

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>01/03/2006</u>	<u>361-02787</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>22814</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
			Acceptable	Rejection	Included	or	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface	
MCWF-C6	6	1-2	✓						2				
		2-3	✓						1				
E.I.O. C040851		3-4	✓						1				
		4-5	✓						1-2				✓
M173890-1		5-6	✓						1				
		7-8	✓							1			
		8-9		R							R		
		9-10	✓		1								
		11-12	✓										
		12-13	✓										
		13-14	✓										
		15-16	✓		3								
		16-17	✓		3							✓	
		18-19		R	4								
		19-20		R					4				
		20-21		R					4				
		21-22	✓						2				
		23-24	✓										
		24-25	✓		1								
		26-27	✓		1-2								
		27-28		R	4								
		29-30		R						R			
		30-31		R						R			
		32-33		R						R			
		33-34		R						R			

NO. ACCEPTED <u>0</u>	NO. REJECTED <u>1</u>	MQS TECH. NO. <u>12970</u>	SHT. <u> </u>	REV. <u>1</u>
COMMENTS		CUST. RSS NO. <u> </u>	SHT. <u> </u>	REV. <u> </u>
		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		01/03/2006	361-02787
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		22814	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-C6	6	35-36	✓			1						✓	
		36-37	✓						1			✓	
E.I.O. C040851		38-39	✓									✓	
		39-40	✓			1							
M173890-1		41-42	✓										
		42-43			R						R		
		44-45	✓										
		45-46			R	2					R		
		47-48			R						R		
		48-49			R						R		
		49-50-51	✓									✓	
		52-53	✓										✓
		53-54	✓										✓
		54-55	✓						2				
		55-56	✓										
		56-57	✓										
		57-58	✓										
		58-59	✓							1-2			
		59-60	✓										
		60-61	✓										
		62-63	✓										
		63-64			R	5							
		65-66	✓										
		67-68	✓										
		68-69	✓									✓	

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	12970	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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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>22814</u>	GAMMA
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		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWF-C6	6	69-70	✓									✓	
		✓											
E.I.O. C040851		71-72	✓		2-3							✓	
		72-73	✓		2-3							✓	
M173890-1		73-74	✓									✓	
		74-75	✓									✓	
		75-76	✓									✓	
		76-77	✓										
		78-79	✓									✓	
		79-80	✓		1							✓	
		80-81	✓									✓	
		81-82			R				R				
		83-84	✓										
		85-86	✓									✓	
		86-87	✓									✓	
		87-88	✓										
		88-89	✓									✓	
		90-91	✓									✓	
		92-93	✓									✓	
		✓											
		✓											
		96-97	✓										
		97-98			R					R			
		98-99	✓										
		100-101	✓									✓	

NO. ACCEPTED	Φ	NO. REJECTED	1	MQS TECH. NO.	12970	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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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>			GAMMA
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		Dross		Incomplete Penetration		Shrinkage			Film Artifacts			REMARKS
			Accep- table	Reje- Incl- cted sion	or Por- Slag osity	Lack of Fusion Gas Cracks	Hot Under Tears cut	Sur- face							
MCWF-C6	6	101-102	✓												
		102-103	✓										✓	✓	
E.I.O. C040851		103-104	✓											✓	
		104-105	✓										✓		
M173890-1		106-107			R						R				
		107-108	✓												
		108-109	✓												
		109-110	✓												
		111-112	✓												
		112-113	✓												
		114-115	✓											✓	
		115-116	✓												
		116-117			R						R				

NO. ACCEPTED <u> 6 </u>	NO. REJECTED <u> 1 </u>	MQS TECH. NO. <u>12970</u>	SHT. <u> </u>	REV. <u> 1 </u>
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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CUSTOMER

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

DATE
01/03/2006

WORK ORDER NO.
361-02787

P.O. NUMBER

XRAY X

22814

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 Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWF-C6	6	A-B	✓							1				
		B-C			R					5				
E.I.O. C040851		C-D			R					5				
		D-E	✓							2				
M173890-1		E-F	✓											
		F-G	✓							1-2				
		G-H	✓							1				
		H-I	✓							2				
		I-J	✓										✓	
		J-K	✓											
		K-L			R						R			
		L-M			R					3	R			
		M-N	✓							1			✓	
		N-O	✓										✓	
		O-P	✓			2-3							✓	
		P-Q	✓											
		Q-R	✓											
		R-S	✓							1				
		S-T	✓											
		T-U	✓							2			✓	
		U-V	✓											
		V-W	✓											
		W-X	✓							2				
		X-Y	✓											
		Y-Z			R					4-5				

NO. ACCEPTED

4

NO. REJECTED

1

MQS TECH. NO.

12970

SHT.

