



Nondestructive Test Certification for Liquid Penetrant Examination

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

Date of Inspection: 05/26/2006

Type of Material: CAST STAINLESS

NDT#: 16858

Stage of Inspection: <input type="checkbox"/> Incoming Inspection <input type="checkbox"/> In-Process Inspection <input checked="" type="checkbox"/> After Repair <input type="checkbox"/> Final Inspection	Manufacturing Process: <input type="checkbox"/> Weldment <input checked="" type="checkbox"/> Casting <input type="checkbox"/> Bar Stock <input type="checkbox"/> Plate <input type="checkbox"/> Forging <input type="checkbox"/> Other	Surface Condition: <input checked="" type="checkbox"/> Machined <input type="checkbox"/> Rough <input type="checkbox"/> Other FINAL MACHINED	Test Being Run to: <input checked="" type="checkbox"/> Router Instructions <input checked="" type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card SEE NOTES	Heat Treated: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
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Part Information: MTM Job Number: 65709/1.0 -Sub:17 -Op:40 Resource ID: 810-LIQUID PENETRANT INSPECTI Part ID: SE141-114 Part Name: MODULAR COIL WINDING FORM Serial Number: Customer P.O.: S005242-F Customer Unit/Plant:	Test Results: Quantity Inspected: 1 Quantity Accepted: 1 Quantity Rejected: 0 Run Hours:	
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Customer Inspection PI SEE NOTES Test Step: Revision: Material Test Number:	Inspection Criteria: Customer Specification: ASTM A903/A903M MTM Spec Number: PS582 (REF NDT-WI-009) Acceptance Standard: ASTM A903 (SEE NOTES)
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Inspection Materials Used: Manufacturer: SHERWIN Type of Penetrant: DP-51 Batch Number: 41-E47 Developer: D-100 Batch Number: 65-C6	Penetrant Examination Processes: Type: II (Visible) / Dwell Time: 20 Minutes Method: C (Solvent Wipe) Method of Drying: Normal Evaporation Form: e (nonaqueous for Type II visible dye) / Dwell Time: 20 Min
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Inspection Requirements:					
100 % of all accessible surfaces	<input type="checkbox"/> Joint Preps	<input type="checkbox"/> Root Pass	<input type="checkbox"/> Back Gouge	<input type="checkbox"/> Cover Pass	<input type="checkbox"/> Other
OF REPAIR AREA					

Notes:
 INSPECT 100% OF REPAIR AREA SURFACES AS REPORTED ON NCR-19709.

SPECIFICATION: ASTM A903/A903M
 METHOD: ASTM E165

ACCEPTANCE CRITERIA: ASTM A903/A903M LEVEL I FOR MACHINED SURFACES INCLUDING THE ENTIRE "T" SECTION (HIGH STRESS AREAS)

This is to certify that the pieces specified have been inspected in accordance with the specifications shown.

Inspector: 581-D.EDWARDS

Date: 05/26/2006

Douglas D. Edwards Level II



INSPECTION DATA CHECKLIST

Workorder: 65709/1-0 Sub:17 Op:50

Revision: 04/25/06 16:37

Part: REWORK - REWORK / REPAIR PER N/C - N/C # _____

Drawing ID: SE141-116 Rev: 8		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		N C 19709	MASTER GAGE	QA		J-1165	NO PERMEABILITY RESPONSE EQUAL TO OR GREATER THAN 1.02μ (ORSTEADS)	840-G.M			A
(10)		RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.						06-01-06			*

Employees: 840-G.Masood

* To Far Right Indicates Data Package Requirement

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.