TASK GROUP INSTRUCTION
AIM REV 20.11.4.0 (OCTOBER 2020)

TGI NO.:	COMPONENT NAME:	TYPE:	PHASE:	REPEAT:	CHANGE:
	MN FEED 8-76-0-E	PP	A	0	0

SHIP/HULL NO.:	SHIP/HULL NAME:	SYSTEM:	PROJ/WO NO:	CASREP CAT:
LCC-19	USS BLUE RIDGE	25511	19P	

CU PHASE TITLE:
*F/O - ACCOMPLISH THE RADIOGRAPHIC TEST INSPECTION FOR TGI NO. 3819P25507R01

PREPARING ACTIVITY:

	CODE	PHONE	DATE
PREPARED BY: TAKAHIRO SHIBANO	234.	315-243-3583	25-APR-2025
APPROVED BY: SHINICHI ITO	234.	315-243-4297	25-APR-2025
CONCURRED BY:	CODE	PHONE	DATE
CONCURRED BY:	CODE	PHONE	DATE
CONCURRED BY:	CODE	PHONE	DATE
CONCURRED BY:	CODE	PHONE	DATE

REASON FOR WORK/NEED FOR CHANGE:

CHANGE INSTRUCTIONS:

SPECIAL REQUIREMENTS:

WORK CERTIFICATION SIGNATURES

COMPLETION OF WORK REVIEW:	BADGE NO.:	SHOP/CODE:	PHONE:	DATE:

ACCEPTANCE OF COMPLETED WORK

PHYSICAL INSPECTION REQUIRED: ☐ YES ☒ NO	PHYSICAL INSPECTION COMPLETED:	BADGE NO.:	SHOP/CODE:	PHONE:	DATE:
RECORDS REVIEW:		BADGE NO.:	SHOP/CODE:	PHONE:	DATE:

FOUO: Public availability to be determined under 5 USC 552

3819P25507A01

LIST OF EFFECTIVE PAGES									
SHT NO.	CHG NO.	SHT NO.	CHG NO.	SHT NO.	CHG NO.	SHT NO.	CHG NO.	SHT NO.	CHG NO.
1-3		QAJ20A (1-3)							
J-1									
M-1									
Map (1)									

1. **SCOPE/PURPOSE**

1.1 Title: Onboard Radiographic Test (RT) Inspection of Piping Welded Joint; accomplish

1.2 Location of Work:

1.2.1 Fire Room (8-76-0-E)

1.3 Identification:

1.3.1 Quantity (3 EA), Welded Joint, Piping
System: No. 1B Main Feed, Economizer Outlet
Size: 5 Inch IPS and 4 Inch IPS
Material: Carbon Steel
Joint Design: Butt Weld, P-3
Joint ID: PJ-1, PJ-2 and PJ-5 of TGI No. 3819P25507R01
Piping Class: Class P-1 Piping
Remarks: See Mapping Plan Enclosure-01 for detail.

1.4 Security Classification: None.

1.5 Initial Condition: None.

1.6 Contractor work start date: 7/21/2026

1.7 Contractor work completion date: 11/21/2027

2. **REFERENCES:**

REF. NO.	DOCUMENT /DRAWING NUMBER	DOCUMENT/DRAWING TITLE	REV	CHG NO.	COPY REQ'D (Y/N)	SOURCE DOC (Y/N)	PARA	SEC	PG	CHP
1	NSI FY-26	NAVSEA Standard Items	-	1	N					
2	LI FY-26	Local Standard Items	-	ORG	N					

3. **APPENDICES:**

3.1. Appendix "J" TGI Job Summary Information Sheet
3.2. Appendix "M" TGI Material List
3.3. Appendix "D" Deficiency Form

4. **GENERAL REQUIREMENTS:**

4.1 None.

5. **PROCEDURE:**

5.1 Accomplish the requirements of 009-112 of 2.1.

5.2 Accomplish the requirements of 009-012 of 2.1, including Table One, Column A, Line 11 for RT inspection of each welded joint listed in 1.3.1, using Enclosure-01 for guidance.