REV. 1

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

John Petroske
 CERTIFIED NDT LEVEL (RT)

John Petroske RT II Exp. 01/08

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

[illegible]

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	12970	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				

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Industries of OHIO		PURCHASE ORDER NUMBER PPL-FP-LTS-2		DATE 1-19-06		CONTROL NO. 40851		PAGE 1 of 2			
PART NO. MCWFC-6		SPECIFICATION E446/E186/E280		CLASS See Spec		TOTAL PIECES 1		PIECES ACCEPTED 1			
RADIOGRAPHED BY: Kelley/Midgett		INTERPRETED BY: Kelley/Midgett		ASNT LEVEL II							
FILM TYPE 29/59/80	MATERIAL CF8M/MN/MD		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
M178500											
A-1	8-9	50	/								Film Crimp
	18-19			X				X			
	19-20		/			1	1		/		
	20-21		/			1	1		/		
	27-28			X	ADP					X	
	29-30	30	/		1	2			/		
	30-31		/		1	2			/		
	32-33		/			2	1		/		
	33-34		/		2	2			/		
	42-43	30/40	/			1			/		
	45-46		/			1	1		/		Film Crimp
	47-48			X				X			ADP
	48-49			X				X			ADP
	63-64	30	/			2	2		/		
	81-82	30/40	/				2				
	97-98	50		X						X	
	106-107			X						X	
	116-117			X						X	
	B-C	60/120	/			1	1		/		
	C-D	60/120/40	/	X		+	+		X	X	

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER		PURCHASE ORDER NUMBER				DATE		CONTROL NO.		PAGE		
PART NO.		SPECIFICATION		CLASS		TOTAL PIECES		PIECES ACCEPTED				
Energy Industries of OHIO		PPL-FP-LTS-2				1-19-06		40851		2 of 2		
MCWFC-6		E44/E186/E280		See Spec		1		1				
RADIOGRAPHED BY: Kelley/Midgett				INTERPRETED BY: Kelley/Midgett				ASNT LEVEL II				
FILM TYPE		MATERIAL		ISOTOPE				CODE				
29/59/80		CF8M MN Mod		IRIDIUM 192 COBALT 60 /				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
M178500												
R1		K-L	60 120		X	X						
↓		L-M	↓	/				2		/		
↓		Y-Z	↓	/				2		/		
R-2		18-19	50	/			2	1		/		
↓		27-28	↓		X						X	
↓		47-48	30/40	/				1		/		
↓		48-49	↓	/			1	1		/		
↓		97-98	50	/			1	1		/		
↓		106-107	↓	/		1				/		
↓		116-117	↓	/			1			/		
↓		K-L	60 120	/				2				
↓		C-D	60 120	/				2				
R3		27-28	50	/		1		1		/		



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>Energy Ind. of Ohio</u>	Pattern Number <u>MCWFC-6</u>
Material <u>CEBMNND</u>	Traceability Number
Film Manufacturer <u>Fuji</u>	Source Number <u>22.1 ci 6060</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)	8-9	18-19	19-20	20-21	27-28	29-30	30-31	32-33	33-34	42-43	45-46	47-48
Thickness (IN.)	<u>2-3/4</u>	<u>2 3/4</u>				<u>1 1/2</u>				<u>1 1/2 - 2"</u>		
S/F Distance (IN.)	<u>20"</u>											
Penetrameter	<u>50</u>					<u>30</u>				<u>30/40</u>		
Time (MIN.)	<u>10m</u>					<u>5m 30s</u>				<u>15m</u>		
Focal Spot (IN.)	<u>1</u>											
Film Size (IN.)	<u>14X17</u>				<u>7X17</u>	<u>14X17</u>						
Screen Size (Pb)	<u>01</u>											
Front/Back												
S.W.E./D.W.E.	<u>SWF</u>											
S.W.V./D.W.V.	<u>SWV</u>											
Film Type	<u>80</u>									<u>20/50</u>		
Acceptance Standard	<u>E186</u>					<u>E446</u>				<u>E446</u>		
Severity Level	<u>See Spec</u>											

Shooting Sketch (Use Additional Pages as Needed)

See original Technique Drawing.

Technique Prepared By: Doug Moly Level: II Date: 1-22-06
 Technique Approved By: _____ Level: _____ Date: _____



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer	E I O	Pattern Number	MCWFC-6
Material	CF8MNMN Mod	Traceability Number	
Film Manufacturer	Fuji	Source Number	
IQI LEVEL 2-2T From CQP 401 <input checked="" type="checkbox"/> Other (Specify, E.G. 2-4T, 2-1T) N/A			

Exposures (views)	48-49	63-64	81-82	97-98	106-107	116-117	B-C	C-D	K-L	L-M	Y-Z
Thickness (IN.)	1 1/2"-2"	1 1/2"	1 1/2"-2"	2 3/4"			3 1/2"	3'x8"	3'x6"		
S/F Distance (IN.)	20"										
Penetrameter	30/40	30	30/40	50			60/120	60/120	60/120		
Time (MIN.)	15m	10m	15m	11m30s			1hr55m	2hr15m	1hr55m		
Focal Spot (IN.)	1										
Film Size (IN.)	14X17										
Screen Size (Pb)	01										
S.W.E./D.W.E.	SWE										
S.W.V/D.W.V.	SWV										
Film Type	29/59			80/80			80/59	29/59	80/59		
Acceptance Standard	E446			E186			E186	80X2	29X2		
Severity Level	See spec						E280				

Shooting Sketch (Use Additional Pages as Needed)

See original Technique Drawing.

Technique Prepared By: Dougherty Level: SA Date: 1-22-06
 Technique Approved By: _____ Level: _____ Date: _____