



WHAT IS A WORK INSTRUCTION

A work instruction (WI) is a document that is used to clearly define the inspection variables for a given inspection. It is designed to be used in conjunction with a procedure or standard.

A work instruction is normally issued for the following reasons:

- 1) To ensure that a particular task is carried out to specific requirements to improve reproducibility and reliability.

Example: If 100 items of a given component need to be tested over a period of time by numerous technicians. A WI will ensure that all technicians are using the same technique / process.

- 2) To be issued to Level 1 Technicians.

As per AS3998/ISO9712 Level 1 technicians shall not be responsible for selecting method or technique.

A Work Instruction is essentially most of the technique areas normally recorded on a record of test, pre-nominated by a Level 2 or Level 3.

Any example of some of the variables to be specified for a given Magnetic Particle Inspection could be:

Scope:	Material:	Process:	Contrast Media:	Limitations:
Safety:	Area of Examination:	Current:	White Light:	Demagnetisation:
Test Procedure:	Surface Condition:	Technique:	Black Light (UV):	Post Cleaning:
Method Code:	Pre Cleaning Process:	Field Application Time:	Eye Adaption:	Reporting:
Acceptance Criteria:	Magnetising Force:	Magnetic Media:	System Performance Test:	Qualifications:

Any example of some of the variables to be specified for a given Liquid Penetrant Inspection could be:

Scope:	Area of Examination:	Part Temperature:	Penetrant Dwell Time:	Limitations:
Safety:	Surface Condition:	Drying Temperature:	Drying Time:	Post Cleaning:
Test Procedure:	Pre Cleaning Process:	Penetrant Application Method:	Developer Dwell Times:	Reporting:
Method Code:	Penetrant Media:	Penetrant Removal Method:	Black Light (UV):	Qualifications:
Acceptance Criteria:	Remover Media:	Drying Method:	Eye Adaption:	
Material:	Developer Media:	Penetrant Application Method:	System Performance Test:	



Any example of some of the variables to be specified for a given Ultrasonic Weld Inspection could be:

Scope and Control	Test Equipment & Probes	Surface Condition	Scanning Sensitivity	Evaluation
Test Standard	Area of Inspection/Datum's	Scan Technique Parent	Evaluation Sensitivity	Reporting
Acceptance Standard	Couplant	Scan Technique Weld	Sizing Method/s	
Personnel Certification/Approval	Calibration	Scanning Positions	Post Cleaning	

Any example of some of the variables to be specified for a given Radiographic Weld Inspection could be:

Scope and control	Test Equipment	Placement of IQI	Back Scatter	Number of Exposures
Method Designation	Screens	Ug	Film Identification	Film Processing
Safety	IQI Type and Details	Density	SFD and Beam Alignment	Evaluation
Personnel Certification/Approval	Film Type & Size	Film Coverage	Exposure Details	Reporting

Any example of some of the variables to be specified for a given Eddy Current Inspection could be:

Scope	ET Unit Details	SNR Requirements	Surface Condition	Interpretation
Test Specimen	Calibration Pieces	Probe Frequency	Scanning Increments	Evaluation
Personnel	Probe Details	Unit Calibration	Scan Speed	Reporting
Referenced Docs	Unit Setup	Calibration Frequency		

Note: The above are examples only, additional attributes and variables may be required depending on the scope of work and method of test.