

**Major****Tool & Machine, Inc.**1458 E. 19th Street, Indianapolis, In 46218
TEL:(317)636-6433 FAX:(317)634-9420

Nondestructive Test Certification for Visual Inspection

Date of Inspection:03/21/2005**Type of Material:**316 SST CASTING**NDT#:**11885

Stage of Inspection: <input type="checkbox"/> Incoming Inspection <input type="checkbox"/> In-Process Inspection <input type="checkbox"/> After Repair <input checked="" type="checkbox"/> Final Inspection	Manufacturing Process: <input checked="" type="checkbox"/> Weldment <input type="checkbox"/> Casting <input type="checkbox"/> Bar Stock <input type="checkbox"/> Plate <input type="checkbox"/> Forging <input type="checkbox"/> Other	Surface Condition: <input type="checkbox"/> Machined <input checked="" type="checkbox"/> Rough <input type="checkbox"/> Other AS-WELDED	Test Being Run to: <input checked="" type="checkbox"/> Router Instructions <input checked="" type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card	Heat Treated: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
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Part Information: MTM Job Number: 65706/2.0 -Sub:18 -Op:30 Resource ID: 806-CWI Part ID: PQR 433 REV. 0 Part Name: Serial Number: N/A Customer P.O.: S005242-F Customer Unit/Plant: N/A	Test Results: Quantity Inspected: 1 Quantity Accepted: 1 Quantity Rejected: 0 Run Hours:	
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Customer Inspection Plan: N/A Test Step: N/A Revision: N/A Material Test Number: N/A	Inspection Criteria: Customer Specification: MIL-STD-271 MTM Spec Number: NDT-WI-011 Acceptance Standard: SEE NOTES
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Inspection Methods Used: Magnification Used: NONE Light Source Used: MAGLIGHT S/N FL-2	
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Pre-Weld Inspection	Acc	Rej	N/A	In-Process Inspection	Acc	Rej	N/A	Post-Weld Inspection	Acc	Rej	N/A
Base Material Certs:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Preheat/Interpass Temp:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Welds Properly Completed:	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Filler Material Certs:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Proper Filler Material/Flux:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Weld Surfaces:	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
PQR/WPS:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Shielding Gas/Back Purge:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Weld Dimensions:	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
WPQ:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Welder Conforming to WPS:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Weld Contours:	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Joint Preparation:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Root Pass:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Post-Weld Cleaning:	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Fit-up:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Fill Pass:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Distortion of Part:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
Pre-Weld Cleaning:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Cover Pass:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>				
Equip Condition/Calibr:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>	Interpass Cleaning:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>				
				Distortion of Part:	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>				

Inspection Requirements:

% of all accessible surfaces ☐ Joint Preps ☐ Root Pass ☐ Back Gouge ☒ Cover Pass ☐ Other
VISUALLY INSPECT COMPLETED WELD..

Notes:

ACCEPTANCE PER:

* AWS B2.1

* ASME IX

* PQR433Rev0

* Process: GTAW

* Welder Name: Jason Bever

* Welder Clock Number: 465

* Base Material Specification: CF8MNMnMOD

* Base Material Thickness: 1.5"

* Filler Material: ER316MnnF

* Position: Flat

* PWHT: Without

This is to certify that the pieces specified have been inspected in accordance with the specifications shown.

Inspector: 581-D.EDWARDS

Date: 03/21/2005