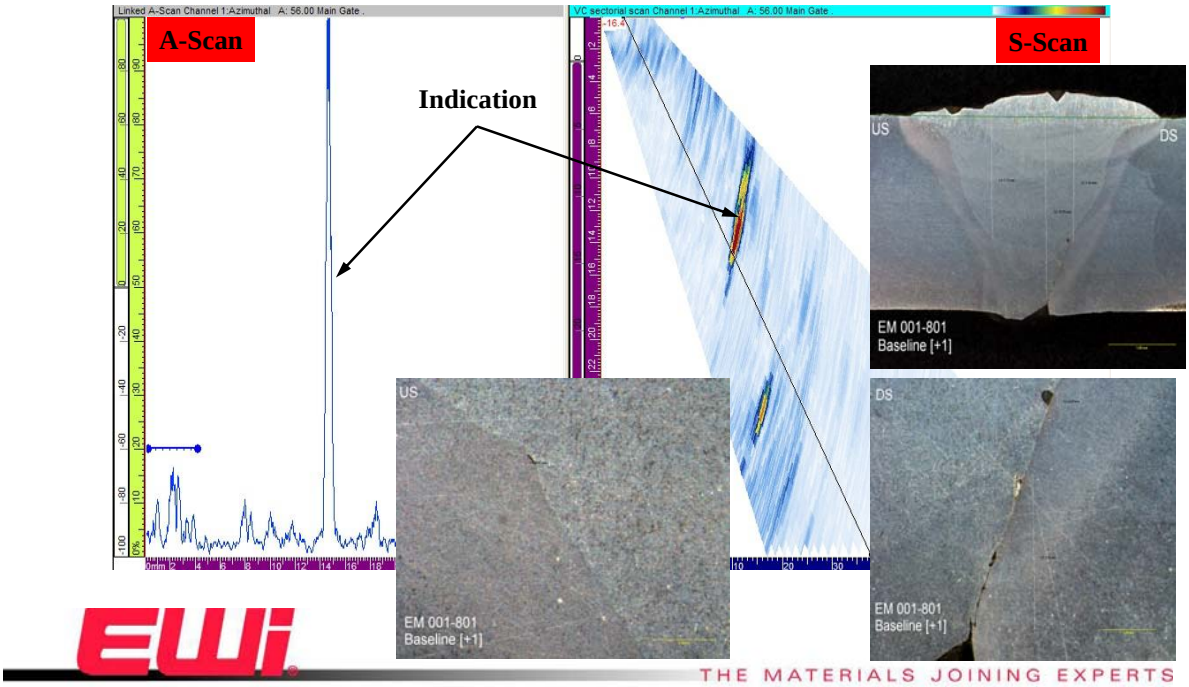

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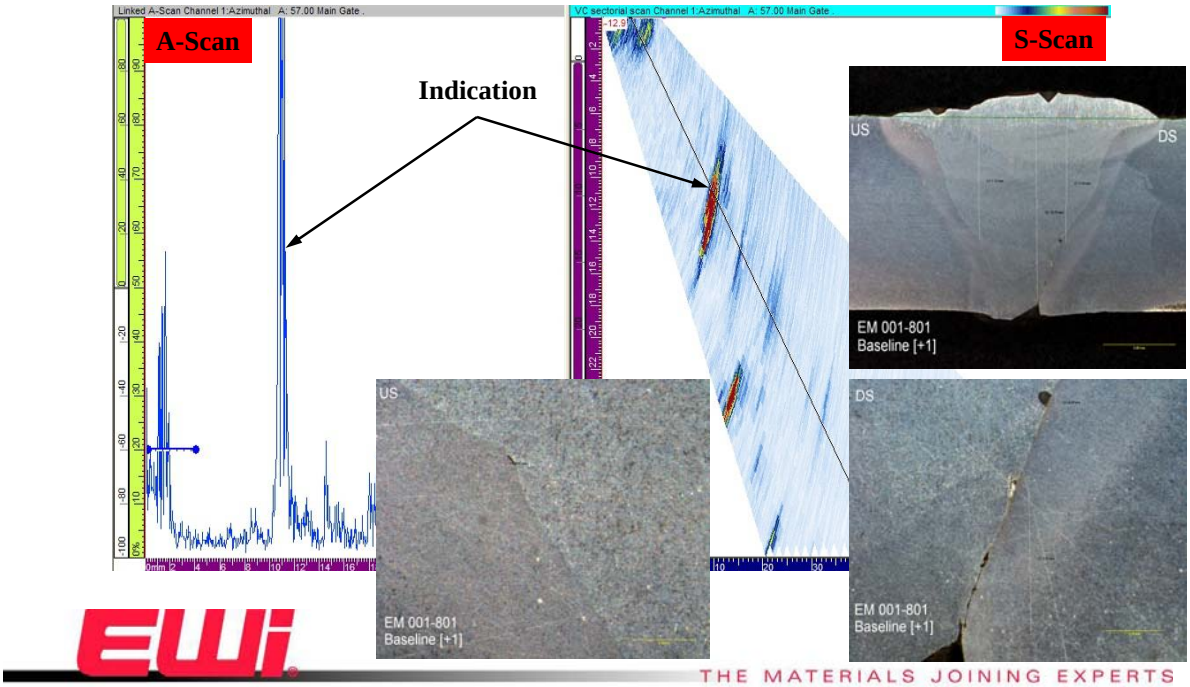
