

1.0 PURPOSE

1.1 This procedure describes the methods utilized for the Visual Examination of materials and workmanship during and after fabrication to assure compliance with the applicable codes and contract requirements.

1.2 Visual Examination is generally used to determine such things as the surface condition of the part, alignment of mating surfaces, shape, or evidence of leading. In addition, visual examination is used to determine a composite materials of (translucent laminate) subsurface conditions.

2.0 SCOPE

The examination of materials upon receipt will include verification that item markings are in accordance with the applicable ASTM/ASME/API material specification and that there is no visible damage to material surfaces, bevels, or flange faces.

This procedure has been qualified in accordance with ASME SEC. V Article 9.

3.0 RESPONSIBILITY

The Quality Manager/Management Representative and Shop Superintendent are to implement and monitor all activities required to visually inspect the product. Other designated employees will have the responsibility to visually inspect the product as required by the procedure.

4.0 APPLICABLE CODES

- ASME Section V, Article 9 – Latest Edition
- ASME B31.3 – Latest Edition
- PFI Standard ES-27 – Latest Edition

5.0 PROCEDURE

5.1 Direct Visual Examination – This method may be used when access is sufficient to place the eye within 24 inches (610 mm) of the surface to be examined and at an angle not less than 30° to the surface to be examined. Mirrors may be used to improve the angle of vision, and aids such as a magnifying lens may be used to assist examinations. The minimum light intensity at the examination surface/site shall be 100 FC (1000 lux).

5.2 The Minimum Visual Examination listed below, which will be performed by a Q.C. Inspector, shall be incorporated in the job instructions and on the shop sketch/shop traveler weld history form. This shall be based

MANUFACTURING PROCEDURE SPECIFICATION AND INSPECTION TEST PLAN FOR INDUCTION BENDING VISUAL INSPECTION		PAGE 1	PASADENA, TEXAS November 17, 2020
	CONTROL COPY DATA		DATE
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Reviewed By:			
Approved By:			
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BENDING PROCEDURE 4

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on the applicable code and contract specification as applicable to the fabrication. The dimensional tolerances shall be in accordance with PFI Standard ES-3 (unless specified otherwise in the applicable code or job instructions).

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