

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>	361-03170
ADDRESS <u>8600 COMMERCIAL BLVD</u>		P.O. NUMBER	XRAY X
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>		23525	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET _____ OF _____	
ASTM E94-93	MSS-SP-54-1999		

PART NUMBER	Serial No	View	No Apparent Indications		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Dross or Slag	Porosity	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	✓					12			
		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	✓					12			
		22-23	✓								
		23-24	✓								
		24-25	✓								
		25-26	✓								

NO. ACCEPTED	φ	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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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 _____ OF _____	
<u>ASTM E94-93</u>	<u>MSS-SP-54-1999</u>		

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage			Film Artifacts		REMARKS
			Acceptable	Rejection	Included	or Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface			
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 <u>1</u>	NO. REJECTED <u>0</u>	MQS TECH. NO. <u>13205</u>	SHT. <u>1</u>	REV. <u>1</u>
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

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		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Dross or Slag	Porosity	Lack of Fusion Gas Cracks	Hot Tears	Under cut	Surface	
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	✓			3						
	63-65			R	4						
	65-66			R	4			4			
	66-67	✓			2						
	67-68	✓								✓	
	69	✓								✓	
	70-71	✓			2						
	71-72	✓			2						
	73-74			R	5						
	74-75	✓									
	75-76	✓									
	77-78			R	5			4			
	78-79			R	5						
	80-81	✓									
	81-82	✓								✓	
	82-83			R				5	4		
	84-85			R					5		
	85-86			R					4		

NO. ACCEPTED

0

NO. REJECTED

1

MQS TECH. NO.

13205

SHT.

REV. 1

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

John Petroske

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		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Dross or Slag	Porosity	Lack of Fusion Gas Cracks	Hot Tears	Under cut	Surface	
MCWF-B6	86-87			R							
	87-88			R							
E.I.O. C040851	88-89			R							
	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							
	112-113	✓									
	113A-114	✓									
	115-116	✓									

NO. ACCEPTED	4	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		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	Accep- table	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage			Film Artifacts		REMARKS
				Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face			
MCWF-B6	117-118		✓												
	118-119		✓												
E.I.O. C040851	119-120		✓												
	120-121		✓												
M183530	121-122		✓								2-3				
	123-124		✓						2						
Z103989	124-125		✓						2						
	126-127		✓												
	127-128				R							R			✓

NO. ACCEPTED	φ	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		DATE	WORK ORDER NO.
NAME <u>METAL TEK INTERNATIONAL</u>		<u>06/22/2006</u>	361-03256
ADDRESS <u>8600 COMMERCIAL BLVD</u>		P.O. NUMBER	XRAY X
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>		23525	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET <u>1</u> OF <u>1</u>	
ASTM E94-93	MSS-SP-54-1999		

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Included	or Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
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 <u>0</u>	NO. REJECTED <u>1</u>	MQS TECH. NO. 13205	SHT.	REV. 1
COMMENTS <i>Additional Film included For uneven surface areas.</i>		CUST. RSS NO.	SHT.	REV.
		REVIEWER <u>[Signature]</u>	D. CYWINSKI R.T. III EXP. 1/09	

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER <i>Energy Ind. of Ohio</i>		PURCHASE ORDER NUMBER <i>PPPL-EP-LTS-2</i>			DATE <i>6-26-06</i>		CONTROL NO. <i>40851</i>		PAGE <i>1 of 1</i>			
PART NO. <i>MCWF-B6</i>		SPECIFICATION <i>E476/E186/E280</i>		CLASS <i>See spec</i>		TOTAL PIECES <i>1</i>		PIECES ACCEPTED <i>1</i>				
RADIOGRAPHED BY: <i>M. Kelly</i>				INTERPRETED BY: <i>M. Kelly</i>			ASNT LEVEL <i>IP</i>					
FILM TYPE <i>29/59/80</i>		MATERIAL <i>CF8MNMnMod</i>		ISOTOPE <i>IRIDIUM 192 COBALT 60 ✓</i>			CODE <i>ASTM E94 ✓ ASME MIL-STD-453</i>					
		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
<i>M 18 353 0</i>												
<i>R2</i>		<i>59-60</i>	<i>30/50</i>	<i>/</i>		<i>2</i>	<i>2</i>					
<i>Repair Film</i>		<i>65-66</i>	<i>30/40</i>	<i>/</i>	<i>X</i>			<i>X</i>		<i>X</i>		
		<i>82-83</i>	<i>50</i>	<i>/</i>		<i>3</i>	<i>2</i>			<i>/</i>		
		<i>84-85</i>	<i>/</i>	<i>/</i>	<i>X</i>					<i>X</i>		
		<i>85-86</i>	<i>40</i>	<i>/</i>		<i>2</i>						
		<i>112-111</i>	<i>30</i>	<i>/</i>		<i>2</i>		<i>1</i>				
		<i>111-112</i>	<i>120</i>	<i>/</i>								
<i>R3</i>		<i>65-66</i>	<i>30/40</i>	<i>/</i>	<i>X</i>			<i>X</i>				
		<i>84-85</i>	<i>50</i>	<i>/</i>	<i>X</i>						<i>X</i>	
<i>R4</i>		<i>65-66</i>	<i>30/40</i>	<i>/</i>	<i>X</i>			<i>X</i>				
		<i>84-85</i>	<i>50</i>	<i>/</i>	<i>X</i>						<i>X</i>	
<i>R5</i>		<i>65-66</i>	<i>30/40</i>	<i>/</i>			<i>1</i>	<i>2</i>				<i>Film Crimp</i>
		<i>84-85</i>	<i>50</i>	<i>/</i>		<i>1</i>		<i>2</i>	<i>/</i>			



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer EIO	Pattern Number MCWFB-6
Material	Traceability Number
Film Manufacturer Fuji	Source Number 20.8ci cobd
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.)	1/2-2 1/2	1 1/2-2	2 1/2"	→		1 1/2-2 1/2	→						
S/F Distance (IN.)	20"	→		→		20"	20"	→ 36"					
Penetrater	2X30 40/50	2X30 40	2X50	→		30X2 120	30X2						
Time (MIN.)	16m 45s	16m 20s	9m 16s	→		1m 27s	26m						
Focal Spot (IN.)	.1												
Film Size (IN.)	14X17	→		→		→	→						
Screen Size (Pb)	101	→		→		→	→						
Front/Back		→		→		→	→						
S.W.E./D.W.E.	SWE	→		→		→	→						
S.W.V/D.W.V.	SWV	→		→		→	→						
Film Type	29 ⁵⁹ 80	29 ⁵⁹ 59	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: IR Date: 6-26-06
 Technique Approved By: _____ Level: _____ Date: _____