

# 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		DATE <u>5-10-06 AP</u> <u>4/08/2006</u>	WORK ORDER NO. 361-03154
NAME <u>METAL TEK INTERNATIONAL</u>		P.O. NUMBER 23525	XRAY X GAMMA
ADDRESS <u>8600 COMMERCIAL BLVD</u>			
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>			
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 Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	
MCWF-B5		1-2	✓										
		2-3	✓										
E.I.O. C040851		3-4	✓									✓	
		4-5	✓									✓	
M183520		5-6	✓									✓	
		6-7	✓										
Z103989		7-8	✓									✓	
		8-9	✓						1/2				
		9-10	✓						1				
		10-11	✓										
		11-12	✓						2				
		12-13	✓						2-3				
		13-14	✓										
		14-15			R						R		
		15-16	✓										
		16-17			R				4		R		✓
		17-18	✓										
		18-19	✓									✓	
		19-20	✓						2				
		20-21	✓									✓	
		21-22	✓										
		22-23	✓										
		23-24	✓									✓	
		24-25	✓										
		25-26	✓										

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	13205	SHT.	REV. 1
COMMENTS				CUST. RSS NO.		SHT.	REV.
				REVIEWER <u>John Petroske</u>			
				CERTIFIED NDT LEVEL (RT) John Petroske RT II Exp. 01/08			

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ADDRESS <u>8600 COMMERCIAL BLVD</u>			
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>			
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PART NUMBER	Serial No	View	No Apparent Indications		Incomplete Penetration			Shrinkage			Film Artifacts			REMARKS
			Accep- table	Reje- cted	Inclu- sion	Dross or Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWF-B5		26-27			R	4								
		27-28	✓											
E.I.O. C040851		28-29	✓											
		29-31	✓										✓	
M183520		30-31	✓											
		31-32	✓											
Z103989		33	✓											
		34-35			R						R			
		35-36	✓											
		36-37	✓											
		38	✓											
		39-40	✓											
		40-41	✓											
		42-43	✓											
		43-44	✓											
		45	✓											
		46-47	✓											
		47-48	✓											
		48-49	✓											
		49-50	✓											
		51	✓											
		51A	✓											
		52-53	✓											
		53-54	✓											
		54-55	✓											

NO. ACCEPTED <u>4</u>	NO. REJECTED <u>1</u>	MQS TECH. NO. 13205	SHT.	REV. 1
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER <u>John Petroske</u> CERTIFIED <u>NOT</u> LEVEL (RT) John Petroske RT II Exp. 01/08		

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ADDRESS <u>8600 COMMERCIAL BLVD</u>			
CITY <u>PEVELY</u>	STATE <u>MO</u> ZIP <u>63070</u>		
PROCEDURE SPECIFICATION ASTM E94-93		ACCEPTANCE CRITERIA MSS-SP-54-1999	
		SHEET <u>      </u> OF <u>      </u>	

PART NUMBER	Serial No	View	No Apparent Indications		Incomplete Penetration				Shrinkage			Film Artifacts			REMARKS
			Accept- table	Reje- cted	Inclu- sion	Dross or Por- osity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Sur- face				
MCWF-B5		3356	✓												
		5657	✓												
E.I.O. C040851		5859	✓												
		5960	✓					2							
M183520		6161			R						R				
		6162	✓									✓			
Z103989		6263	✓			2		2							
		6264	✓												
		6365	✓			2							✓		
		6566			R	4									
		6667			R	4-5				4					
		6768	✓			2		2							
		6869	✓												
		7071	✓											✓	
		7172	✓												
		7374	✓												
		7475	✓												
		7576	✓												
		7778	✓												
		7879	✓												
		8081	✓									✓			
		8182	✓									✓			
		8283			R					4					
		8485	✓												
		8586	✓							2					

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COMMENTS		CUST. RSS NO. <u>      </u>	SHT. <u>      </u>	REV. <u>      </u>
		REVIEWER <u>John Petroske</u>		
		CERTIFIED NOT LEVEL (RT) John Petroske RT II Exp. 01/08		

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NAME <u>METAL TEK INTERNATIONAL</u>		P.O. NUMBER 23525	XRAY <u>X</u> GAMMA
ADDRESS <u>8600 COMMERCIAL BLVD</u>			
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>			
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 Por- osity	Lack of Fusion	Gas	Cracks	Hot Under Tears cut	Sur- face		
MCWF-B5		86-87			R					4			
		87-88	✓							3			
E.I.O. C040851		88-89	✓										
		89-90	✓										
M183520		90-91	✓										
		91-92	✓									✓	
Z103989		93-94	✓										
		94-95	✓										
		96-97	✓										
		97-98	✓										
		98-99	✓										
		99-100	✓										
	101-	102	✓										
	102-	103	✓										
	103-	104	✓										
	104-	105	✓										
	106-	107	✓										
	107-	108	✓		2-3								
	108-	109	✓		1								
	109-	110	✓									✓	
	110-	111			R					4			
	111-	112			R					4			
	112-	113	✓										
	113-	114	✓										
	115-	116	✓							2			

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COMMENTS		CUST. RSS NO.		SHT.	REV.
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		CERTIFIED NDT LEVEL (RT)			
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CUSTOMER		DATE <u>5-10-06</u> <u>4/08/2006</u>	WORK ORDER NO. 361-03154
NAME <u>METAL TEK INTERNATIONAL</u>		P.O. NUMBER 23525	XRAY <u>X</u>
ADDRESS <u>8600 COMMERCIAL BLVD</u>			GAMMA
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>		SHEET _____ OF _____	
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999		

[illegible]

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

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		06/12/2006	361-03236
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070			GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET ____ OF ____	

[illegible]

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COMMENTS		CUST. RSS NO.		SHT.	REV.
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## RADIOGRAPHIC INTERPRETATION REPORT

FORM CC034



# RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>E.I.O</u>	Pattern Number <u>MCWFB-5</u>
Material <u>CF8MNMN MOD</u>	Traceability Number
Film Manufactuer <u>FUJI</u>	Source Number <u>C06 21 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>66-67</u>													
Thickness (IN.)	<u>1 1/2"</u>													
S/F Distance (IN.)	<u>20"</u>													
Penetrameter	<u>30/40</u>													
Time (MIN.)	<u>12min</u>													
Focal Spot (IN.)	<u>.1</u>													
Film Size (IN.)	<u>14X17</u>													
Screen Size (Pb)	<u>.01</u>													
Front/Back														
S.W.E./D.W.E.	<u>SWE</u>													
S.W.V./D.W.V.	<u>SWV</u>													
Film Type	<u>29/59</u>													
Acceptance Standard	<u>E446</u>													
Severity Level	<u>SEE SPEC</u>													

Shooting Sketch (Use Additional Pages as Needed)

Accept TO MSS-SF-54-1999

Technique Prepared By: Ron Kelley Level: II Date: 6-13-06  
 Technique Approved By: \_\_\_\_\_ Level: \_\_\_\_\_ Date: \_\_\_\_\_