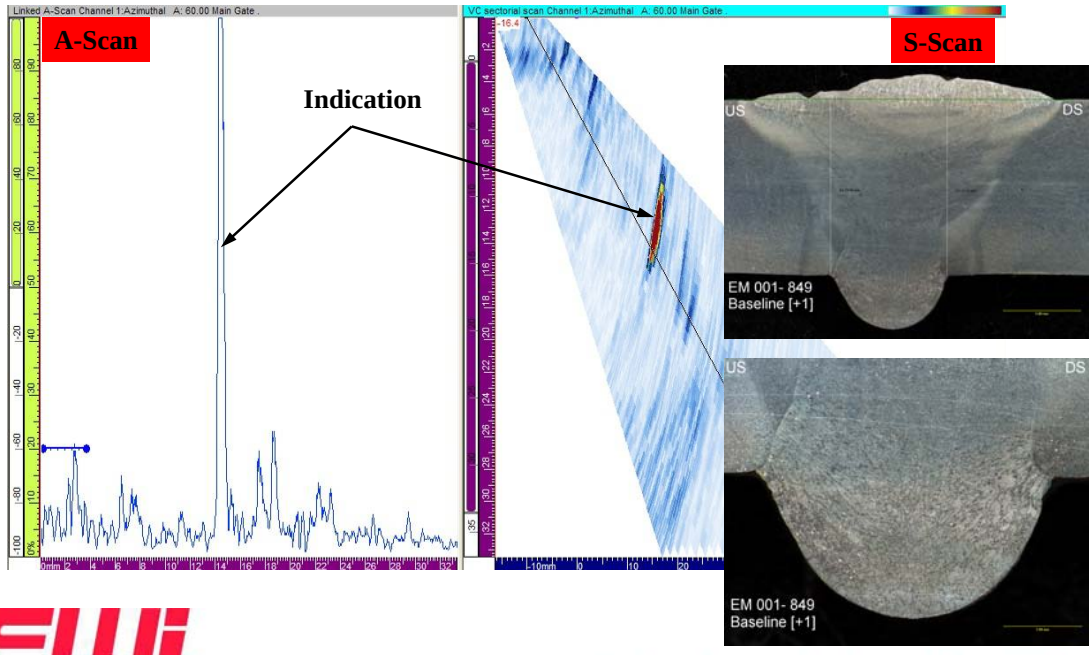


Location 849 US – PA4 64/21, FD 20



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