5.2.1 Accomplish the requirements of 009-009 of 2.1.

5.2.2 Obtain each copy of QA Form 20 Enclosure-02-1 through Enclosure-02-3 of TGI No. 3819P25507R01 for verification of joint ID PJ-1, PJ-2 and PJ-5. See 5.3.4.

5.2.3 Accomplish the requirements of 099-911YO of 2.2, using QA Form J20A Enclosure-02-1 through Enclosure-02-3.

5.3 Notes:

5.3.1 Planner: Code 234 T. Shibano, 243-3583
Engineer: Code 260 T. Uno, 243-5085

5.3.2 Work Integration Manager (WIM): Code 333 T. Yaginuma, 080-5419-0598

5.3.3 Welding of each joint has been accomplished by SRF-JRMC in accordance with TGI No. 3819P25507R01 for joint ID PJ-1, PJ-2 and PJ-5.

5.3.4 SRF-JRMC WIM will provide a copy of QA Form 20 when requested by the Contractor.

5.3.5 JCN EM02-8919 is related to this TGI.

5.4 Government Furnished Material (GFM): None.

5.5 SRF-JRMC will provide the following service work: (TGI No. 3819P25507S03).

5.5.1 [C740] Crane and crane rigging service.

5.5.2 [X99E] Utilities service.

5.5.3 [X99M] Utility service, including low pressure air supply, water supply, and steam supply.

5.5.4 [C106.1] Safety inspection for SRF-JRMC employees.

5.5.5 [C106.2] Gas free inspection for SRF-JRMC employees.

5.5.6 [C106R] RSO and ARSO service for RT.

5.5.7 [C135] QA inspection for (G)Symbol inspection.

APPENDIX "J"
TGI JOB SUMMARY INFORMATION SHEET

SYSTEM:	PLANT NO.:	COMPONENT NAME:	TYPE:	PHASE:	REPEAT:	CU PH VERSION:	CASREP CAT:
25511		MN FEED 8-76-0-E	PP	A	0	0	

CU PHASE TITLE:
***F/O - ACCOMPLISH THE RADIOGRAPHIC TEST INSPECTION FOR TGI NO. 3819P25507R01**

PRIMARY COMPONENT:

COMPONENT UNIT LIST (FOR ASSEMBLIES):

ATTACHMENT LIST:
1. ENCLOSURE-01 (3819P25507A01-Map.pdf) saved on 24-APR-2025 0000.
2. ENCLOSURE-02 (3819P25507A01-QAJ20A.docx) saved on 24-APR-2025 0000.

ZONE MANAGER:	ZONE:	COMPARTMENT:	LEVEL:	FRAME:	SIDE:
YAGINUMA ,TAKEHIDE		8-76-0-E	8		U

JO:	KO:	TOTAL MAN HRS:	TOTAL MAT'L COST	TOTAL DURATION:	PLANNING ACCEPTANCE:
3819P25507	A01				

CU PHASE DESCRIPTION:
The purpose of this TGI is to accomplish the Radiographic Test (RT) inspection of 1B boiler feed water piping for supporting of TGI No. 3819P25507R01.

Location of Work:
Fire Room (8-76-0-E)

TASK NAME	SHOP	TSD/WC	TS	CREW#	MHRS	HIGH RAD HOURS	RC GRID#
5.2 QA							
CFM: (cost for radiographic test of each welded joint and MISC.)							
Process Funding Document.							

