

	AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED Lifting Inspection	Doc No: QC-LIF-P-018
		Level: 3
		Page 1 of 4
Title: Inspection Procedure of Pad Eyes		Rev: 2
Established By: Ashraf Elsaid	Position: Lifting Supervisor	Date: JULY-2022
Approved By: Ahmed Mohamed	Position: Operation Manager	

Inspection Procedure of Pad Eyes

	AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED Lifting Inspection	Doc No: QC-LIF-P-018
		Level: 3
		Page 2 of 4
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Contents	Page
1 YOUR SAFETY IS FIRST	3
2 SCOPE	3
3 REFERENCE STANDARDS	3
4 DEFINITION OF PAD EYES	3
5 THOROUGH EXAMINATION.....	3
6 PROOF LOAD TEST	4
7 REPORTING AND CERTIFICATION	4

	AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED Lifting Inspection	Doc No: QC-LIF-P-018
		Level: 3
		Page 3 of 4
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1. YOUR SAFETY IS FIRST:

Your safety wear is mandatory at job sites including in general: suit, shoes, helmet, gloves, ear plugs, glasses, and mask.

2. SCOPE:

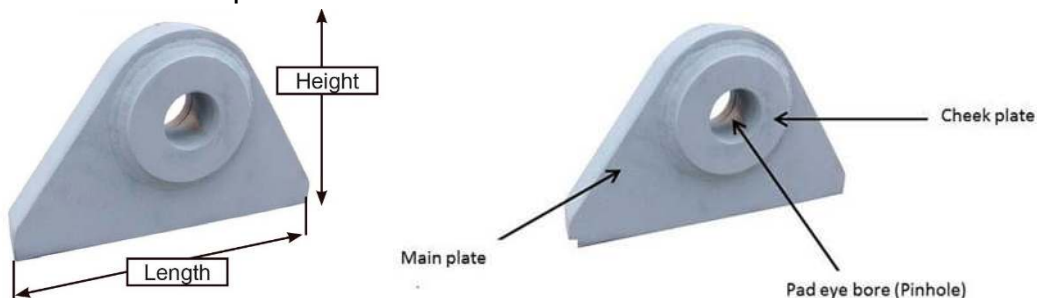
This Procedure describes the inspection and testing of Pad Eyes:

3. PRODUCT/ MANUFACTURE STANDARDS:

BS EN 13001-3-1:2012+A2:2018	<i>Cranes – General design - Part 3-1 Limit States and proof competence of steel structure</i>
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4. DEFINITION OF PAD EYES:

Pad eyes are lifting points mounted on loads. Pad eyes are made of steel plates with radius at one side. The basic purpose of a pad-eye is to provide a point to which a rope or wire can be fastened, directly or through a shackle. Pad eyes can be designed with or without a cheek plate on either side of the pinhole.



5. THOROUGH EXAMINATION:

Pad eyes shall be thoroughly examined at intervals not exceeding **twelve months**.

Pad eyes surfaces shall be pre-cleaned cleaned: all signs of dirt, paint, scale, and any other contaminates shall be removed from surface.

Marking shall be checked: marking shall be eligible and clearly visible, marking contains WLL of the pad eye, and Identification mark, where marking have become illegible, it shall be re-stamped on an area not affecting the strength of the pad eye with the following information: ID Number, WLL, and date of test.

The pad eye shall be checked for the following:

- Dimensions: the following dimensions shall be checked against manufacturer's design:
 - ✓ Wall thickness
 - ✓ Length
 - ✓ Height
 - ✓ Pinhole diameter
- Pad eyes shall not be distorted or elongated.

	AI TAKAMUL COMPANY FOR ENGINEERING TESTS AND PROFESSIONAL SAFETY LIMITED Lifting Inspection	Doc No: QC-LIF-P-018
		Level: 3
		Page 4 of 4
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- Pad eyes shall be free on wear, cracks, nicks, gouges, and any other defect that may affect strength
- Welds: all welds and adjacent areas (HAZ) shall be checked for defects, this is done by:
 - ✓ visual inspection of weld profile as per (**ATS-NDT-P-004 Visual testing of Welds**),
 - ✓ magnetic particles inspection as per (**ATS-NDT-P-001 Magnetic Particles Inspection**),
 - ✓ and – when the competent person has reason to doubt the integrity of pad eye – by ultrasonic testing as per (**ATS-NDT-P-003-1 Ultrasonic Testing acc. to AWS D1.1**).
- Supporting structure: the supporting structure on which the pad eye is welded shall be checked for damage, distortion, and any signs of overloading

6. PROOF LOAD TEST:

Pad eyes shall be proof load tested before being put into use for the first time, or after any major alteration or repair.

Pad eyes are first pre-test examined, if no faults are found which could affect the WLL of the pad eye, then the proof load test may be applied, as follows:

A proof load of $2 \times \text{WLL}$ of the pad eye is applied. This load shall be applied in the same direction of which the pad eye is loaded during service. The load is applied on the pad eye for a period of five minutes. After releasing of the load, the pad eye is thoroughly examined as per 5. THOROUGH EXAMINATION, the pad eye shall withstand the load without any deformation or signs of cracking.

7. REPORTING AND CERTIFICATION:

A certificate of test and thorough examination will be issued upon the satisfactory completion of the examination, i.e. the lifting equipment is safe to operate

A defect report will be issued if the lifting equipment fails to meet the requirements.