

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 METAL TEK INTERNATIONAL		11/20/05	361-02698-1
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		22501	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET 1 OF 5	

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Inclusion	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWF-A3	1-2		✓						1				
	2-3		✓						3				
E.I.O. C040851	3-4		✓						1-2				
	4-5		✓						2				
M176180	5-6		✓						2				
	6-7		✓						1-2				
Z103990	7-8		✓						1-2				
	8-9		✓						2				
	9-10		✓									✓	
	10-11				R				4				
	11-12				R				1		R	✓	
	12-13				R				5		R	✓	✓
	13-14				R				5				
	15				R				5				
	16-17		✓						3				
	17-18		✓									✓	
	18-19		✓						1				
	19-20		✓										
	20-21		✓									✓	
	21-22		✓										
	22-23		✓										
	23-24		✓						1				
	24-25		✓						2				
	25-26		✓						1-2				
	26-27		✓										

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	13043	SHT.	REV. 1
COMMENTS				CUST. RSS NO.		SHT.	REV.
				REVIEWER	John Petraske		
				CERTIFIED NDT LEVEL (RT)	RT II John Petraske		

Exp 01/08

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CITY PEVELY STATE MO ZIP 63070		22501	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET 2 OF 5	
ASTM E94-93	MSS-SP-54-1999		

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Inclusion	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWF-A3	27-28	✓							23				
	28-29	✓							2				
E.I.O. C040851	29-1	✓							2				
	30-31	✓							1				
M176180	31-32	✓										✓	
	32-33	✓											
Z103990	33-34	✓											
	34-35	✓											
	35-36			R							R		
	36-37												
	37-38	✓							1				
	38-39			R					5				
	39-40			R					4				
	41-42			R					5				
	43-44	✓							1				
	44-45	✓							1				
	45-46	✓											
	46-47	✓											
	47-48	✓											
	48-49	✓											
	50-51	✓											
	51-52	✓											
	52-53			R							R		
	54-55	✓											
	55-56	✓							2				

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	13043	SHT.	REV. 1
COMMENTS				CUST. RSS NO.		SHT.	REV.
				REVIEWER	<i>John Petraske</i>		
				CERTIFIED NDT LEVEL (RT)	RTIF E-101108 John Petraske		

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CITY PEVELY STATE MO ZIP 63070		22501	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET 3 OF 5	

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-A3	57-58	✓						2			
	58-59	✓							1		
E.I.O. C040851	59-60	✓									
	60-61	✓									
M176180	61-62			R					4		
	62-63			R						R	
Z103990	64-65			R						R	
	63-64	✓							1		
	64-65	✓									✓
	65-66	✓									
	66-67	✓							2		
	67-68			R	5				2	R	
	68-69	✓							2		
	69-70			R					4		
	70-71			R					4		
	71-72	✓			2						
	72-73	✓						2-3			
	73-74	✓									
	74-75	✓									✓
	75-76	✓			1						
	76-77			R					4		
	77-78	✓									
	78-79	✓							2		
	79-80	✓							2-3		
	80-81			R					4		

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	13043	SHT.	REV. 1
COMMENTS		CUST. RSS NO.		SHT.	REV.
		REVIEWER	<i>John Petruska</i>		
		CERTIFIED NOT LEVEL (RT)	RT II Exp 01/08 John Petruska		

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CITY PEVELY STATE MO ZIP 63070		22501	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET 4 OF 5	

PART NUMBER	Serial No	View	No Apparent Indications		Dross or Porosity		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Inclusion	Slag	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWF-A3	81-82	✓						2	1-2				
	82-83	✓						1-2					
E.I.O. C040851	84-85	✓						2-3					
	85-86	✓						2-3					
M176180	86-87	✓		R				3		R			
	87-88A	✓											
Z103990	88-89	✓						2					
	89-90	✓		R	5								
	90-91	✓						1-2					
	92-93	✓		R				5					
	94-95	✓							2			✓	
	95-96	✓		R					4			✓	
	96-97	✓		R					4			✓	
	97-98	✓		R					5			✓	
	98-99	✓			2			1	2			✓	
	99-100	✓		R				5				✓	
	100-101	✓										✓	
	102-103	✓						3				✓	
	103-104	✓							3			✓	
	104-105	✓		R					4			✓	
	106-107	✓						1				✓	
	107-108	✓						2				✓	
	108-109	✓		R				2	5			✓	
	109-110	✓						2	3			✓	
	111-112	✓										✓	

