

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>02/07/2006</u>	361-02844
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>		Chuck Rudd	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	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face			
MCWFA-5		1-2	✓												
		2-3	✓												
Z103990		3-4	✓												
HT# M176200		4-5	✓												
CO 40851		5-6			R				4						
		6-7			R				4						
		7-8	✓						2						
		8-9	✓												
		9-10	✓												
		10-11	✓											✓	
		11-12	✓			3									
		12-13	✓												
		13-14	✓												
		15	✓											✓	
		16-17	✓												
		17-18	✓												
		18-19	✓											✓	
		19-20	✓											✓	
		20-21	✓											✓	
		21-22	✓											✓	
		22-23	✓											✓	
		23-24			R						R				
		24-25			R						R				
		25-26	✓												

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV.
0	1	12970		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		CERTIFIED NDT LEVEL (RT)		
		John Petroske RT II Exp. 01/08		

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NAME METAL TEK INTERNATIONAL					02/07/2006	361-02844
ADDRESS 8600 COMMERCIAL BLVD					P.O. NUMBER Chuck Rudd	XRAY X
CITY PEVELY STATE MO ZIP 63070						GAMMA

PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET _____ OF _____	
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[illegible]

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	12970	SHT.	REV.
COMMENTS				CUST. RSS NO.		SHT.	REV.
				REVIEWER	John Petroske		
				CERTIFIED NDT LEVEL (RT)	John Petroske RT II Exp. 01/08		

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NAME METAL TEK INTERNATIONAL		02/07/2006	361-02844
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		Chuck Rudd	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET ____ OF ____	
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	or Slag	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface	
MCWFA-5	30-31	✓										✓	
	31-32			R						R		✓	
Z103990	32-33			R						R			
HT# M176200	33-34			R						R			
CO 40851	34-35	✓											
	35-36			R						R			
	37-38			R						R			
	38-39	✓											
	39-40	✓											
	41-42	✓											
	43-44	✓											
	44-45	✓											
	45-46	✓										✓	
	46-47	✓											
	47-48	✓											
	48-49	✓											
	50-51	✓											
	51-52	✓											
	52-53			R						R			
	54-55	✓											
	55-56	✓										✓	
	57-58	✓											
	58-59	✓											
	59-60	✓											
	60-61	✓										✓	

NO. ACCEPTED	Φ	NO. REJECTED	1	MQS TECH. NO.	12970	SHT.	REV.
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 METAL TEK INTERNATIONAL		02/07/2006	361-02844
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		Chuck Rudd	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET ____ OF ____	
ASTM E94-93	MSS-SP-54-1999		

PART NUMBER	Serial No	View	No Apparent Indications		Dross or Por- osity		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	Slag	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWFA-5		61-62	✓									✓	
		62-63		R						R			
Z103990	62A-63A			R						R			
HT# M176200		63-64		R					4				
CO 40851		64-65		R					4			✓	
	65-65A-66			R						R			
		66-67	✓						2			✓	
		67-68	✓					2				✓	
		68-69	✓									✓	✓
		69-70		R					4				
		70-71		R					4	R			
		71-72		R				2	4				
		72-73	✓						*				See 71-72
		73-74	✓										
		74-75	✓										
		75-76	✓										
		76-77		R					4				
		77-78	✓										
		78-79	✓										✓
		79-80	✓										
		80-81	✓						3				
		81-82	✓						1				✓
		82-83	✓						1			✓	
		84-85	✓										
		85-86	✓										

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV.
0	1	12970		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		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

02/07/2006

WORK ORDER NO.

361-02844

P.O. NUMBER

Chuck Rudd

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		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- Inclu- cted sion	or Por- Slag osity	Lack of Fusion Gas Cracks	Hot Under Sur- Tears cut face						
MCWFA-5		86-87	✓										
		87-88A	✓										
Z103990		88-89		R						R			
HT# M176200		89-90	✓									✓	
CO 40851		90-91	✓				2						
		92-93	✓						1				
		94-95	✓				2		2				
		95-96	✓				2		2-3				
		96-97	✓						1				
		97-98		R					4				
		98-99	✓						2-3				
		99-100		R					4				
		100-101	✓										
		102-103	✓						1				
		103-104	✓						2				
		104-105		R					4				
		106-107	✓										
		107-108	✓										
		108-109	✓						2				
		109-110	✓						1				
		111-112	✓						2				
		112-113	✓								✓		
		113-114	✓										
		115-116	✓										
		116-117	✓										

NO. ACCEPTED

4

NO. REJECTED 1

MQS TECH. NO. 12970

SHT.

