

PHOTO REPORT

Messr.

Date : 4th Oct 2017
Location : Singapore
Job No. : 2990

No.	Description	Pg1
	Subject : Partial Repair of 20ft Flat racks (for Lashing Gear Bin) x 2 unit	
	(1) Flat Rack - NUK1168	
	<div style="display: flex; justify-content: space-around;">   </div> <p style="text-align: center;">Install stiffening brackets onto flat rack to prevent deformation during hot works.</p> <div style="display: flex; justify-content: space-around;">   </div> <p style="text-align: center;">Proceed gas cut to remove partial joints of main frame connecting corner casting vertical legs</p>	

No.	Description	Pg2
		
		
<p>New material fabricated as per marking and fitted in positions, alignment checked & proceed full welding</p>		
		

No.	Description	Pg3
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Re-adjusted & aligned corner casting vertical legs to main frame of flat rack

No.	Description	Pg4
(2) Flat Rack - NUK1169		<p>Same repair methodology applied to flat rack NUK 1169.</p> <p>Deformed sections of main frame were partially renewed.</p> <p>Corner casting legs were adjusted & aligned back to straight positions.</p>

No.	Description	Pg5
		<p>← Deformed parts on main frame of flat rack were straightened by fairing.</p> <p>Misaligned parts on main frame of flat rack were cropped off re-adjusted and fully welded.</p> <p>↓</p>
		<p>↑ Bottom bracket of transverse forklift pocket's beam were cropped, fabricated as per origin and welded back in position.</p>
 <p>Cropped deformed bottom bracket of transverse forklift pocket's beam.</p>		

No.	Description	Pg6
		<p>Repaired flat racks were tried fitted with twistlocks storage bin to ensure functionality, & NDT dye penetrant test were carried out on weldment to ensure no defects.</p>
		
		

No.	Description	Pg7
		
		
		
<p>NDT Dye Penetrant Tests resulted good, no defects were found on weldment</p>		

No.	Description	Pg8
		
		
		<p>Renewed sections of flat racks were surfaces prepared and cold galvanise sprayed.</p>