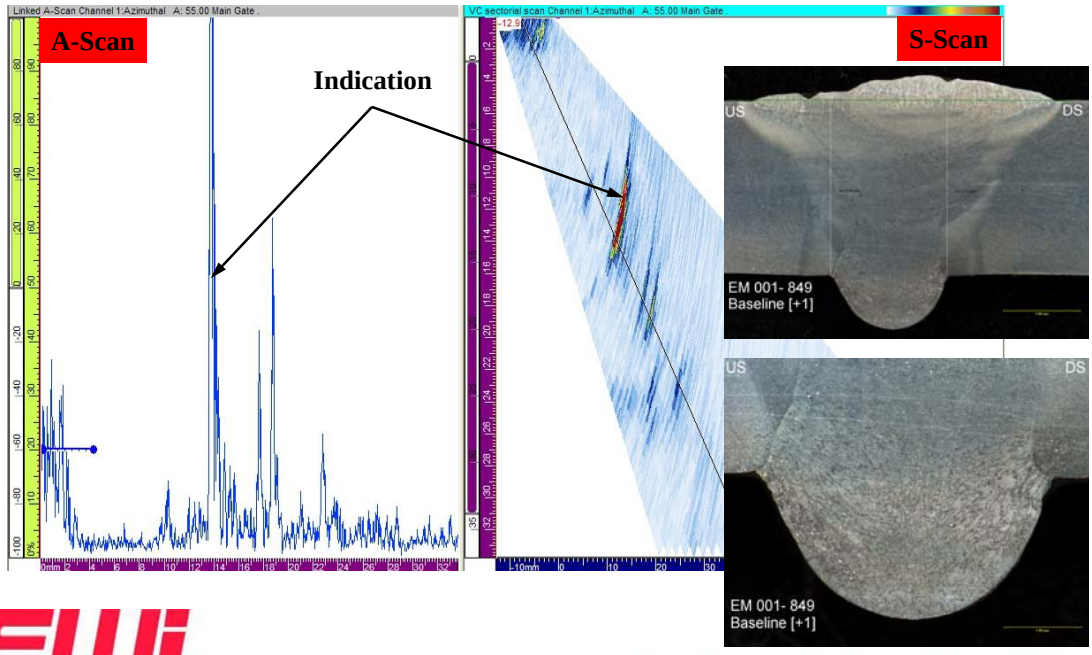
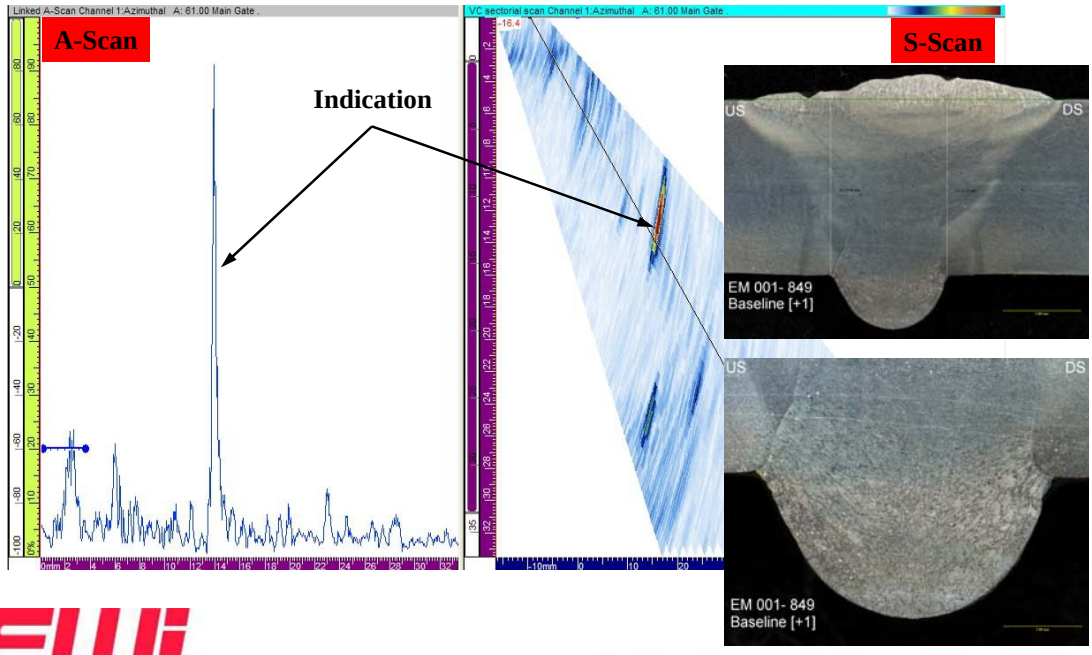


Location 849 DS – PA4 64/21, FD 20



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