SITE survey. APP

SITE SURVEY REPORT

Welding Inspection

Prepared for	Ashbourne Developments Ltd
Date	18 Sep 2026
Site	Longton Works, Stoke-on-Trent
Prepared by	G. Hargreaves

FORM

Welding Inspection

1. Record details and scope

Project	Longton Works, Stoke-on-Trent: mezzanine frame welding inspection
Client or organisation	Ashbourne Developments Ltd
Site or premises address	Unit 3, Longton Works, Stoke-on-Trent ST3
Record date	18 Sep 2026
Person completing the record	G. Hargreaves

> For competent welding inspection. This is not a welder qualification, approved welding procedure, NDT report or automatic acceptance of a welded joint.

2. Job and procedure

Job, assembly and drawing revision	Job TS-2291, mezzanine frame beam-to-column assemblies, drawing TS-2291-GA-03 rev C
Welding procedure specification and revision	WPS-TS-014 rev 2, MAG fillet welds
Welder ID and qualification reference	Welder W-07, qualification ref WQ-W07-2025
Inspector and competence reference	G. Hargreaves, welding inspector, competence ref WI-GH-2024
Inspection plan and acceptance standard with edition	Inspection and test plan ITP-TS-2291 rev A, acceptance criteria and edition as set in project specification PS-2291 section 6

3. Joint inspection

Weld joint 1: J-01, beam B1 end plate fillet weld

Joint or weld ID	J-01, beam B1 end plate fillet weld
Material and consumable traceability references	Plate heat H-55102, wire batch WB-0811
Preparation, fit-up and pre-weld checks	Fit-up gap under 1 mm, surfaces clean and dry
In-process observations and specified parameter evidence	Current and voltage within the WPS range, run sheet RS-0917
Post-weld visual findings and dimensions	8 mm leg fillet all round, measured 8 to 9 mm with a gauge. No cracks or undercut seen.

Specified weld size (mm)	8.0
Smallest measured weld size (mm)	8.0
Measured against specified size	Meets the size
Surface defects seen	None seen
Result	Meets recorded visual criteria
Separate NDT method and report reference	No NDT required for J-01 under the ITP

Supporting photos



Weld joint 2: J-04, beam B2 end plate fillet weld

Joint or weld ID	J-04, beam B2 end plate fillet weld
Material and consumable traceability references	Plate heat H-55102, wire batch WB-0811
Preparation, fit-up and pre-weld checks	Fit-up gap up to 2 mm on the top flange
In-process observations and specified parameter evidence	Run sheet RS-0917 shows travel speed higher than the other joints
Post-weld visual findings and dimensions	Undercut about 1 mm deep over 30 mm at the toe on the top flange. Leg 7 mm at the start against 8 mm required.
Specified weld size (mm)	8.0
Smallest measured weld size (mm)	7.0
Measured against specified size	Undersize
Undersize by (mm)	1.0
Surface defects seen	Undercut

Result	Repair or review required
Separate NDT method and report reference	MT after repair, report MT-2291-04 to follow

Supporting photos



Weld joint 3: J-07, column C3 cap plate fillet weld

Joint or weld ID	J-07, column C3 cap plate fillet weld
Material and consumable traceability references	Plate heat H-55140, wire batch WB-0811
Preparation, fit-up and pre-weld checks	Fit-up tight, surfaces clean
Post-weld visual findings and dimensions	Even profile, 6 mm leg as required. Light spatter on the plate, removed.
Specified weld size (mm)	6.0
Smallest measured weld size (mm)	6.0
Measured against specified size	Meets the size
Surface defects seen	Spatter
Result	Meets recorded visual criteria

Weld joint 4: J-09, column C4 base plate fillet weld

Joint or weld ID	J-09, column C4 base plate fillet weld
Material and consumable traceability references	Plate heat H-55140, wire batch WB-0811
Preparation, fit-up and pre-weld checks	Fit-up tight, surfaces clean and dry

In-process observations and specified parameter evidence	Run sheet RS-0917, parameters within the WPS range
Post-weld visual findings and dimensions	8 mm leg all round, measured 8 mm with a gauge. Two surface pores about 1 mm across at the stop end on the north side.
Specified weld size (mm)	8.0
Smallest measured weld size (mm)	8.0
Measured against specified size	Meets the size
Surface defects seen	Porosity
Result	Repair or review required
Separate NDT method and report reference	Repair and visual reinspection under RI-2291-02
Joints inspected	4
Meet the visual criteria	2
Repair or review	2
Not fully inspected	0
Undersize welds	1

Joints with each defect type

Cracks	0
Undercut	1
Porosity	1
Lack of fusion	0
Overlap, spatter or uneven profile	1

Joints need repair or review. Do not accept them until the repair is reinspected and any NDT is reported.

4. Repair and closure

Approved repair instruction and affected weld IDs	Repair instruction RI-2291-01: grind out the undercut on J-04 and add a run to bring the leg to 8 mm. RI-2291-02: grind out the two pores on J-09 and reweld the stop end. Welder W-07 to WPS-TS-014.
Reinspection and NDT report references	J-04 to be reinspected visually and by MT after repair, reports VI-2291-04R and MT-2291-04
Authorised acceptance reference and limitations	J-01 and J-07 visually accepted by G. Hargreaves, ref VI-2291-01. J-04 and J-09 open.

5. Actions and review

Are further actions required?	Yes

Further action 1: Repair J-04 to RI-2291-01.

Action and evidence reference	Repair J-04 to RI-2291-01.
Person responsible	Welder W-07
Target date	22 Sep 2026
Action status	Completed
Completion evidence	Repair welded 21 September, reinspected visually and found to meet the recorded criteria, VI-2291-04R.

Further action 2: Arrange MT on J-04 after repair and file report MT-2291-04.

Action and evidence reference	Arrange MT on J-04 after repair and file report MT-2291-04.
Person responsible	G. Hargreaves
Target date	25 Sep 2026
Action status	Open

Further action 3: Repair J-09 to RI-2291-02 and reinspect visually.

Action and evidence reference	Repair J-09 to RI-2291-02 and reinspect visually.
Person responsible	Welder W-07
Target date	22 Sep 2026
Action status	In progress
Outstanding limitations and information to pass on	J-04 not accepted until the MT report is received. J-09 awaiting repair and reinspection.
Record status	Further work needed
Reviewed by	R. Salt, quality manager
Review date	21 Sep 2026
Author signature	G. Hargreaves

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