

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		1/11/2006	361-02763-2
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		Chuck Rudd	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
			Acceptable	Rejection	Inclusion	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWF-B-1	1-2	✓											
	2-3	✓						2-3					
E.I.O. C040851	3-4	✓						2					
	4-5			R				4-5					
M177210	5-6	✓						2					
	6-7	✓						2					
Z103989	7-8			R				4-5				✓	
	8-9	✓						2					
	9-10	✓						1-2				✓	
	10-11	✓									✓		
	11-12			R				5					
	12-13			R				5					
	13-14	✓						2-3					
	14-15	✓						2					
	15-16	✓											
	16-17	✓											
	17-18	✓											
	18-19	✓											
	19-20	✓											
	20-21	✓						1-2					
	21-22	✓											
	22-23	✓											
	23-24	✓										✓	
	24-25	✓											
	25-26	✓			2-3			2-3				✓	✓

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

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CITY PEVELY STATE MO ZIP 63070		Chuck Rudd	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	
			Accep- table	Reje- cted	Inclu- sion	Dross	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	Sur- face	Sur- face								
MCWF-B-1		2627	✓																				
		2728	✓																				
E.I.O. C040851		2829	✓																				
		29-1	✓																				
M177210																							
Z103989																							

NO. ACCEPTED	φ	NO. REJECTED	1	MQS TECH. NO.	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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CUSTOMER		DATE	WORK ORDER NO.
NAME <u>METAL TEK INTERNATIONAL</u>		<u>1/11/2006</u>	<u>361-02763-2</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>Chuck Rudd</u>	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	Included	or Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface		
MCWF-B-1	30-31	✓										✓	
	31-32	✓											
E.I.O. C040851	V33	✓											
	34-35	✓											
M177210	36-37	✓											
	V38	✓											
Z103989	39-40	✓										✓	
	40-41	✓											
	42-43	✓											
	43-44	✓											
	V45	✓											
	46-47	✓											
	48-49				R				5				
	49-50				R				5		R		
	V51	✓											
	V51A	✓											
	52-53	✓											
	53-54	✓											
	54-55	✓											
	55-56	✓											
	56-57	✓											
	58-59	✓											
	59-60				R						R	✓	
	60-61				R				5		R		
	61-62				R						R		

NO. ACCEPTED <u>0</u>	NO. REJECTED <u>1</u>	MQS TECH. NO.	SHT.	REV. 1
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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NAME METAL TEK INTERNATIONAL		1/11/2006	361-02763-2
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 ____	

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejection	Inclusion	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Undercut	Surface		
MCWF-B-1	62-63			R							R		
	64	✓											
E.I.O. C040851	63-65	✓						1				✓	
	65-66	✓						1				✓	
M177210	66-67	✓						2					
	67-68	✓						2					
Z103989	69			R					R				
	70-71			R					R				
	71-72	✓											
	73-74	✓											
	74-75	✓		X RBK				X RBK				✓	
	75-76	✓		R RBK				X RBK				✓	
	77-78	✓											
	78-79	✓											
	80-81	✓											✓
	81-82	✓											
	82-83			R					3				
	84-85			R					4				
	85-86			R				5					
	86-87			R				5	4-5				
	87-88	✓							4-5				
	88-89	✓							3				
	89-90			R					2				
	90-91	✓						2			R		
	91-92	✓						2					

NO. ACCEPTED	Φ	NO. REJECTED	1	MQS TECH. NO.	SHT.	REV. 1
COMMENTS				CUST. RSS NO.	SHT.	REV.
				REVIEWER	<i>John Petroske</i>	
				CERTIFIED ND LEVEL (RT)		
				John Petroske	RT II Exp. 01/08	

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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 _____	

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-B-1	93-94	✓												
	94-95	✓							2				R	
E.I.O. C040851	96-97	✓												
	97-98	✓												
M177210	98-99	✓												
	99-100	✓												
Z103989	101-102	✓												
	102-103	✓												
	103-104	✓								2				
	104-105	✓			R				R					
	106-107	✓												
	107-108	✓												
	108-109	✓											✓	
	109-110	✓											✓	
	110-111	✓											✓	
	111-112	✓											✓	
	112-113	✓											✓	
	113-114	✓											✓	
	115-116	✓			R				5		R		✓	
	117-118	✓											✓	
	118-119	✓								1			✓	
	119-120	✓											✓	✓
	120-121	✓				1			1				✓	✓
	121-122	✓											✓	✓

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	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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CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>		<u>Chuck Rudd</u>	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET ____ OF ____	
<u>ASTM E94-93</u>	<u>MSS-SP-54-1999</u>		