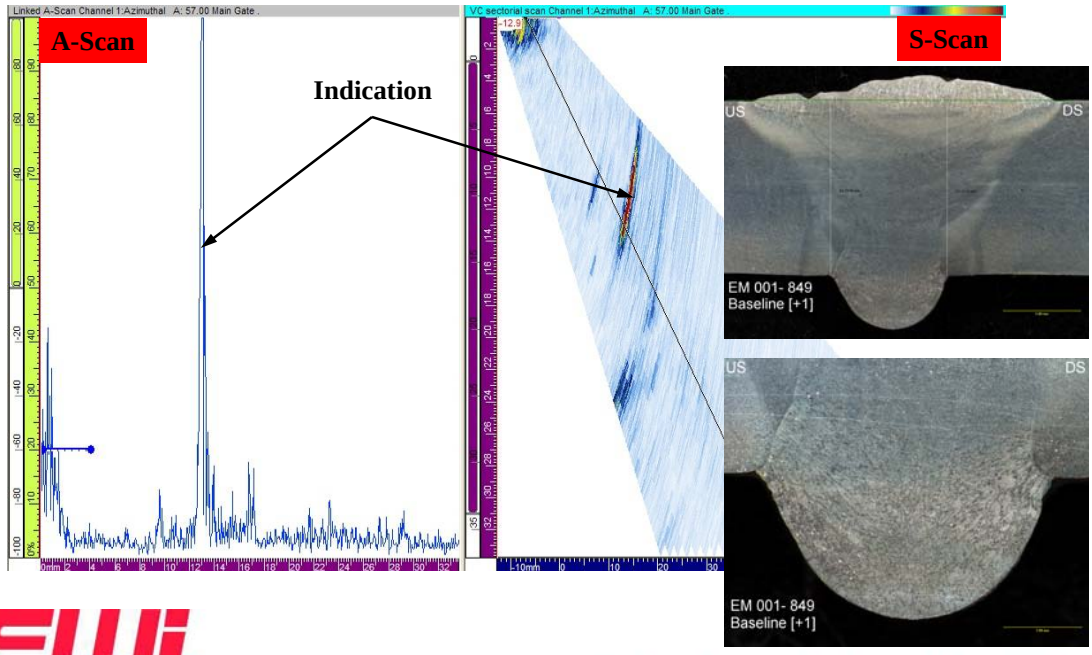

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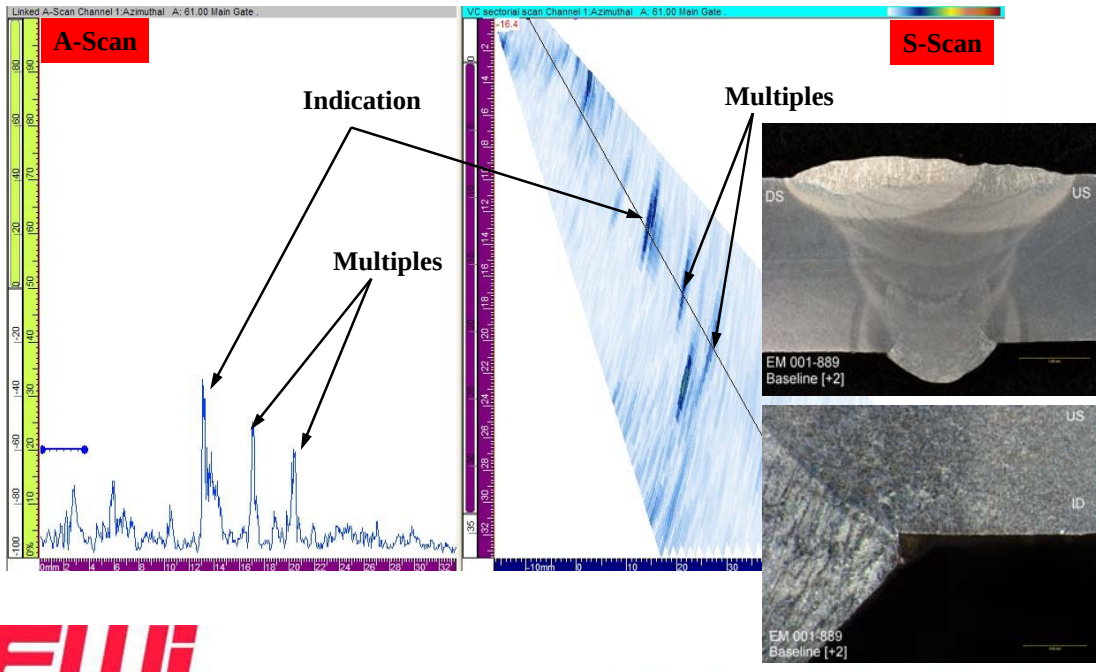
