



Carondelet Division

8600 Commercial Blvd. - Pevely, MO 63070 USA
Phone: 636-479-4499 - Fax: 636-479-3399

Material Test Report

ENERGY INDUSTRIES OF OHIO

Purchase Order Number PPPL-FP-LTS-2 Heat Number 29198 Pour Date 4/28/2005
Pattern Number SE-141-073 COIL C SHIM (-3 thru-6 Parts) Cert Number S73220-2 and
SE-141-033 COIL A SHIM (-1 thru-6 Parts) Cert Number S76220-1
CAF Metal Designation CF8MNMnMod S/N 6
Material Spec CF8MNMN MOD
Revised 1/30/06

Element	Min	Actual	Max
C	0.040	0.070	0.070
CR	18.000	18.100	18.500
MN	2.300	2.970	2.800
MO	2.100	2.450	2.500
N	0.240	0.255	0.280
NI	13.000	13.120	13.500
P*	0.000	0.013	0.035
S*	0.000	0.010	0.025
SI	0.000	0.700	0.700

MN & SI previously reported on CA 1308 and were accepted.

*P & S taken from test from heat parts were poured from and analyzed by wet chemistry, ASTM E1019-03 for sulfur and Gravimetric for Phosphorous.

This report covers the eleven castings poured from heat 29198. Only parts listed above however will be shipped for this order. Each casting has a unique number stamped in the part adjacent to the pattern number to differentiate the part and subsequent reporting that will be traced to the casting.

Specification limits have been updated to latest specification.

The certificate is produced with EDP and valid without signature.

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager



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Final Inspection Report

Customer ENERGY INDUSTRIES OF OHIO Pattern: SE-141-033 COIL A SHIM S/N 6

Order PPPL-FP-LTS-2

ASTM Metal CF8MNMN MOD

Date 4/19/2006

Type Description	Cert Number	Procedure	Acceptance Criteria	Actual
Liquid Penetrant	S76220-1	CQP - 300 Rev 9	ASTM A903 Level II	Acceptable
Mag Perm	S76220-1	SOP Mag Perm 100 Rev 1	<1.02	Acceptable
Radiographic	S76220-1	Technique # 12726	MSS SP 54	Acceptable
Visual	S76220-1	CQP - 500 REV 4	ASTM A802 LEVEL 2	Acceptable

Liquid Penetrant

Technician: Tom Chapman
ASNT Level II

Visual

Technician: Kevin Anderson
ASNT Level II

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

Superior Quality Engineered Metal Products

www.MetalTekInt.Com



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Certificate of Conformance

ENERGY INDUSTRIES OF OHIO

Order Number PPPL-FP-LTS-2

Pattern SE-141-033 COIL A SHIM

S/N .6

Alloy CF8MNMnMOD

Date 4/19/2006

Cert Number

S76220-1

A shim for A-6 coil was poured from heat number 29198. No weld repairs were necessary.

A handwritten signature in black ink, appearing to read "CARUUD".

We certify that we have complied in accordance with the drawings(s) and specifications(s) listed on the above purchase order. The articles furnished were made and/or processed from parts and/or materials in accordance with all applicable drawings(s) and specifications(s) pursuant to the afore mention purchase order except as noted by corrective actions.

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

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RADIOGRAPHIC INTERPRETATION REPORT

[illegible]



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>E.I.O.</u>	Pattern Number <u>MCWFA-6</u>
Material <u>CF8M/4V MoA</u>	Traceability Number
Film Manufacturer <u>FUJI</u>	Source Number <u>CO</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>6364</u>	<u>71-72</u>	<u>99-100</u>										
Thickness (IN.)	<u>1 1/2" 4"</u>	<u>1 1/2"</u>	<u>2 3/4"</u>										
S/F Distance (IN.)	<u>20"</u>	<u>→</u>	<u>→</u>										
Penetrameter	<u>30x2</u> <u>50 80</u>	<u>30x2</u>	<u>82</u> <u>50</u>										
Time (MIN.)	<u>2 min</u>	<u>4/45s</u>	<u>8/25s</u>										
Focal Spot (IN.)	<u>.1</u>	<u>→</u>	<u>→</u>										
Film Size (IN.)	<u>14x17</u>	<u>→</u>	<u>→</u>										
Screen Size (Pb)	<u>.01</u>	<u>→</u>	<u>→</u>										
S.W.E./D.W.E.	<u>SWE</u>	<u>→</u>	<u>→</u>										
S.W.V./D.W.V.	<u>SWV</u>	<u>→</u>	<u>→</u>										
Film Type	<u>29</u> <u>80</u>	<u>80</u>	<u>→</u>										
Acceptance Standard	<u>E444</u> <u>E186</u>	<u>→</u>	<u>→</u>										
Severity Level	<u>See Spec</u>	<u>→</u>	<u>→</u>										

