

Customer: <b>Lodge Manufacturing</b>	Customer Job #: <b>PO 59077</b>	Date: <b>2/20/2014</b>
Job Location: <b>Chattanooga, TN</b>	ICS WO#: <b>140132</b>	Drawing Number: <b>N/A</b>
Inspection Procedure: <b>ICS QOP 9-PT-1</b>	Rev: <b>5</b>	Acceptance Standard: <b>None Specified - Record Data</b>

*Material/Lighting and Inspection Information Section*

Structure: <b>SS Pots 3.4 Qt and 1.9 Qt</b>	Material Type: <b>Stainless Steel</b>	Surface Conditions: <b>Final Brushed Surface</b>
Thickness: <b>Approx 1/16"</b>	Diameter: <b>N/A</b>	Length: <b>NA</b>

<i>Lighting Equipment</i>		<i>Lighting Type Section</i>	
<input checked="" type="checkbox"/> Portable	<input checked="" type="checkbox"/> Black	Pre-Intensity ( $\mu\text{W}/\text{cm}^2$ ): <b>&gt; 1000 <math>\mu\text{W}/\text{cm}^2</math></b>	Post-Intensity ( $\mu\text{W}/\text{cm}^2$ ): <b>&gt; 1000 <math>\mu\text{W}/\text{cm}^2</math></b>
<input checked="" type="checkbox"/> Fixed	<input type="checkbox"/> White	Pre-Intensity (Foot-Candles):	Post-Intensity (Foot-Candles):

Penetrant Type <input checked="" type="checkbox"/> Type I (Fluorescent) <input type="checkbox"/> Type II (Visible) Sensitivity Level: <b>3</b> (Type I only) Certification #: <b>11F017</b>	Removal Method <input checked="" type="checkbox"/> Method A (Water Washable) <input type="checkbox"/> Method B (Post-Emulsifiable Lipophilic) <input type="checkbox"/> Method C (Solvent Removable) <input type="checkbox"/> Method D (Post-Emulsifiable Hydrophilic) Certification #:	Developer Type <input type="checkbox"/> Form a (Dry Powder) <input type="checkbox"/> Form b (Water Soluble) <input type="checkbox"/> Form c (Water Suspendable) <input type="checkbox"/> Form d (Nonaqueous) Certification #: <b>Not Used</b>	Light Meter Model: <b>Spectroline</b> Serial: <b>1519510 and 1519511</b> Cal Date: <b>3/20/2013</b> Cal Due: <b>3/20/2014</b> <input type="checkbox"/> Verification on record
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Weld Identification or Part Number	Condition	Accept	Reject	Type of Discontinuity													Remarks	
				Crack	Lap	L.O.F.	Porosity	Seam	Slag	Undercut	Linear	Rounded	Aligned	Diameter	Length			
Pot SS 1.9 Qt	Brushed	Initial Inspection														1@1/2", 3@3/32", 2@1/16", 6@1/32"		
Pot SS 3.4 Qt	Brushed	Initial Inspection														See Note 2		
Pot SS 1.9 Qt	Brushed	Post Wash Inspection														1 @ 1/2", 2 @ 1/32" See Note 3		
Pot SS 3.4 Qt	Brushed	Post Wash Inspection														See Note 3		

Sketch/Drawing/Location of Discontinuity \_\_\_\_\_ Images Attached:  Yes  No

3 Photos Attached

- Note 1 Inspect per QOP 9-PT-1, except use no developer and do not post clean items. Document size and number of indications. Send items thru commercial dishwashing cycle and re-inspect inside surface with blacklight (do not pre-clean or use dye for this inspection) and again record size and number of indications observed.
- Note 2 Initial inspection revealed all samples have numerous small indications  $\leq$  to 1/64" in diameter. Major indications around rivet location would be normal for a lap joint.
- Note 3 Post wash inspection revealed some indications  $\leq$  to 1/64" still remain, but in small quantity. Major indications at all rivet locations and at burst in 1.9Qt still remain.

David W. Ivey ICS Technician (Print)	_____ ICS Technician (Sign)	III Level	_____ Customer Reviewer
ASNT 67926 Certification Number	_____ Authorized Inspector		