TGI NO.:	MN FEED 8-76-0-E	PP	A	0
SHIP:	LCC-19	CHG/VER:		0/0

APPENDIX "M"
TGI MATERIAL LIST

SYSTEM:	PLANT NO.:	COMPONENT NAME:	TYPE:	PHASE:	REPEAT:	CU PH VERSION:	CASREP CAT:
25511		MN FEED 8-76-0-E	PP	A	0	0	

CU PHASE TITLE:
*F/O - ACCOMPLISH THE RADIOGRAPHIC TEST INSPECTION FOR TGI NO. 3819P25507R01

MATERIAL REFERENCES

REF NO.	DOCUMENT/DRAWING NUMBER	DOCUMENT/DRAWING TITLE	REV

JOB ORDER:	KEY OP:
3819P25507	A01

MATERIAL LIST

ITEM NO.	PC NO.	REF NO.	M / C	DESCRIPTION	STOCK NUMBER	GENERIC MATL TYPE	LVL	QA	HAZ MAT	DOC NO.	QTY REQD/ UNIT	QTY USED/ UNIT

NOTES:

TGI NO.:	MN FEED 8-76-0-E	PP	A	0
SHIP:	LCC-19	CHG/VER:		0/0

FOUO

☐ NUCLEAR

APPENDIX "D"
DEFICIENCY FORM

☐ NON-NUCLEAR

1. SHIP/HULL NO.:	2a. DL or DR No. (Circle One)	2b. REVISION:	3a. COMPONENT NAME:	3b. TYPE:	3c. PHASE:	3d. REPEAT:
LCC-19			MN FEED 8-76-0-E	PP	A	0

4a. ICN:	4b. KEY OP:	5. LOC SPACE/LVL: FRAME: P/S/C:	6. CAUSED BY:
3819P25507	A01		

7. DESCRIPTION:

8. ORIGINATOR:	NAME:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.:

9. CORRECTIVE ACTION:

10. EVALUATOR:	NAME:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.:

FOR NON-NUCLEAR USE ONLY

11. RFD/RFW REQ'D ☐ LAR REQ'D ☐ ILS MOD REQ'D ☐

SRD/PLAN REV REQ'D ☐

DWG NO.: _____ S/A NO.: _____

12. ISOLATION SATISFACTORY:	SIGN:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.:
13. SUBSAFE OQE RECORD? YES ☐ NO ☐	SIGN:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.
14. CORRECTIVE ACTION COMPLETE:	SIGN:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.
15. INSPECTION REQ'D? :YES ☐ NO ☐	INSPECTION COMPLETE/SIGN:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.
16. RECORDS REVIEW COMPLETE (DR ONLY)	SIGN:	BADGE:	SHOP/CODE:	DATE:	PHONE NO.

DL's ISSUED (DR ONLY)								