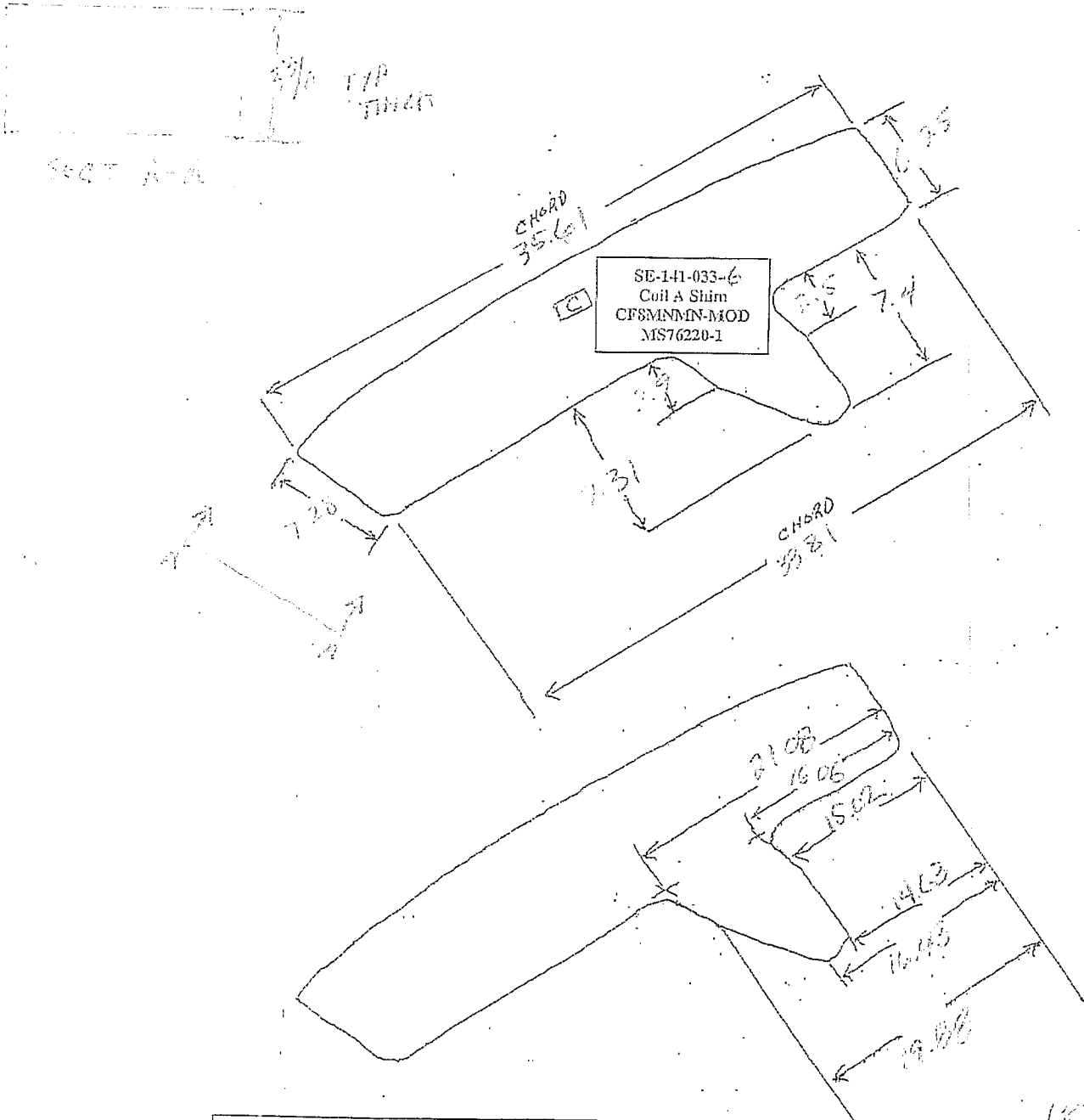
Shooting Sketch (Use Additional Pages as Needed)

Accept to MSS-SP-54-1999

Technique Prepared By: Ron Kelly Level: 4E Date: 4-4-06
 Technique Approved By: _____ Level: _____ Date: _____

Metaltek

INTERNATIONAL



Inspected By: *[Signature]* Date Inspected: *1/27/06*

A+C Shims CTR