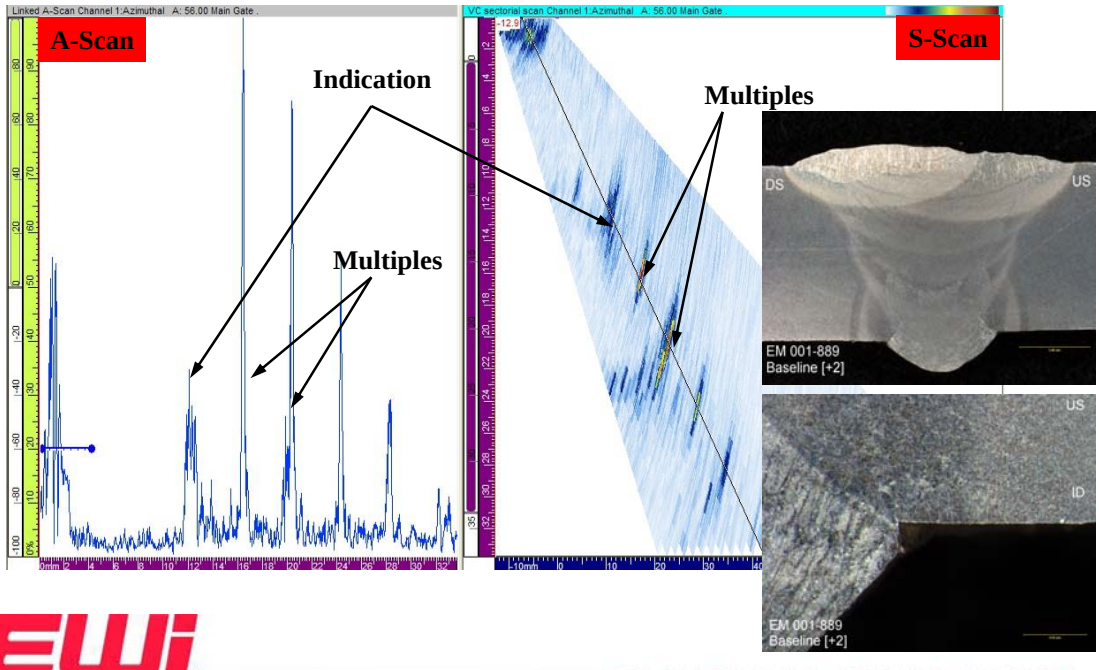
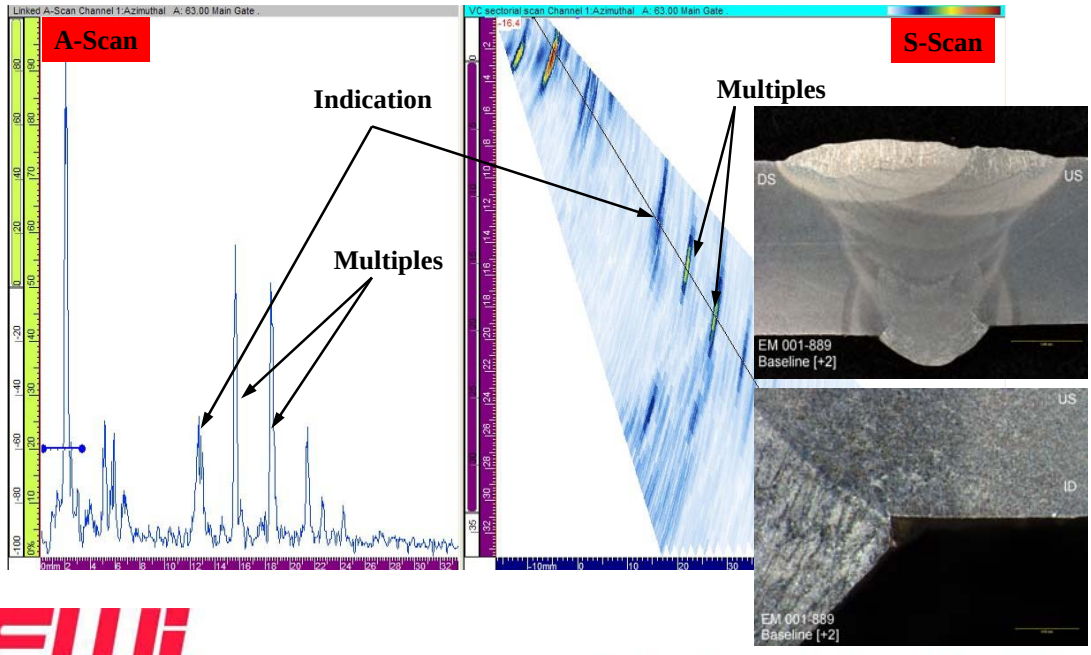


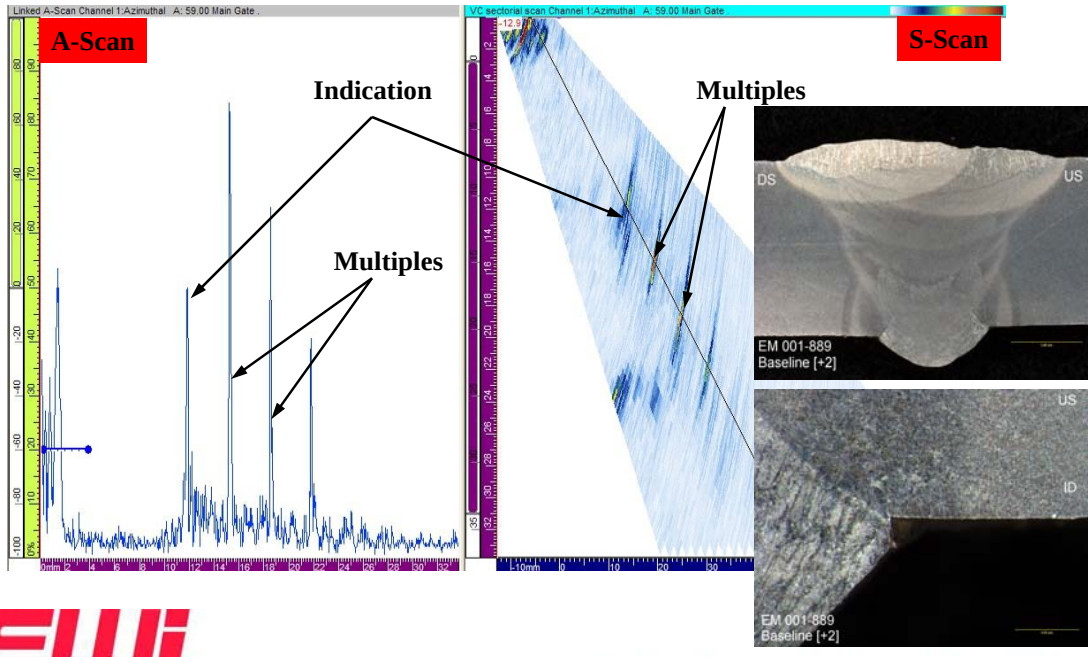
