

Inspection Procedure for Leak Testing

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APPROVED: _____

This procedure is a guideline for the inspection of _____
_____ testing method. This method is more common _____
_____ also pressure testing of repads. This may be acc _____
_____ applying pressure or vacuum across the item to be tes _____
_____ detecting solution on the low pressure side of the test ite _____

- Hazardous Energy Control Procedure
- Safe Work Permit
- National Board of Boiler and Pressure Vessel Inspectors
Board Inspection Code ANSBI-NB-23.
- API-510 Pressure Vessel Inspection Code, Latest Edition.
- American Society of Mechanical Engineers (ASME), Sect _____
- Process Safety Information for the equipment being inspe _____

Refer to proper MATERIAL SAFETY DATA SHEETS.

This procedure requires qualified craftsmen.

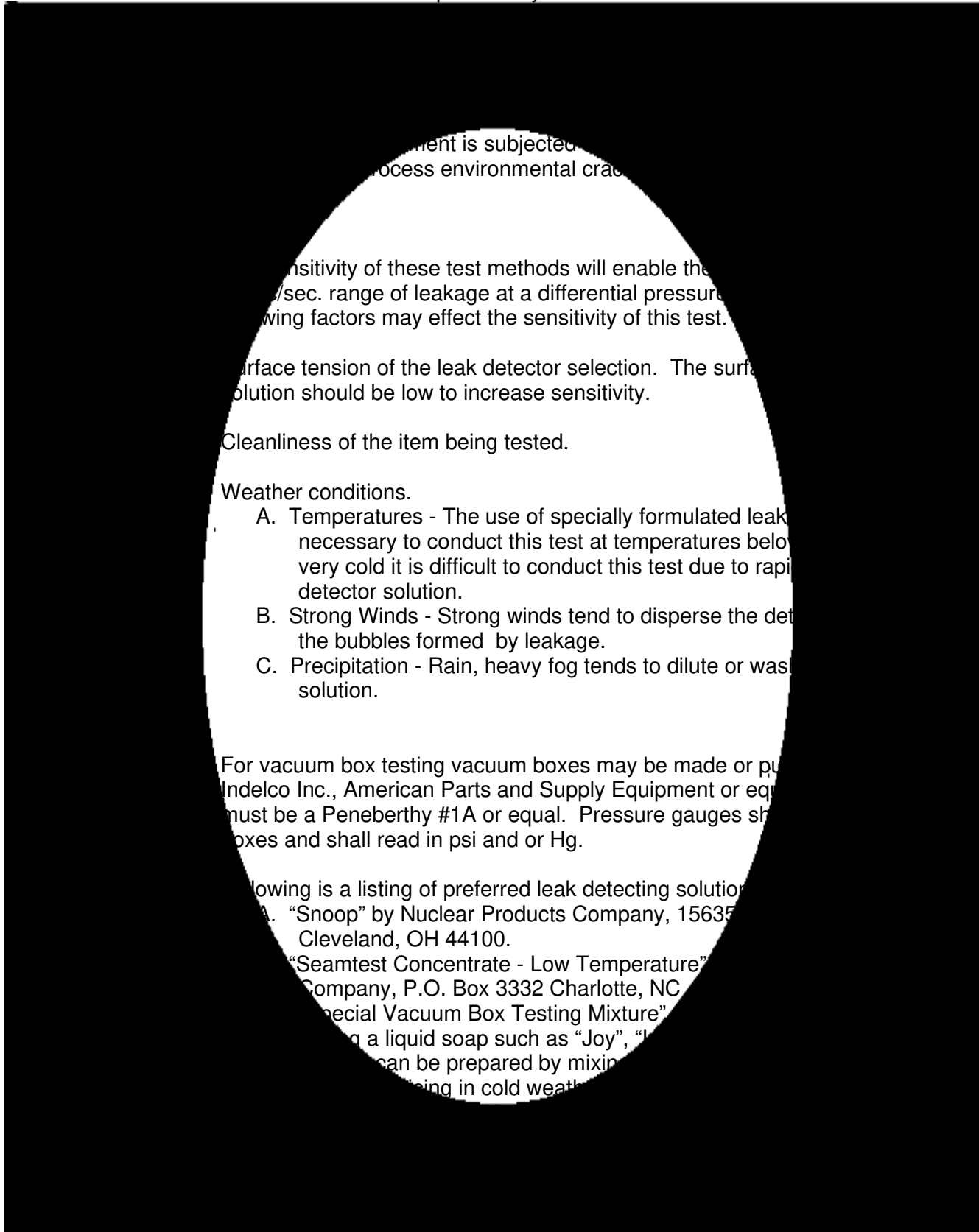
REVIEW this procedure to ENSURE all steps and cau _____
_____ hazards have been DEFINED. Match the proper _____
_____ DATA SHEETS with the equipment service.

Use special precautions defined on MATERIAL _____
_____ and verify operation of all safety showers and _____
_____ to ENSURE they are in good working orde _____

_____ proper steps to VERIFY that equip _____
_____ and CLEAR of hazardous materi _____

_____ tive equi _____

- Current mechanical design requirements
- Inspection frequency table
- Previous repair history



...ment is subjected to process environmental cracks

...sensitivity of these test methods will enable the
 .../sec. range of leakage at a differential pressure
 ...following factors may effect the sensitivity of this test.

...surface tension of the leak detector selection. The surf
 ...solution should be low to increase sensitivity.