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV. 1
4	1	13043		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		CERTIFIED NDT LEVEL (RT)		
		RTII Exp 1/08 John Petraske		

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ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		22501	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET 5 OF 5	

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Inclusion	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWF-A3			112-113	R					4			✓	
			113-114	✓					3			✓	
E.I.O. C040851			115-116	✓					2			✓	
			116-117	✓								✓	
M176180			118-119	R					1	R		✓	
			119-120	✓								✓	
Z103990			121-122	✓				1	1			✓	
			122-123	✓								✓	
			123-124	✓	1			1				✓	
			124-125	R	R	ST				R		✓	
			125-126	R				4				✓	
			126-127	✓				3	1			✓	
			127-128	✓					2			✓	
			129-129	✓								✓	
			130-131	✓								✓	
			131-132	✓				3				✓	
			133	✓								✓	
			134	✓								✓	

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV. 1
0	1	13043		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER	S. TERACE	
		CERTIFIED NOT LEVEL (RT)	II	

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CUSTOMER

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

DATE 01/15/2005 WORK ORDER NO. 361-02825

P.O. NUMBER 22896 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 Surface	
MCWFA-3		10-11	✓								
	(R1)	11-12	✓					2			
Z103990		12-13	✓					2			
HT# M176180		13-14	✓								✓
CO 40851		V15	✓		2						✓
		35-36	✓								
		38-39	✓								✓
		39-40	✓								
		41-42	✓								
		52-53	✓								
		61-62	✓								
		12-63	✓					1			
	62A-63A	✓									
		67-68	✓					2			
		69-70	✓					1-2			
		70-71	✓								
		76-77	✓		1						
		80-81	✓								
		86-87	✓								✓
		89-90	✓								
		92-93			R						
		95-96	✓					5			
		96-97	✓								
		99-100	✓								
		104-105	✓					3			

COMMENTS

Φ

NO. REJECTED /

MQS TECH. NO. 13043

SHT. REV. 1

CUST. RSS NO.

SHT. REV.

REVIEWER John Petroske
 CERTIFIED NDT LEVEL (RT)

John Petroske RT II Exp. 01/08

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 ADDRESS 8600 COMMERCIAL BLVD
 CITY PEVELY STATE MO ZIP 63070

DATE 01/15/2005 WORK ORDER NO. 361-02825
 P.O. NUMBER 22896 XRAY X
 GAMMA
 SHEET OF

PROCEDURE SPECIFICATION ASTM E94-93 ACCEPTANCE CRITERIA MSS-SP-54-1999

PART NUMBER	Serial No	View	No Apparent Indications		Dross or Porosity		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejection	Inclusion	or Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWFA-3		26-27	✓										
	109-110		✓							2			
Z103990													
HT# M176180													
CO 40851													

O. ACCEPTED 1 NO. REJECTED 0

COMMENTS Reshots

MQS TECH. NO. 13043 SHT. REV. 1
 CUST. RSS NO. SHT. REV.
 REVIEWER John Petroske
 CERTIFIED NDT LEVEL (RT)
 John Petroske RT II Exp. 01/08



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <i>Energy Ind. of Ohio</i>	Pattern Number <i>MW FA-3</i>
Material <i>CF8M UN Mod</i>	Traceability Number
Film Manufacturer <i>Fuji</i>	Source Number <i>22.1 Ci 6060</i>
IQI LEVEL <u>2-2T</u> From CQP 401 <input checked="" type="checkbox"/> Other (Specify, E.G. 2-4T, 2-1T) <i>N/A</i>	

Exposures (views)	<i>9R-93</i>																			
Thickness (IN.)	<i>1 1/2" 3</i>																			
S/F Distance (IN.)	<i>20"</i>																			
Penetrameter	<i>3040 60</i>																			
Time (MIN.)	<i>15m</i>																			
Focal Spot (IN.)	<i>.1</i>																			
Film Size (IN.)	<i>14X17</i>																			
Screen Size (Pb) Front/Back	<i>101</i>																			
S.W.E./D.W.E.	<i>SWE</i>																			
S.W.V/D.W.V.	<i>SWV</i>																			
Film Type	<i>29 159</i>																			
Acceptance Standard	<i>E746 E186</i>																			
Severity Level	<i>see spec</i>																			

Shooting Sketch (Use Additional Pages as Needed)

See original Technique drawing

Technique Prepared By: *Dave Matyja* Level: *IF* Date: *1-22-06*
 Technique Approved By: _____ Level: _____ Date: _____