Location 889 US – PA7 60/16, FD 20



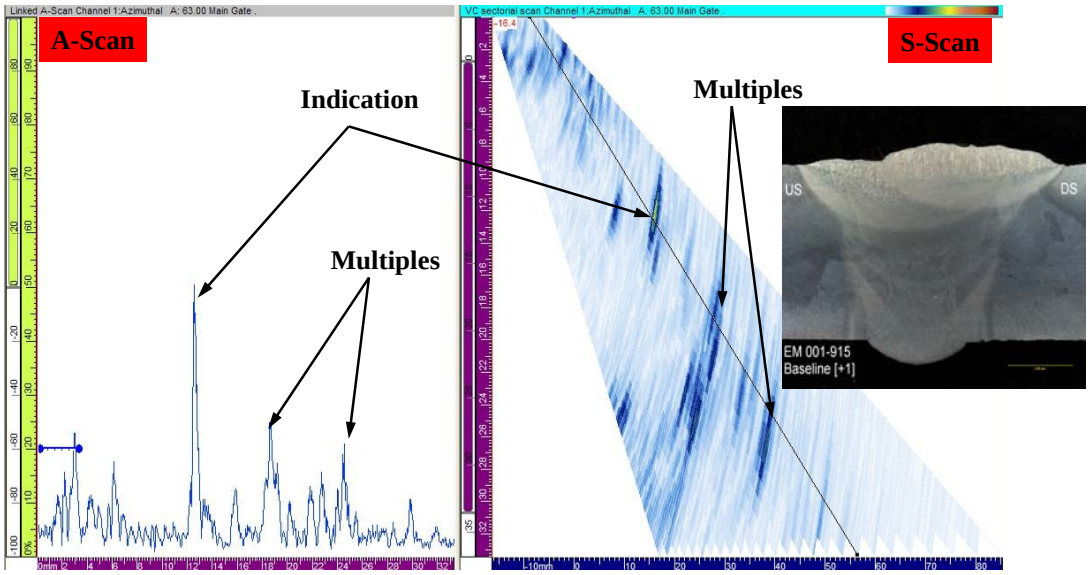
Location 889 DS – PA4 64/21, FD 20



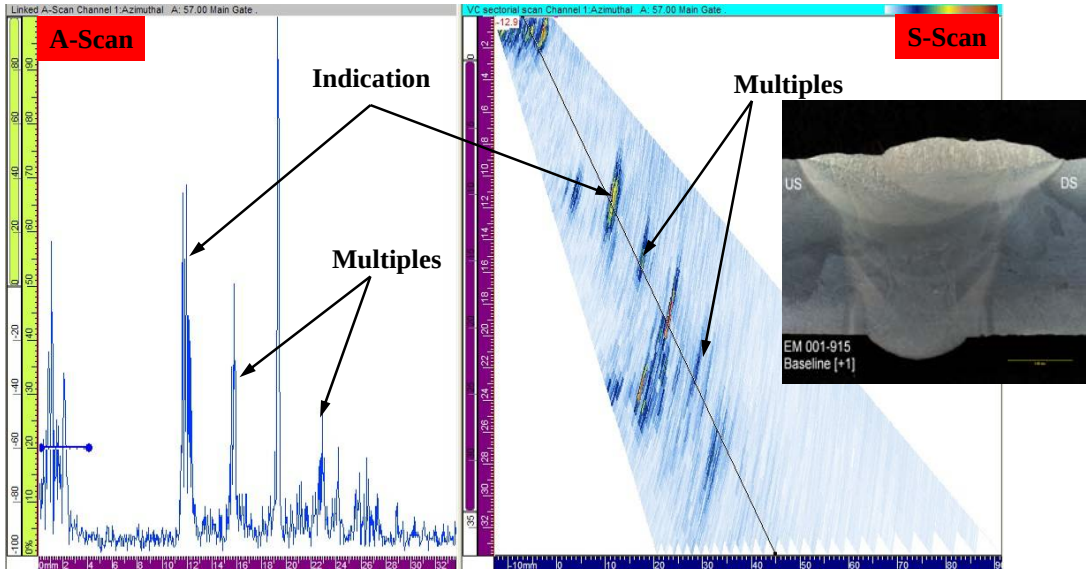
