

# Creating an RT Report

## Radiographic Examination Report

1 On the Tool Bar, click on the small drop-down arrow next to the "New" icon. Select **Radiographic Report**.

2 Begin filling out the record by entering the Project and Client information. While filling out this record, make sure to take advantage of the drop-down menus and databases to select your data rather than typing the information manually.

3 When entering the **Examination results**, make sure to enter the welder that performed the welding, the length of the examined area, length of rejectable welding, and the process used. Tracking this data will enable the use of Performance Reports which determine reject rates and helps to monitor production weld quality.

4 The **Examination results** section of this form is "never ending". Continue adding as many line items as needed and WeldOffice® NDE will automatically span your report over as many

5 Based on the number of techniques specified in the Examination results section (A,B,C,D), WeldOffice® NDE provides the proper number of **Equipment and Technique details** sections.

6 When filling out the Equipment and Techniques details, Source and Film data can be entered straight out of the Source and Film Profile databases preventing the need to ever enter the same information twice. Additionally, Curies will be automatically calculated based on the date at the top of the record. See the page on **Source & Film Databases**

7 Instead of drawing an NDE Technique sketch, a database of these images are already included in the Sketch Selection Manager. See the **Drawings & Sketches** section.

8 To sign the record, simply click your cursor in the appropriate Signature box. This will input the name and signature of the person currently logged in, as well as the current date. For more information on electronic signatures, see the **Security Settings** section.

Weld piece ID	Area	Result	Discontinuity	Comments	Tech	Welder D	Length of area (in)	Length of defect(s) (in)	Process
Weld 001	0-1	ACC			A	5555	10	0	SMAW
	1-2	REJ	Incomplete				10	.75	
	2-3	REJ	Incomplete				10	.25	
	3-0	ACC					10	0	
Weld 002	0-1	ACC			A	7777	10	0	SMAW
	1-2	ACC					10	0	
	2-3	ACC					10	0	
	3-0	ACC					10	0	
Weld 003	0-1	ACC			A	7777	10	0	SMAW
	1-2	ACC					10	0	
	2-3	ACC					10	0	
	3-0	ACC					10	0	
Weld 004	0-1	ACC			A	5555	10	0	SMAW
	1-2	ACC					10	0	
	2-3	ACC					10	0	
	3-0	ACC					10	0	
Weld 005	0-1	ACC			B	5555	13.5	0	FCAW
	1-2	ACC					13.5	0	
	2-3	ACC					13.5	0	
	3-4	ACC					13.5	0	
	4-5	ACC					13.5	0	
	5-0	ACC					13.5	0	
Weld 006	0-1	ACC			B	5555	13.5	0	FCAW
	1-2	ACC					13.5	0	
	2-3	ACC					13.5	0	
	3-4	ACC					13.5	0	
	4-5	ACC					13.5	0	
	5-0	ACC					13.5	0	

Equipment and Technique details - Technique "A"			
Source	Iridium 192	Source to film (in.)	.13
Serial #	91010	Object to film (in.)	.75
Curies	62	Material	C.Fe
Size (in.)	0.10	Pipe dia./Plate	.25
IQI type	Hole	Thickness (in.)	.375
IQI size	15-2T	Shim (in.)	.125
IQI side	Film	Screen type	Lead
Developer time/temp	Emer/EBF	Unsharp Ug (in.)	.004
Density range	2.8 - 3.2	Exposure time	45 Sec.
Screen size	.005 / .010	Film type	1
Film make	Kodak	Film speed	T
Film size (in.)	3.5 x 8.5	Film per cassette	1
Total film	16	Exposure/view type	Double Wall Exposure/Single Wall View

Equipment and Technique details - Technique "B"			
Source	Iridium 192	Source to film (in.)	.13
Serial #	91010	Object to film (in.)	.5
Curies	62	Material	C.Fe
Size (in.)	0.10	Pipe dia./Plate	.25
IQI type	Hole	Thickness (in.)	.375
IQI size	20-2T	Shim (in.)	.125
IQI side	Source	Screen type	Lead
Developer time/temp	5 min/EBF	Unsharp Ug (in.)	.006
Density range	2.4 - 2.9	Exposure time	32 Sec.
Screen size	.005 / .010	Film type	1
Film make	Kodak	Film speed	T
Film size (in.)	3.5 x 7.7	Film per cassette	1
Total film	12	Exposure/view type	Single Wall Exposure/Single Wall View

