



INSPECTION REPORT

Magnetic Particle Testing

Client:	HE Lancaster Pty. Ltd.	Test Date:	18 th May, 2016
Client Contact:	Mark Lancaster	Client Job No:	N/A
Location:	Redhead workshop	Purchase Order:	Nil supplied
Subject:	Inspection of BAJAKITS 2 x control arm assemblies	ISA Job No:	16264
Inspected by:	John Parker & Jamie Fibbens	ISA Report No:	16264-1
		Revision:	0
Reported by:	Jamie Fibbens	Date of Issue:	18 th May, 2016

SUMMARY:

As requested, a Magnetic Particle test was carried out on the following: -

- **BAJAKITS 2 x control arms (newly fabricated) – all welding tested**

The purpose of this inspection was to determine if welding complies with the requirements of AS 1554.1 SP category.



Photo 1 – Inspected components

Unit 1, 66A Kalaroo Road, REDHEAD NSW 2290
PO Box 436 Belmont NSW 2280

T: 02 49447798
F: 02 49447764
W: www.inspectionsolutions.com.au
E: admin@inspectionsolutions.com.au

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Job No:	16264	Client:	HE Lancaster Pty Ltd
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RESULTS:

Component Inspected	Areas Inspected	Findings
Control arm 1	100% welding	Nil recordable surface defects evident, welding complies with the requirements of AS1554.1 SP
Control arm 2	100% welding	Nil recordable surface defects evident, welding complies with the requirements of AS1554.1 SP



Photo 2 & 3 – Typical tested welding

In addition, ultrasonic thickness gauging revealed the SHS wall thickness to be in the order of 2.6 – 2.9mm.

TEST LIMITATIONS:

Equipment was inspected in assembled condition, all areas requiring magnetic particle inspection had coatings / contaminates removed prior to testing.

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TEST PARAMETERS:

Test Specification:	AS 1171 - 1998	Magnetising Unit:	E014 AC yoke magnet	
ISA Procedure:	ISA-LTP-01	Magnetisation Method:	Magnetic flow – AC yoke	
Product Specification:	Initial:	AS 1554.1 - 2014	Magnetism:	Sustained
	Final:	N/A	Ultraviolet Light Unit:	N/A
Material Specification:	C/steel – grade	Current:	Mains AC	
Weld Process:	TIG	Heat Treatment Condition:	Not specified	
Surface Preparation:	Paint locally removed	Pole Spacing:	75 – 300mm	
Surface Condition:	Bare steel surface	Particle Type:	Ardrox 800/3	
Flux Indicator Used:	Yes - ELY Type1	Background:	Ardrox 8901W	
Demagnetised Gauss Reading:	No	Light source:	White > 1000 Lux Natural & Artificial	

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Technician:	John Parker	Signature:		Qualifications:	AINDT Level 2 Cert.
Reviewed by:	Jamie Fibbens	Signature:		Qualifications:	AINDT Level 3 Cert.

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