

**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:**08/01/2005**Type of Material:**CF8MNMNMOD**NDT#:**13218

<b>Stage of Inspection:</b> <input type="checkbox"/> Incoming Inspection <input type="checkbox"/> In-Process Inspection <input type="checkbox"/> After Repair <input checked="" type="checkbox"/> Final Inspection	<b>Manufacturing Process:</b> <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	<b>Surface Condition:</b> <input type="checkbox"/> Machined <input checked="" type="checkbox"/> Rough <input type="checkbox"/> Other AS WELDED	<b>Test Being Run to:</b> <input checked="" type="checkbox"/> Router Instructions <input checked="" type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card	<b>Heat Treated:</b> <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
--	--	--	--	--

<b>Part Information:</b> MTM Job Number: 65706/2.0 -Sub:28 -Op:40 Resource ID: 806-CWI Part ID: PQR437-REV 0 Part Name: Serial Number: N/A Customer P.O.: S005242-F Customer Unit/Plant: N/A	<b>Test Results:</b> Quantity Inspected: 1 Quantity Accepted: 1 Quantity Rejected: 0  Run Hours:
---	---

Customer Inspection Plan: N/A Test Step: N/A Revision: N/A Material Test Number: N/A	<b>Inspection Criteria:</b> Customer Specification: MIL-STD-271 MTM Spec Number: NDT-WI-011 Acceptance Standard: SEE NOTES
---	---

<b>Inspection Methods Used:</b> Magnification Used: NONE Light Source Used: MAGLIGHT S/N FL-2
---

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

TEST INFO:

\* PQR437-Rev0

\* Process: GTAW

\* Welders Names: Jason Bever #465 &amp; John Spencer #352

\* 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:** 08/01/2005

*Don D. Edwards*  
  
/NDT:All /Dat:All /WO:65706 /Lot:2 /Spl:0 /Sub:28 /Op:40  
User ID: MAYNE# Date: 08/22/05