NDE Technician		Name	Lvl.	Signature
Date				

Client		Name	Signature
Date			

Certifying Authority		Name	Signature
Date			



**C-spec**  
P.O. Box 27604, Concord, California 94527, (888) 673-9777  
**Radiographic Examination Report (RT)**  
C-spec WeldOffice® Software

		NDE procedure number	RT 001
Client	Power Plant Company	Exam date	3/14/01
Project	ABC Power Plant	Project ID number	Project 001
Location	Boonyville, USA	Job/serial number	Job # 001
Project specification	ABCP-001	Drawing number	Drawing 001
Acceptance standards	ASME Section 1	NDE reference number	N/A

**Examination results**

Weld piece ID	Area	Result	Discontinuity	Comments	Tech.	Welder ID	Weld Area	Defect length	Process					
Weld 001	0-1	ACC	Incomplete penetration		A	5555	10	0	SMAW					
	1-2	REJ					10	.75						
	2-3	REJ					10	.25						
3-0	ACC	10					0							
Weld 002	0-1	ACC					Incomplete penetration			A	7777	10	0	SMAW
	1-2	ACC										10	0	
	2-3	ACC	10	0										
3-0	ACC	10	0											
Weld 003	0-1	ACC	Incomplete penetration		A	7777			10			0	SMAW	
	1-2	ACC							10			0		
	2-3	ACC					10	0						
3-4	ACC	10					0							
Weld 004	0-1	ACC					Incomplete penetration		A	5555	10	0		SMAW
	1-2	ACC									10	0		
	2-3	ACC	10	0										
3-0	ACC	10	0											
Weld 005	0-1	ACC	Incomplete penetration		B	5555					13.5	0	FCAW	
	1-2	ACC									13.5	0		
	2-3	ACC					13.5	0						
	3-4	ACC					13.5	0						
	4-5	ACC					13.5	0						
5-0	ACC	13.5					0							
Weld 006	0-1	ACC	Incomplete penetration		B	5555	13.5	0	FCAW					
	1-2	ACC					13.5	0						
	2-3	ACC					13.5	0						
	3-4	ACC					13.5	0						
	4-5	ACC					13.5	0						
5-0	ACC	13.5					0							

**Equipment and Technique details - Technique "A"**

Source S/N	91010	Source to film	13	Screen size	.005 / .010	<p>Double Wall Exposure/Single Wall View</p>
Type / kV	Iridium 192	Object to film	.75	Film type	1	
Curies / mA	62	Material	C-Fe	Film make	Kodak	
Size	0.10	Pipe dia./Plate	12	Film speed	T	
IQI type	Hole	Thickness	.375	Film size	3.5 x 8.5	
IQI size	15-2T	Shim.	.125	Film per cassette	1	
IQI side	Film	Screen type	Lead	Total film	16	
Dev. time/temp	5 min/ 68 F			Unsharpness Ug	.004	
Density range	2.8 - 3.2			Exposure time	45 Sec.	

**Equipment and Technique details - Technique "B"**

Source S/N	91010	Source to film	13	Screen size	.005 / .010	<p>Single Wall Exposure/Single Wall View</p>
Type / kV	Iridium 192	Object to film	.5	Film type	1	
Curies / mA	62	Material	C-Fe	Film make	Kodak	
Size	0.10	Pipe dia./Plate	26	Film speed	T	
IQI type	Hole	Thickness	.375	Film size	3.5 x 17	
IQI size	20-2T	Shim.	.125	Film per cassette	1	
IQI side	Source	Screen type	Lead	Total film	12	
Dev. time/temp	5 min/ 68 F			Unsharpness Ug	.006	
Density range	2.4 - 2.9			Exposure time	32 Sec.	

We, the undersigned, certify that the statements in this record are correct and that the welds and/or pieces were examined in accordance with the requirements of the above specified project specification and acceptance standard.

<b>NDE Technician</b>	Name Date Level	Signature
<b>Client</b>	Name Date	Signature
<b>Certifying Authority</b>	Name Date	Signature