

# TEAM COOPERHEAT-MQS, INC.

## CERTIFIED RADIOGRAPHIC INSPECTION REPORT

FORM 6061-RT- 002 Rev.2

5512 W. State St. Milwaukee, WI 53208 Tel:(414)771-3060 Fax:(414)771-9481 (800)818-6403 www.cooperheat-mqs.com

CUSTOMER

NAME METAL TEK INTERNATIONAL  
 ADDRESS 8600 COMMERCIAL BLVD  
 CITY PEVELY STATE MO ZIP 63070

DATE

4/10/2006

WORK ORDER NO.

361-03104

P.O. NUMBER

23525

XRAY

X

GAMMA

PROCEDURE SPECIFICATION  
 ASTM E94-93

ACCEPTANCE CRITERIA  
 MSS-SP-54-1999

SHEET        OF       

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accept- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWF-B 3	1-2	✓							2				
	2-3	✓							1-2				
E.I.O. C040851	3-4	✓											
	4-5	✓							1				
M183500	5-6	✓											
	6-7	✓											
Z103989	7-8	✓							2				
	8-9	✓							1-2				
	9-10	✓							1				
	10-11	✓							1				
	11-12	✓											
	12-13	✓											
	13-14	✓											
	14-15	✓											
	15-16	✓											
	16-17			R					R				
	17-18			R					3-4 R				
	18-19	✓											
	19-20	✓											
	20-21			R					5				
	21-22			R					4				
	22-23	✓											
	23-24	✓											
	24-25	✓							1				
	25-26	✓											

NO. ACCEPTED

0

NO. REJECTED

1

COMMENTS

MQS TECH. NO. 13205

SHT.

REV. 1

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NOT LEVEL (RT)

John Petroske RT II Exp. 01/08

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			Accep- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Under Tears	Sur- face		
MCWF-B 3	26-27	✓											
	27-28	✓											
E.I.O. C040851	28-29				R				4				
	29-1	✓							2				
M183500	30-31	✓											
	31-32	✓											
Z103989	V33	✓											
	34-35	✓											
	35-36	✓											
	36-37	✓											
	V38	✓											
	39-40	✓											
	40-41	✓											
	42-43	✓											
	43-44	✓							2				
	V45	✓											
	46-47	✓											
	47-48	✓											
	48-49	✓											
	49-50	✓											
	V51	✓											
	V51A	✓											
	52-53	✓											
	53-54	✓											
	54-55	✓											

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COMMENTS

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### DATE

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### WORK ORDER NO.

361-03104

### P.O. NUMBER

23525

XRAY X

GAMMA

PROCEDURE SPECIFICATION  
 ASTM E94-93

ACCEPTANCE CRITERIA  
 MSS-SP-54-1999

SHEET \_\_\_\_\_ OF \_\_\_\_\_

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accept- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWF-B 3		55-56	✓										
		56-57	✓										
E.I.O. C040851		58-59	✓										
		59-60	✓										
M183500		60-61			R						R		
		61-62	✓										
Z103989		62-63	✓						2-3	2			
		64	✓										
		63-65			R				4				
		65-66			R	3-4				4			
		66-67			R					4			✓
		67-68	✓										
		69	✓										
		70-71	✓										
		71-72	✓										
		73-74			R						R		
		74-75			R					3-4			
		75-76	✓										
		77-78			R	4							
		78-79	✓										
		80-81			R				4		X RBK		
		81-82	✓								2-3		
		82-83	✓								2		
		84-85			R				5		4		
		85-86			R				5		4		

NO. ACCEPTED

4

NO. REJECTED

1

MQS TECH. NO.

13205

SHT.