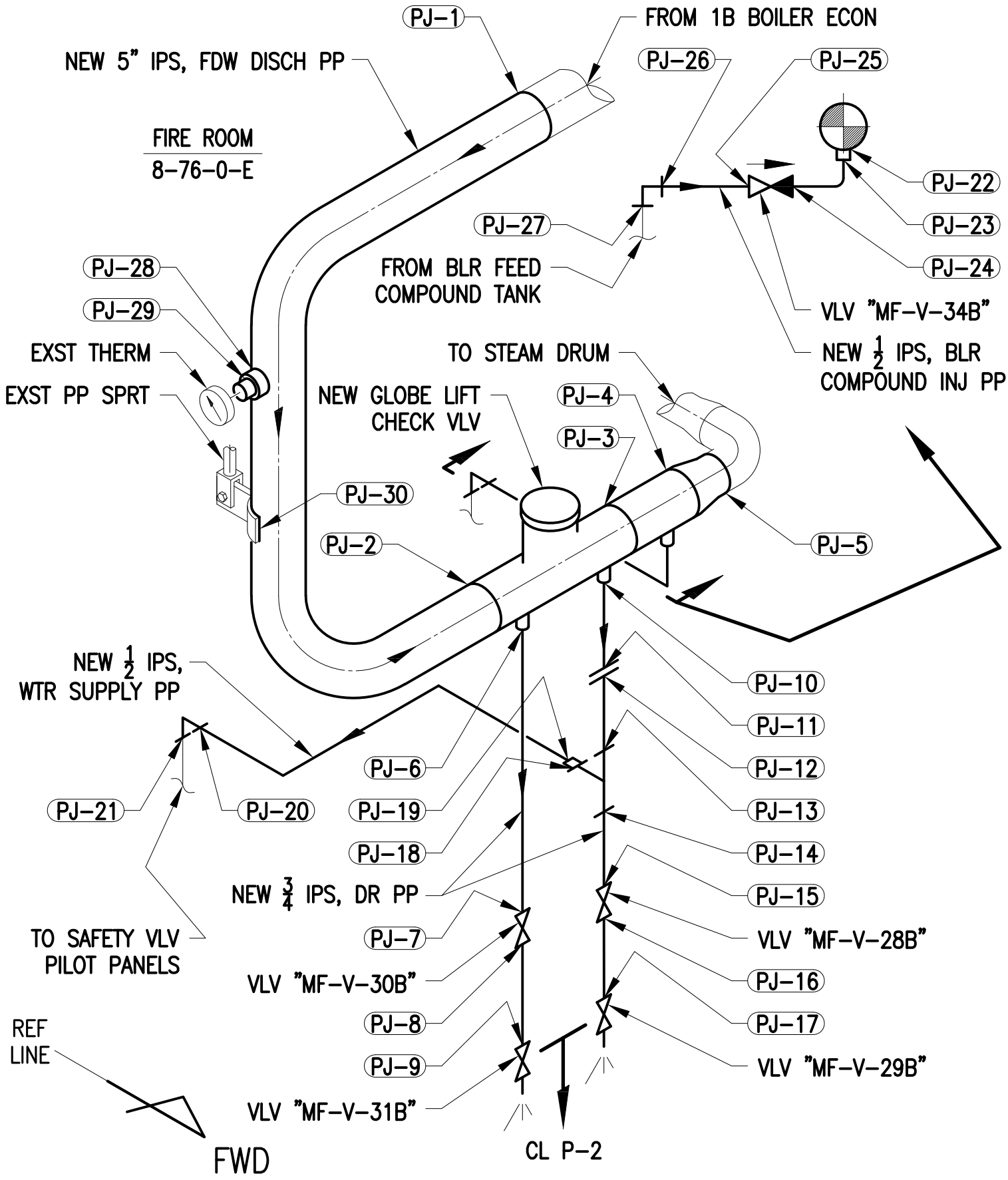
FOUO: Public availability to be determined under 5 USC 552

☐ NUCLEAR

Deficiency Form Continuation Sheet

☐ NON-NUCLEAR

1. SHIP/HULL NO.:	2a. DL or DR No. (Circle One)	2b. REVISION:	3a. COMPONENT NAME:	3b. TYPE:	3c. PHASE:	3d. REPEAT:
LCC-19			MN FEED 8-76-0-E	PP	A	0



MAPPING PLAN

ENCLOSURE-01

3819P25507A01

SHEET 1 OF 1

QA FORM J20A (FRONT)

2. SHIP AND HULL NO.: USS BLUE RIDGE (LCC-19)	3. JOB ORDER/KEY OP.: 3819P25507/A01	4. CU PHASE TITLE: *F/O - ACCOMPLISH THE RADIOGRAPHIC TEST INSPECTION FOR TGI NO. 3819P25507R01		
5. RT PERFORMED BY:	6. SPECIMEN MATERIAL: [] CSTL [] CRES [] CUNI [] AL [] OTHER:	7. TM:	8. TS:	9. JOINT ID PJ-1
10. WELD TYPE: [] Butt [] W/backing [] Backing removed [] Con insert [] Other:		11. REPAIR NO. [] Orig. [] R-	12. INSPECTION PROCEDURE(S):	
13. ACCEPTANCE STANDARD [] MIL-STD 2035 [] MIL-STD 1689 [] Other: [] Class 1 [] Class 2 [] Class 3		14. PENETRAMETER: SIZE: GROUP: []02 []1 []4 []Other:		
15. PENETRAMETER PLACEMENT [] Source side [] Film Side [] On/off [] Separate block	16. PENETRAMETER TYPE: [] MIL-Type [] ASTM-Type	17. QUALITY LEVEL [] 2-2T [] 2-4T []Other:		
18. RT COVERAGE REQUIRED: [] 60 DEG [] 360 DEG [] 100% [] Other:	19. EXPOSURE TECHNIQUE: [] SWE/SWV [] DWE/SWV [] DWE/DWV [] O [] S	20. FILM TYPE: [] Fuji IX-80 [] Fuji IX-100 [] Other:		
21. FILM LOAD [] Single [] Double [] Other:	22. INTENSIFYING SCREENS: [] Pb Oxide [] Pb Foil	23. FRONT FILTER Tm: [] N/A	24. BACK FILTER Tm:	
25. RADIATION SOURCE: [] X-ray [] Ir-192 [] Se-75 [] Co 60	26. VOLTAGE / CURIES:	27. FSS / SOURCE DIM.:	28. SFD: Min: Act:	29. BEAM ANGLE:
30. SHIM MATERIAL: []N/A GROUP: []02 []1 []4 []Other:	31. SHIM THICKNESS: []N/A	32. FILM ID: []N/A	33. MASKING [] Used [] Not Used	

