

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	WORK ORDER NO.
NAME <u>METAL TEK INTERNATIONAL</u>		<u>5/17/2006</u>	<u>361-03170</u>
ADDRESS <u>8600 COMMERCIAL BLVD</u>		P.O. NUMBER	XRAY <u>X</u>
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>		<u>23525</u>	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET <u> </u> OF <u> </u>	
ASTM E94-93	MSS-SP-54-1999		

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	or Por- osity	Slag	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	
MCWF-B6		1-2	✓										
		2-3	✓									✓	
E.I.O. C040851		3-4	✓									✓	
		4-5	✓						2			✓	
M183530		5-6	✓						1-2			✓	
		6-7	✓										
Z103989		7-8	✓										
		8-9	✓										
		9-10	✓									✓	
		10-11	✓									✓	
		11-12			R	4			4				
		12-13			R	4			4				
		13-14			R	4			4				
		14-15			R	4			4				
		15-16			R	4							
		16-17	✓						2			✓	
		17-18	✓						2				
		18-19	✓						2				
		19-20	✓						2				
		20-21			R				4				
		21-22	✓						1-2				
		22-23	✓									✓	✓
		23-24	✓										
		24-25	✓										
		25-26	✓									✓	

NO. ACCEPTED	<u>4</u>	NO. REJECTED	<u>1</u>	MQS TECH. NO.	<u>13205</u>	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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NAME METAL TEK INTERNATIONAL
 ADDRESS 8600 COMMERCIAL BLVD
 CITY PEVELY STATE MO ZIP 63070

DATE

5/17/2006

WORK ORDER NO.

361-03170

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 or Por- osity			Incomplete Penetration			Shrinkage			Film Artifacts			REMARKS
			Accep- table	Reje- cted	Inclu- sion	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face							
MCWF-B6		26-27	✓															
		27-28	✓															
E.I.O. C040851		28-29	✓													✓		
		29-31	✓															
M183530		30-31	✓															
		31-32	✓															
Z103989		33	✓															
		34-35	✓															
		35-36	✓															
		36-37	✓															
		38	✓															
		39-40	✓			1												
		40-41	✓							1								
		42-43	✓															
		43-44	✓															
		45	✓															
		46-47	✓															
		47-48	✓															
		48-49	✓															
		49-50	✓															
		51	✓															
		51A	✓															
		52-53	✓															
		53-54	✓															
		54-55	✓															

NO. ACCEPTED 1

NO. REJECTED 0

MQS TECH. NO. 13205

SHT.

REV. 1

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REV.

REVIEWER John Petroske

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John Petroske RT II Exp. 01/08

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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 Tears	Under cut	
MCWF-B6		55-56	✓										
		56-57	✓										
E.I.O. C040851		58-59	✓		2-3					2-3			
		59-60		R						4			
M183530		60-61		R						4			
		61-62	✓							*			* See View
Z103989		62-63	✓		2-3								
		64-65	✓		3								
		65-66		R	4								
		66-67		R	4					4			
		67-68	✓		2								
		68-69	✓									✓	
		70-71	✓		2							✓	
		71-72	✓		2								
		72-73		R	5								
		73-74	✓										
		74-75	✓										
		75-76	✓										
		77-78		R	5					4			
		78-79		R	5								
		80-81	✓										
		81-82	✓									✓	
		82-83		R				5		4			
		83-84		R						5			
		84-85		R						4			
		85-86		R									

NO. ACCEPTED

0

NO. REJECTED

1

MQS TECH. NO.

13205

SHT.