REV. 1

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NDT LEVEL (RT)

John Petroske RT II Exp. 01/08

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		4/10/2006	361-03104
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		23525	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET ____ OF ____	

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accept- table	Reje- Inclu- cted sion	or Por- Slag osity	Lack of Fusion Gas Cracks	Hot Under Tears cut	Sur- face					
MCWF-B-3	86-87	✓						1					
	87-88	✓		R			X-RAY	4					
E.I.O. C040851	88-89	✓					1						
	89-90	✓		R			5						
M183500	90-91	✓					1						
	91-92	✓											
Z103989	93-94	✓											
	94-95	✓							2				
	96-97	✓											
	97-98	✓											
	98-99	✓											
	99-100	✓											
	101-102	✓											
	102-103	✓											
	103-104	✓											
	104-105	✓											
	106-107	✓											
	107-108	✓			2								
	108-109	✓											
	109-110			R						R			
	110-111	✓											
	111-112			R						R			
	112-113	✓											
	113A-114	✓											
	115-116			R				5	4	R			

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV. 1
0	1	13205		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		CERTIFIED NOT LEVEL (RT)		
		John Petroske RT II Exp. 01/08		

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		4/10/2006	361-03104
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER 23525	XRAY X
CITY PEVELY STATE MO ZIP 63070			GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET ____ OF ____	

[illegible]

NO. ACCEPTED	2	NO. REJECTED	1	MQS TECH. NO.	13205	SHT.	REV. 1
COMMENTS				CUST. RSS NO.		SHT.	REV.
				REVIEWER	<i>John Petroske</i>		
				CERTIFIED NDT LEVEL (RT)			
				John Petroske RT II Exp. 01/08			

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### CUSTOMER

NAME METAL TEK INTERNATIONAL  
 ADDRESS 8600 COMMERCIAL BLVD  
 CITY PEVELY STATE MO ZIP 63070

DATE 4/24/2006

WORK ORDER NO.  
361-03154

P.O. NUMBER

XRAY X

GAMMA

PROCEDURE SPECIFICATION  
ASTM E94-93

ACCEPTANCE CRITERIA  
MSS-SP-54-1999

SHEET \_\_\_\_ OF \_\_\_\_

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	or Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Under Tears cut	Sur- face	
MCWF-B3	R1	16-17	✓										
		17-18	✓										
E.I.O. C040851		20-21	✓										
		21-22	✓										
M183500		28-29	✓										
		60-61	✓										
Z103989		63-65	✓							2			
		65-66	✓							2-3			
		66-67	✓		2					2			
		73-74	✓		2					2			
		74-75	✓										
		77-78	✓										
		80-81	✓										
		84-85	✓										
		85-86	✓							2			
		87-88	✓							1	1-2		
		89-90	✓							1			
		109-110	✓										
		111-112	✓		R			R	R				
		115-116	✓										
		117-118	✓										

NO. ACCEPTED

Φ

NO. REJECTED 1

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COMMENTS

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CERTIFIED NDT LEVEL (RT)

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# RADIOGRAPHIC INTERPRETATION REPORT

FORM CC034



# RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>E.I.O.</u>	Pattern Number <u>MCWFB-3</u>
Material <u>CF8MNMN MOD</u>	Traceability Number
Film Manufacturer <u>FUJI</u>	Source Number <u>C060 21.2 CJ</u>
IQI LEVEL <u>2-2T</u> From CQP 401 <input checked="" type="checkbox"/> Other (Specify, E.G. 2-4T, 2-1T) <u>N/A</u>	

Exposures (views)	<u>111-112</u>	<u>111-112</u>										
Thickness (IN.)	<u>1 1/2-6"</u>	<u>→</u>										
S/F Distance (IN.)	<u>20"</u>	<u>→</u>										
Penetrameter	<u>30/60</u>	<u>→</u>										
Time (MIN.)	<u>24min</u>	<u>1hr 25min</u>										
Focal Spot (IN.)	<u>.1</u>	<u>→</u>										
Film Size (IN.)	<u>14X17</u>	<u>→</u>										
Screen Size (Pb)	<u>.01</u>	<u>→</u>										
Front/Back												
S.W.E./D.W.E.	<u>SWE</u>	<u>→</u>										
S.W.V./D.W.V.	<u>SWV</u>	<u>→</u>										
Film Type	<u>2980</u>	<u>80</u>										
Acceptance Standard	<u>E446</u>	<u>E280</u>										
Severity Level	<u>See Spec</u>											

Shooting Sketch (Use Additional Pages as Needed)

Accept to: MSS-SP-54-1999  
 Take 2 separate views for Density

Technique Prepared By: Ron Kelley Level: II Date: 5-9-06  
 Technique Approved By: \_\_\_\_\_ Level: \_\_\_\_\_ Date: \_\_\_\_\_