34. RADIOGRAPHIC SHOOTING SKETCH

Depict the following: (1) Direction of radiation (2) Placement of penetrameter (3) Location of location marker (4) Location of shims (if used) (5) Location of Pb "B" (6) Location & thickness of back filter (7) Location of film (8) Blocking/masking technique used (if applicable)

STANDARD SET-UPS

[ ] TECH 1
SWE/SWV

[ ] TECH 2
DWE/SWV

[ ] TECH 3
DWE/DWV (O)

[ ] TECH 4
DWE/DWV (S)

NOTE: REFERENCE TO A STANDARD SETUP IS ACCEPTABLE

35. REMARKS:

36. RADIOGRAPHER	DATE (DATE OF EXPOSURE):	37. REPORT NUMBER:

QA FORM J20A (BACK)

38. RADIOGRAPHIC INTERPRETATION OF JOINT NO.: _____									39. REMARKS AND INDICATION DETAILS:
(a) LOCATION MARKERS (INCREMENTS)									
(b) PENETRAMETER PLACEMENT									
(c) REQ. T-HOLE VISIBLE									
(d) DENSITY (PENE AND AOI)									
(e) BACKSCATTER CONTROL (LEAD "B')									
(1) CRACK									
(2) SLAG/OXIDE									
(3) POROSITY									
(4) LACK OF PENETRATION									
(5) LACK OF FUSION									
(6) MELT THROUGH									
(7) BURN THROUGH									
(8) ROOT OXIDATION									
(9) CRATER PIT									
(10) TUNGSTEN INCLUSION									
(11) ROOT SURFACE CONCAVITY									
(12) ROOT SURFACE CONVEXITY									
(13) UNDERCUT									
(14) ROOT CENTER LINE CREASE									
(15) INCOMPLETE INSERT MELT									
(16) QUESTIONABLE DISCONTINUITY									
(17) FILM ARTIFACTS									
(18) BASE METAL INDICATIONS									
(19) INADVERTENT RADIOGRAPHY									
(20)									
(21)									
(22)									

40. INTERPRETATION KEY:
(1) Blocks left blank – condition is NOT present on the film

(2) Blocks marked O – condition is present on the film and is acceptable.

(3) Blocks marked X – condition is present on the film and rejectable.

(4) Blocks marked with prepared notes (①,②, etc.) – condition present and see applicable note(s).