REV. 1

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		5/17/2006	361-03170
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 or Por- osity		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Sur- face			
MCWF-B6		86-87			R					4			
		87-88			R					4			
E.I.O. C040851		88-89			R					3-4			
		89-90	✓										
M183530		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	✓									✓	
		108-109	✓										
		109-110	✓										
		110-111	✓										
		111-112			R					4			
		112-113	✓									✓	
		113A-114	✓									✓	
		115-116	✓										

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV. 1
4	1	13205		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		CERTIFIED NDT LEVEL (RT)		
		John Petroske RT II Exp. 01/08		

NO. ACCEPTED	NO. REJECTED	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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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		06/22/2006	361-03256
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 1 OF 1	

PART NUMBER	Serial No	View	No Apparent Indications		Dross or Por- osity		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Sur- face			
MCWF-B6		11-12	✓		3			0-1				✓	
R-1		12-13	✓									✓	
E.I.O. C040851		13-14	✓									✓	
		14-15	✓									✓	
M183530		20-21	✓									✓	
		59-60		R	2-3		R	1		2-3			
Z103989		60-61	✓							2-3			
		63-65	✓		3							✓	
		65-66		R	3		4	R				✓	
		73-74	✓		1								
		77-78	✓		1								
		78-79	✓										
		82-83		R	1-2		R			2-3			
		84-85		R	1-2			R				✓	
		85-86		R				1	R	1			
		86-87	✓		1					1			
		87-88	✓		1					1			
		88-89	✓							1			
		111-112		R			R					✓	
		127-128	✓									✓	
		15-16	✓									✓	✓

NO. ACCEPTED 0	NO. REJECTED 1	MQS TECH. NO. 13205	SHT.	REV. 1
COMMENTS Additional Film included For uneven surface areas.		CUST. RSS NO.		SHT.
		REVIEWER <i>[Signature]</i>		REV.
		CERTIFIED NDT LEVEL (RT)		
		D CYWINSKI R.T. III EXP. 1/09		

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Ind. of Ohio		PURCHASE ORDER NUMBER PPPL-EP-LTS-2		DATE 6-26-06		CONTROL NO. 40851		PAGE 1 of 1			
PART NO. MCWF-B6		SPECIFICATION E476/E186/E280		CLASS See spec		TOTAL PIECES 1		PIECES ACCEPTED 1			
RADIOGRAPHED BY: M. Jett / Kelley		INTERPRETED BY: M. Jett / Kelley		ASNT LEVEL IR							
FILM TYPE 29/59/80	MATERIAL CF8M/MnMod		ISOTOPE IRIDIUM 192 COBALT 60 ✓		CODE ASTM E94 ✓ ASME MIL-STD-453						
	V I E W	P E N E	A C C E P T	R E J E C T	S H R I N K	I N C L U S I O N	P O R O S I T Y	L I N E A R	S U R F A C E	L O F / L O P	COMMENTS
M 18 353 0											
R2	59-60	30/50	/		2	2					
Repair Film	65-66	30/40		X			X			X	
	82-83	50	/		3	2			/		
	84-85			X						X	
	85-86	40	/		2						
	112-111	30	/		2		1				
	111-112	120	/								
R3	65-66	30/40		X			X				
	84-85	50		X						X	
R4	65-66	30/40		X			X				
	84-85	50		X						X	
R5	65-66	30/40	/			1	2				Film Crimp
	84-85	50	/		1		2		/		



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>ETC</u>	Pattern Number <u>MCWFB-6</u>
Material	Traceability Number
Film Manufacturer <u>Fuji</u>	Source Number <u>20.8ci cobd</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)	59-60	65-66	82-83	84-85	85-86	111-112	111-112						
Thickness (IN.)	1 1/2-2 1/2	1 1/2-2	2 1/2"	→		1 1/2-2	→						
S/F Distance (IN.)	20"	→				20"	20" → 36"						
Penetrameter	2X30 40/50	2X30 40	2X50	→		30X2 120							
Time (MIN.)	16m 45s	16m 20s	9m 16s	→		14m 29s	26m						
Focal Spot (IN.)	.1			→									
Film Size (IN.)	14X17	→				14X17							
Screen Size (Pb)	.01	→				.01							
Front/Back		→											
S.W.E./D.W.E.	SWE	→											
S.W.V/D.W.V.	SWV	→											
Film Type	29 59 80	29 59 80	2X80	→		29 59 80	59/80						
Acceptance Standard	E446 E186	E446	E186	→		E446 E186	E446						
Severity Level	See Spec												

Shooting Sketch (Use Additional Pages as Needed)

See Original Drawing

Technique Prepared By: Dougherty Level: II Date: 6-26-06
 Technique Approved By: _____ Level: _____ Date: _____