REV.

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

John Petroske

CERTIFIED NOT LEVEL (RT)

John Petroske RT II Exp. 01/08

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		02/07/2006	361-02844
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER Chuck Rudd	XRAY X
CITY PEVELY STATE MO ZIP 63070			GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET OF	

[illegible]

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	12970	SHT.	REV.
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

03/10/06

WORK ORDER NO.

361-03019

P.O. NUMBER

23335

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		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Under Tears	Sur- face		
MCWF-A5	R1	5-6	✓										
		6-7	✓						2-3				
E.I.O. C040851		23-24	✓								✓	✓	
		24-25	✓										
M176200		31-32	✓										
		32-33	✓									✓	
Z103990		33-34	✓									✓	
		35-36	✓										
		37-38	✓										
		52-53			R					R			
		62-63	✓									✓	
		62A-63A	✓										
		63-64			R				4				
		64-65			R				4*				See 63-64
		65-66	✓										
		69-70	✓						2				
		70-71			R				2	R			
		71-72	✓					1	1				
		76-77	✓						1				
		88-89	✓						2				
		97-98	✓						1				
		99-100	✓					1					
		104-105	✓						2				
		125-126	✓										

NO. ACCEPTED

0

NO. REJECTED

1

COMMENTS

MQS TECH. NO.

13043

SHT.

REV. 1

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NDT LEVEL (RT)

J Petroske RT II

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Ind. of Ohio		PURCHASE ORDER NUMBER PPPL-FD-LTS-2		DATE 3-13-06		CONTROL NO. 40851		PAGE 1 of 1															
PART NO. MCWFA-5		SPECIFICATION E446/E186/E280 ^{0m}		CLASS See spec		TOTAL PIECES 1		PIECES ACCEPTED 1															
RADIOGRAPHED BY: Midge H / Rippersen		INTERPRETED BY: Midge H		ASNT LEVEL II																			
FILM TYPE 29 59/80		MATERIAL CF8MNMN mod		ISOTOPE IRIDIUM 192 COBALT 60 ✓		CODE ASTM E94 ✓ ASME MIL-STD-453																	
M176200-8 MCWFA-5		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	
		52-53 50				X								X									
R2		63-64 30 50 80		/						2				/									
		64-65 30		/										/									
		70-71 30 60 80		/				3		2		21 ^{0m}		/									
R3		52-53 30 50 80		/		X								X									
R4		52-53 50		/								1		/									



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>Energy Ind. OF OHIO</u>	Pattern Number <u>WCWFA-5</u>
Material <u>CF8MNMN mod</u>	Traceability Number
Film Manufacturer <u>Fuji</u>	Source Number <u>21.7 ci COGO</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)	<u>52-53</u>	<u>63-64</u>	<u>64-65</u>	<u>70-71</u>									
Thickness (IN.)	<u>2 3/4"</u>	<u>1.5"-4"</u>	<u>1 1/2"</u>	<u>1.5"-4"</u>									
S/F Distance (IN.)	<u>20"</u>			<u>24"</u>									
Penetrator	<u>50</u>	<u>30x2</u> <u>50/60</u>	<u>30x2</u>	<u>30x2</u> <u>60/60</u>									
Time (MIN.)	<u>17m</u>	<u>28m</u>	<u>13m</u>	<u>45m</u>									
Focal Spot (IN.)	<u>1</u>			<u>7</u>									
Film Size (IN.)	<u>14X17</u>			<u>7</u>									
Screen Size (Pb)				<u>7</u>									
Front/Back	<u>101</u>			<u>7</u>									
S.W.E./D.W.E.	<u>SWE</u>			<u>7</u>									
S.W.V/D.W.V.	<u>SWV</u>			<u>7</u>									
Film Type	<u>59/60</u>	<u>29x2</u> <u>59/60</u>	<u>29</u> <u>59</u>	<u>29</u> <u>80/59</u>									
Acceptance Standard	<u>see spec</u>												
Severity Level	<u>see spec</u>												

Shooting Sketch (Use Additional Pages as Needed)

See original Drawing for view placement

Technique Prepared By: Doug Midgett Level: II
 Technique Approved By: _____ Level: _____

Date: 3-13-06
 Date: _____