41. PREPARED NOTES
① Visually verified as an acceptable surface condition.
② Engineering evaluation required/requested via CFR.
③ Artifacts (Crimp or pressure marks, processing marks, finger prints, streaks, etc.) present on film and do not interfere with interpretation.
④ Film superimposed for interpretation, evaluation.
⑤
⑥

42. REMARKS

43. CONDITION FOUND REPORTS (CFR) NUMBER(s) SUBMITTED: []N/A

44. FINAL DISPOSITION	45. RT INSPECTOR DATE	46. REPORT NUMBER:
[ ] ACCEPT [ ] REJECT		

THE PERSON DESIGNATED TO SIGN FOR AN ACTION VERIFIES, BASED ON PERSONAL OBSERVATION OR CERTIFIED RECORDS, AND CERTIFIES BY HIS/HER SIGNATURE THAT THE ACTION HAS BEEN PERFORMED IN ACCORDANCE WITH THE SPECIFIED REQUIREMENTS.

REPORT OF RT OPERATIONS AND EVALUATION **PAGE _1_ OF _2_**

QA FORM J20A (FRONT)

2. SHIP AND HULL NO.: USS BLUE RIDGE (LCC-19)	3. JOB ORDER/KEY OP.: 3819P25507/A01	4. CU PHASE TITLE: *F/O - ACCOMPLISH THE RADIOGRAPHIC TEST INSPECTION FOR TGI NO. 3819P25507R01

5. RT PERFORMED BY:	6. SPECIMEN MATERIAL: [] CSTL [] CRES [] CUNI [] AL [] OTHER:	7. TM:	8. TS:	9. JOINT ID PJ-2

10. WELD TYPE: [] Butt [] W/backing [] Backing removed [] Con insert [] Other:	11. REPAIR NO. [] Orig. [] R-	12. INSPECTION PROCEDURE(S):

13. ACCEPTANCE STANDARD [] MIL-STD 2035 [] MIL-STD 1689 [] Other: [] Class 1 [] Class 2 [] Class 3	14. PENETRAMETER: SIZE: GROUP: []02 []1 []4 []Other:

15. PENETRAMETER PLACEMENT [] Source side [] Film Side [] On/off [] Separate block	16. PENETRAMETER TYPE: [] MIL-Type [] ASTM-Type	17. QUALITY LEVEL [] 2-2T [] 2-4T []Other:

18. RT COVERAGE REQUIRED: [] 60 DEG [] 360 DEG [] 100% [] Other:	19. EXPOSURE TECHNIQUE: [] SWE/SWV [] DWE/SWV [] DWE/DWV [] O [] S	20. FILM TYPE: [] Fuji IX-80 [] Fuji IX-100 [] Other:

21. FILM LOAD [] Single [] Double [] Other:	22. INTENSIFYING SCREENS: [] Pb Oxide [] Pb Foil	23. FRONT FILTER Tm: [] N/A	24. BACK FILTER Tm:

25. RADIATION SOURCE: [] X-ray [] Ir-192 [] Se-75 [] Co 60	26. VOLTAGE / CURIES:	27. FSS / SOURCE DIM.:	28. SFD: Min: Act:	29. BEAM ANGLE:

30. SHIM MATERIAL: []N/A GROUP: []02 []1 []4 []Other:	31. SHIM THICKNESS: []N/A	32. FILM ID: []N/A	33. MASKING [] Used [] Not Used

34. RADIOGRAPHIC SHOOTING SKETCH

Depict the following: (1) Direction of radiation (2) Placement of penetrameter (3) Location of location marker (4) Location of shims (if used) (5) Location of Pb "B" (6) Location & thickness of back filter (7) Location of film (8) Blocking/masking technique used (if applicable)

STANDARD SET-UPS

[ ] TECH 1
SWE/SWV

[ ] TECH 2
DWE/SWV

[ ] TECH 3
DWE/DWV (O)

[ ] TECH 4
DWE/DWV (S)

NOTE: REFERENCE TO A STANDARD SETUP IS ACCEPTABLE

35. REMARKS:

36. RADIOGRAPHER	DATE (DATE OF EXPOSURE):	37. REPORT NUMBER:

QA FORM J20A (BACK)