Location 889 DS – PA7 60/16, FD 20



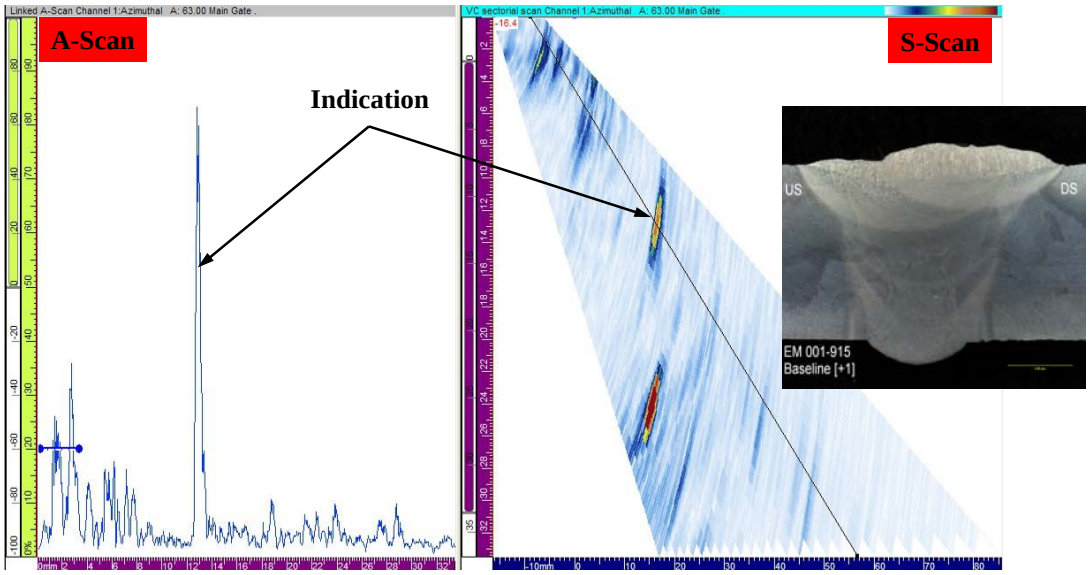
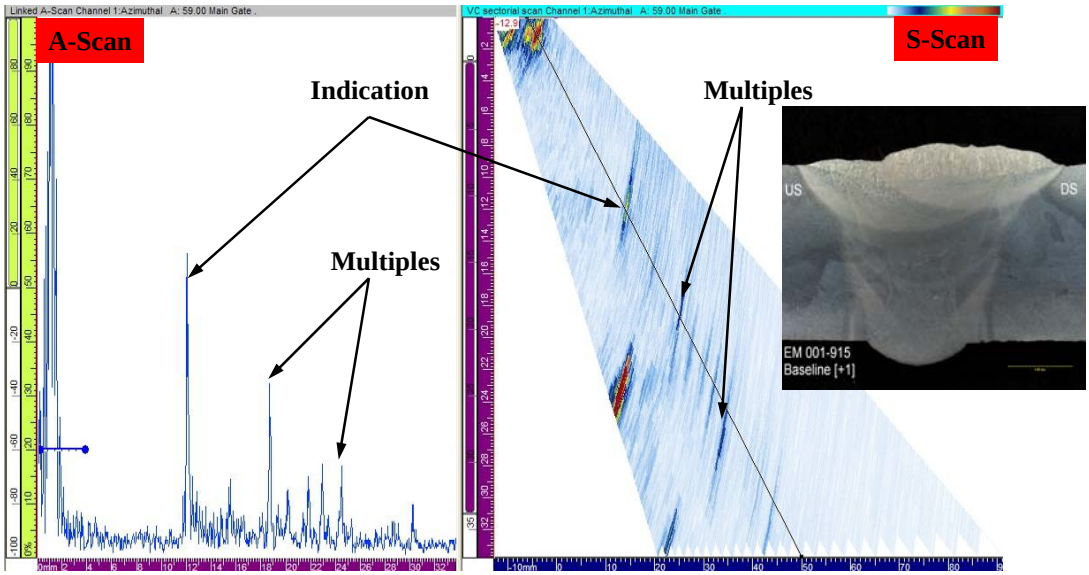
Location 915 US – PA4 64/21, FD 20



Location 915 US – PA7 60/16, FD 20



Location 915 DS – PA4 64/21, FD 20



Location 915 DS – PA7 60/16, FD 20