Cleanliness of the item being tested.

Weather conditions.

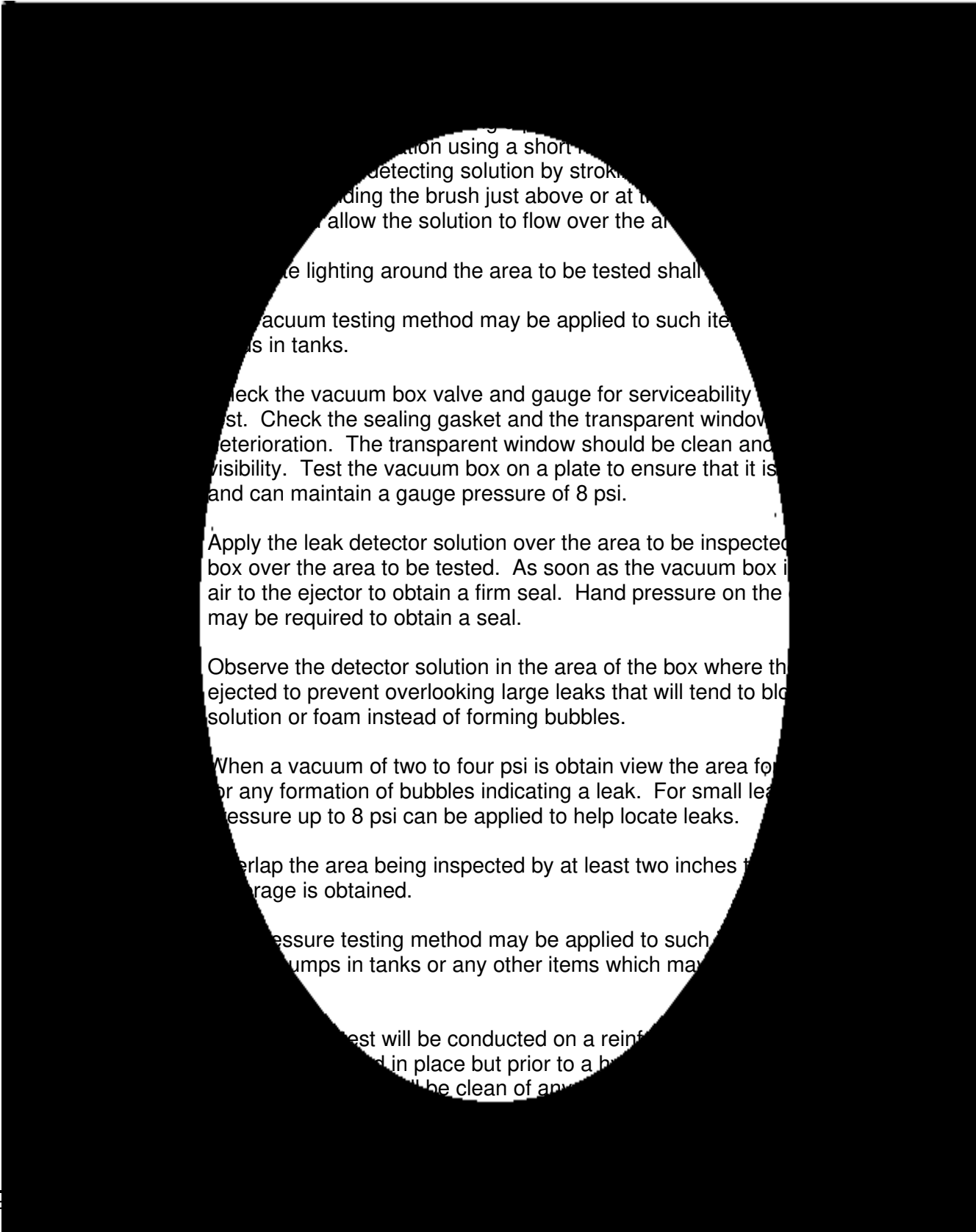
- A. Temperatures - The use of specially formulated leak
 necessary to conduct this test at temperatures below
 very cold it is difficult to conduct this test due to rapi
 detector solution.
- B. Strong Winds - Strong winds tend to disperse the det
 the bubbles formed by leakage.
- C. Precipitation - Rain, heavy fog tends to dilute or was
 solution.

For vacuum box testing vacuum boxes may be made or pu
 Indelco Inc., American Parts and Supply Equipment or equ
 must be a Peneberthy #1A or equal. Pressure gauges sh
 boxes and shall read in psi and or Hg.

Following is a listing of preferred leak detecting solution

- A. "Snoop" by Nuclear Products Company, 15635
 Cleveland, OH 44100.
- "Seamtest Concentrate - Low Temperature"
 Company, P.O. Box 3332 Charlotte, NC
- "Special Vacuum Box Testing Mixture"
 ...ing a liquid soap such as "Joy", "I
 ...can be prepared by mixing
 ...being in cold weath

solution should be prepared in advance to allow the bubbles to settle before use.



All opening in the test boundary should be completely blanked or sealed off.
The test boundary is then pressurized to the specified test pressure.

...for solution to the a...
Observe this area for a mi...

...y repairs are made, the repaired area will be...
...d as the first inspection.

...eport should be made which includes but is not limited...

Equipment Number
Area tested (i.e. floor, corner weld, repad on six inch...
Results of the test
Person conducting the test.

END