38. RADIOGRAPHIC INTERPRETATION OF JOINT NO.: _____									39. REMARKS AND INDICATION DETAILS:
(a) LOCATION MARKERS (INCREMENTS)									
(b) PENETRAMETER PLACEMENT									
(c) REQ. T-HOLE VISIBLE									
(d) DENSITY (PENE AND AOI)									
(e) BACKSCATTER CONTROL (LEAD "B')									
(1) CRACK									
(2) SLAG/OXIDE									
(3) POROSITY									
(4) LACK OF PENETRATION									
(5) LACK OF FUSION									
(6) MELT THROUGH									
(7) BURN THROUGH									
(8) ROOT OXIDATION									
(9) CRATER PIT									
(10) TUNGSTEN INCLUSION									
(11) ROOT SURFACE CONCAVITY									
(12) ROOT SURFACE CONVEXITY									
(13) UNDERCUT									
(14) ROOT CENTER LINE CREASE									
(15) INCOMPLETE INSERT MELT									
(16) QUESTIONABLE DISCONTINUITY									
(17) FILM ARTIFACTS									
(18) BASE METAL INDICATIONS									
(19) INADVERTENT RADIOGRAPHY									
(20)									
(21)									
(22)									

40. INTERPRETATION KEY:
(1) Blocks left blank – condition is NOT present on the film

(2) Blocks marked O – condition is present on the film and is acceptable.

(3) Blocks marked X – condition is present on the film and rejectable.

(4) Blocks marked with prepared notes (①,②, etc.) – condition present and see applicable note(s).

41. PREPARED NOTES
① Visually verified as an acceptable surface condition.
② Engineering evaluation required/requested via CFR.
③ Artifacts (Crimp or pressure marks, processing marks, finger prints, streaks, etc.) present on film and do not interfere with interpretation.
④ Film superimposed for interpretation, evaluation.
⑤
⑥

42. REMARKS

43. CONDITION FOUND REPORTS (CFR) NUMBER(s) SUBMITTED: []N/A

44. FINAL DISPOSITION	45. RT INSPECTOR DATE	46. REPORT NUMBER:
[ ] ACCEPT [ ] REJECT		

THE PERSON DESIGNATED TO SIGN FOR AN ACTION VERIFIES, BASED ON PERSONAL OBSERVATION OR CERTIFIED RECORDS, AND CERTIFIES BY HIS/HER SIGNATURE THAT THE ACTION HAS BEEN PERFORMED IN ACCORDANCE WITH THE SPECIFIED REQUIREMENTS.

REPORT OF RT OPERATIONS AND EVALUATION **PAGE _1_ OF _2_**

QA FORM J20A (FRONT)

2. SHIP AND HULL NO.: USS BLUE RIDGE (LCC-19)	3. JOB ORDER/KEY OP.: 3819P25507/A01	4. CU PHASE TITLE: *F/O - ACCOMPLISH THE RADIOGRAPHIC TEST INSPECTION FOR TGI NO. 3819P25507R01

5. RT PERFORMED BY:	6. SPECIMEN MATERIAL: [] CSTL [] CRES [] CUNI [] AL [] OTHER:	7. TM:	8. TS:	9. JOINT ID PJ-5

10. WELD TYPE: [] Butt [] W/backing [] Backing removed [] Con insert [] Other:	11. REPAIR NO. [] Orig. [] R-	12. INSPECTION PROCEDURE(S):

13. ACCEPTANCE STANDARD [] MIL-STD 2035 [] MIL-STD 1689 [] Other: [] Class 1 [] Class 2 [] Class 3	14. PENETRAMETER: SIZE: GROUP: []02 []1 []4 []Other:

15. PENETRAMETER PLACEMENT [] Source side [] Film Side [] On/off [] Separate block	16. PENETRAMETER TYPE: [] MIL-Type [] ASTM-Type	17. QUALITY LEVEL [] 2-2T [] 2-4T []Other:

18. RT COVERAGE REQUIRED: [] 60 DEG [] 360 DEG [] 100% [] Other:	19. EXPOSURE TECHNIQUE: [] SWE/SWV [] DWE/SWV [] DWE/DWV [] O [] S	20. FILM TYPE: [] Fuji IX-80 [] Fuji IX-100 [] Other:

