



AVEZAAT

CRANES



Repair / Inspection report

Order no.: 212173
Client: Fontexx import/export
Crane: Jost JT 312
Serial no.: 018



STRENGTH IN COLLABORATION

Repair / Inspection report

Order no.: 212173
Date of repair: 3 – 11 May 2021
Place of repair: Bergeijk
Client: Fontexx import/export
Order no. Client:
Crane: Jost JT 312
Serial no.: 018
Specification: ANSI / AWS D14.1 2005
ASME V, VIII 2007
EN ISO 5817 2014
EN ISO 17637 2017
EN ISO 3834-2 2005

Avezaat Cranes has repaired and inspected the 11x inserts of a Jost JT 312 tower crane and has established that the repair has been carried out in accordance with the requirements of the specifications mentioned above.

The findings of the examination are contained in this report and the appendices.

Inspector Schiedam 10/6/2021



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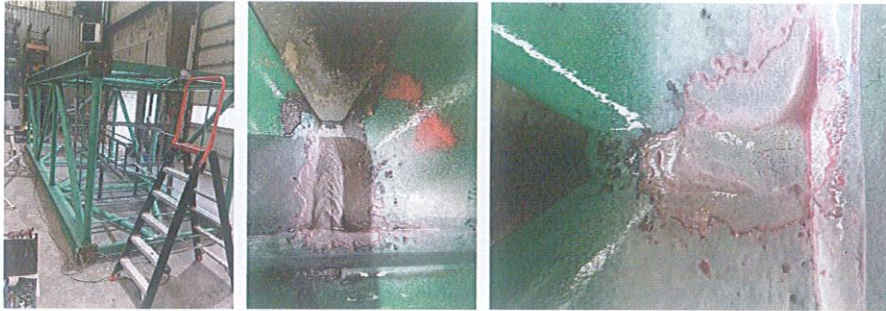


1. General

On the request of Fontexx import/export, Avezaat Cranes has repaired and inspected the 11 inserts of a Jost JT 312 tower crane.

2. Extent and nature

Upon inspection the following damages were found:
Several cracks.



3. Work description

In order to repair the damages the following steps were taken:

- Grind out the cracks and check by MPI method if cracks are completely removed.
- Prepare groove for welding.
- Weld the cracks.
- Check the new welds by MPI method for cracks and/or indications.

4. Procedure

4.1. Material

4.1.1 Material

No new material has been used.

4.2. Welding

Welding was performed according to the WPS AVE03-135. As required by this WPS, ER70S welding wire has been used as weld material for the welds. The requirements of ANSI / AWS D14.1, par. 8.4 and EN ISO 3834-2 were met.

4.3. Supervision during the repair work

The repair work was carried out under supervision of an Avezaat Inspector. The welding was done by qualified welders. The requirements of ANSI / AWS D14.1, par.8.4 and EN ISO 3834-2 were met.

5. Non-destructive examination

5.1. Visual examination

The welding was visually examined and in accordance with EN ISO 17637:2017. At the time of inspection no relevant indications were observed. The results of this examination met the requirements of the mentioned specification.

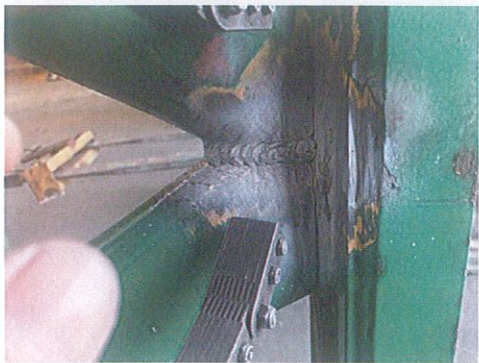
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5.2. MPI examination

MPI examination has been performed using the MPI test method in accordance with EN ISO 17638. At the time of inspection no relevant indications were observed. The results of this examination met the requirements of EN ISO 23278, level 1.

5.3. Dimension examination

All relevant dimensions were checked and found to be within the tolerance in accordance with EN ISO 13920 class BF. The dimensions found are such that the repaired parts can be mounted on the original equipment, if applicable.



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