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Document Title **REINFORCING PAD LEAK TEST**

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Responsible person(s) **Engineering Manager**

APPROVAL

NAME: _____ POSITION: _____

SIGN: _____ DATE: _____



REINFORCING PAD LEAK TEST

1 INTRODUCTION

- 1.1 This procedure describes the control methods for the leak testing of reinforcing pad attachment welds.
- 1.2 The Workshop Foreman shall be responsible to prepare and perform the test in accordance with this procedure.
- 1.3 The QC Inspector shall monitor the test and record the results.
- 1.4 The Engineering Manager is responsible for the implementation of this procedure.

2 REVISIONS

Rev.	Date	Nature of Changes	Approved By
0	15.9.23	Issued for use	HQA

3 PROCEDURE

- 3.1 The QC Inspector shall check and verify the identification marking on vessels and ensure the reinforcing pads to be inspected have identification.
- 3.2 Air will be used for the test.
- 3.3 The detecting Bubble Solution shall produce a film that does not break away from the area to be tested, and the bubbles formed shall not break rapidly due to air drying or low surface tension.
- 3.4 The surface of the part to be examined shall be between 5°C and 50°C.
- 3.5 Direct visual examination access should be approximately 600 mm, or less, from the test area and at an angle not less than 30 deg to the surface to be examined. The minimum light intensity at the test area shall be 1000 Lux.
- 3.6 The Air supply shall be connected at the reinforcing pad 6mm threaded vent hole.
- 3.7 The pressure shall be increased to 15psi and held for 15 minutes prior to inspection.
- 3.8 The bubble solution shall be applied to the surface to be tested by flowing, spraying, or brushing. The number of bubbles produced in the solution by application should be minimized to reduce the problem of masking bubbles caused by leakage.



- 3.9 If a leak is observed, the location of the leak(s) shall be marked. The component shall then be depressurized, and the leak repaired as required by the referencing Code Section. After repairs the it shall be retested in accordance with this Procedure.

4 FORMS

[Pressure Test Report](#)