21. FILM LOAD [] Single [] Double [] Other:	22. INTENSIFYING SCREENS: [] Pb Oxide [] Pb Foil	23. FRONT FILTER Tm: [] N/A	24. BACK FILTER Tm:

25. RADIATION SOURCE: [] X-ray [] Ir-192 [] Se-75 [] Co 60	26. VOLTAGE / CURIES:	27. FSS / SOURCE DIM.:	28. SFD: Min: Act:	29. BEAM ANGLE:

30. SHIM MATERIAL: []N/A GROUP: []02 []1 []4 []Other:	31. SHIM THICKNESS: []N/A	32. FILM ID: []N/A	33. MASKING [] Used [] Not Used

34. RADIOGRAPHIC SHOOTING SKETCH

Depict the following: (1) Direction of radiation (2) Placement of penetrameter (3) Location of location marker (4) Location of shims (if used) (5) Location of Pb "B" (6) Location & thickness of back filter (7) Location of film (8) Blocking/masking technique used (if applicable)

STANDARD SET-UPS

[ ] TECH 1
SWE/SWV

[ ] TECH 2
DWE/SWV

[ ] TECH 3
DWE/DWV (O)

[ ] TECH 4
DWE/DWV (S)

NOTE: REFERENCE TO A STANDARD SETUP IS ACCEPTABLE

35. REMARKS:

36. RADIOGRAPHER	DATE (DATE OF EXPOSURE):	37. REPORT NUMBER:

QA FORM J20A (BACK)

38. RADIOGRAPHIC INTERPRETATION OF JOINT NO.: _____									39. REMARKS AND INDICATION DETAILS:
(a) LOCATION MARKERS (INCREMENTS)									
(b) PENETRAMETER PLACEMENT									
(c) REQ. T-HOLE VISIBLE									
(d) DENSITY (PENE AND AOI)									
(e) BACKSCATTER CONTROL (LEAD "B')									
(1) CRACK									
(2) SLAG/OXIDE									
(3) POROSITY									
(4) LACK OF PENETRATION									
(5) LACK OF FUSION									
(6) MELT THROUGH									
(7) BURN THROUGH									
(8) ROOT OXIDATION									
(9) CRATER PIT									
(10) TUNGSTEN INCLUSION									
(11) ROOT SURFACE CONCAVITY									
(12) ROOT SURFACE CONVEXITY									
(13) UNDERCUT									
(14) ROOT CENTER LINE CREASE									
(15) INCOMPLETE INSERT MELT									
(16) QUESTIONABLE DISCONTINUITY									
(17) FILM ARTIFACTS									
(18) BASE METAL INDICATIONS									
(19) INADVERTENT RADIOGRAPHY									
(20)									
(21)									
(22)									

40. INTERPRETATION KEY:
(1) Blocks left blank – condition is NOT present on the film

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(3) Blocks marked X – condition is present on the film and rejectable.

(4) Blocks marked with prepared notes (①,②, etc.) – condition present and see applicable note(s).

41. PREPARED NOTES
① Visually verified as an acceptable surface condition.
② Engineering evaluation required/requested via CFR.
③ Artifacts (Crimp or pressure marks, processing marks, finger prints, streaks, etc.) present on film and do not interfere with interpretation.
④ Film superimposed for interpretation, evaluation.
⑤
⑥

42. REMARKS

43. CONDITION FOUND REPORTS (CFR) NUMBER(s) SUBMITTED: []N/A

44. FINAL DISPOSITION	45. RT INSPECTOR DATE	46. REPORT NUMBER:
[ ] ACCEPT [ ] REJECT		

THE PERSON DESIGNATED TO SIGN FOR AN ACTION VERIFIES, BASED ON PERSONAL OBSERVATION OR CERTIFIED RECORDS, AND CERTIFIES BY HIS/HER SIGNATURE THAT THE ACTION HAS BEEN PERFORMED IN ACCORDANCE WITH THE SPECIFIED REQUIREMENTS.