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 Under Tears	Surface cut		
MCWF-B-1	123 -124			R				3			E446
	124-125		✓		2-3					✓	
E.I.O. C040851	126 -127		✓							✓	
	127-128			R				R		✓	
M177210											
Z103989											

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

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER E.I.O		PURCHASE ORDER NUMBER PPPL-FP-LTS-2				DATE 2-11-06		CONTROL NO. 40851		PAGE 1 of 2													
PART NO. MCWFB-1		SPECIFICATION E446/E186/E280			CLASS SeeSpec			TOTAL PIECES 1		PIECES ACCEPTED													
RADIOGRAPHED BY: Kelley				INTERPRETED BY: Kelley				ASNT LEVEL II															
FILM TYPE 29/59/80		MATERIAL CF8MNMNMOD			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	
M177210-1																							
R1		4-5		50/80/100				X				4											
		7-8		 		/						1		/									
		11-12		 		/						1		/									
		12-13		↓		/						2		/									
		48-49		50		/				1 1		/											
		49-50		↓				X								X							
		59-60		30/40/50		/						2		/									
		60-61		30/100				X						X									
		61-62		30/40				X		4													
		62-63		↓		/				2				/									
		69		↓				X						X									
		70-71		30/40/50/60/80/100		/						2 2											
		82-83		50		/						1		/									
		84-85		 		/				2													
		85-86		 		/				2		2		/									
		86-87		 		/						1		/									
		89-90		↓		/								/									
		94-95		↓		/						2		/									
		104-105		30		/						1 2		/									
		115-116		↓		/						2 1		/									

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER E.I.O		PURCHASE ORDER NUMBER PPPL-FP-LTS-2				DATE 2-11-06		CONTROL NO. 40851		PAGE 2 of 2													
PART NO. MCWFB-1		SPECIFICATION E446/E196/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 CF8MNMN MOD			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	
M177210-1																							
R1		123-124		40/80		6080		X				4						X					
↓		127-128		30/40		/						1											
R2		4-5		50/80		100		/				1						/					
 		49-50		50		/		X										X					
 		60-61		30/100		/						1 1						/					
 		61-62		30/40		/						2 1						/					
 		69		↓		/												/					
↓		123-124		40/80		6080		/		1 1		2											
R3		49-50		50		/						2 1						/					



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer	E.I.O	Pattern Number	MCWFB-1
Material	CFBMNMU MDA	Traceability Number	
Film Manufacturer	FUJI	Source Number	CO60 22CI
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)	4-5	7-8	11-12	12-13	48-49	49-50	59-60	60-61	61-62	62-63	69	70-71
Thickness (IN.)	2 3/4" - 3 1/2" / 2 1/2" - 3"			3"			1 3/4" - 2 1/4"	1 3/4"	1 3/4"		1 1/2"	1 1/2" - 2"
S/F Distance (IN.)	20"											
Penetrator	50/100			50			30/50	30/100	30/40			30/60 / 40/80 / 50/100
Time (MIN.)	1 hr 55 min			17 min			16 min	17 min	16 min		15 min	20 min
Focal Spot (IN.)	.1											
Film Size (IN.)	14X17											
Screen Size (Pb)	.01											
Front/Back												
S.W.E./D.W.E.	SWE											
S.W.V/D.W.V.	SWV											
Film Type	29X29 / 80X2			80X2			29/80	29/80	29/59			29X29 / 80X2
Acceptance Standard	E186 / E280			E186			E446	E446 / E280	E446			E446 / E186
Severity Level	See SPEC.											

Shooting Sketch (Use Additional Pages as Needed)

See Original Technique

Technique Prepared By: Ken Kelley Level: II Date: 2-11-06
 Technique Approved By: _____ Level: _____ Date: _____



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer	E.I.O	Pattern Number	McWFB-1
Material	CF8MNMN Mod	Traceability Number	
Film Manufacturer	FUJI	Source Number	CO60 22.CI
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)	82-83	84-85	85-86	86-87	89-90	94-95	104-105	115-116	123-124	127-128		
Thickness (IN.)	2 1/4"						1 3/4"			1 3/4"		
S/F Distance (IN.)	20"											
Penetrameter	50						30		40/60	30/40		
Time (MIN.)	9min						16min		20min	16min		
Focal Spot (IN.)	.1											
Film Size (IN.)	14x17											
Screen Size (Pb) Front/Back	.01											
S.W.E./D.W.E.	SWE											
S.W.V./D.W.V.	SWV											
Film Type	80X2						29/59		29X2	29/59		
Acceptance Standard	E186						E446		E446	E186	E446	
Severity Level	See Spec.											

Shooting Sketch (Use Additional Pages as Needed)

See Original Technique

Technique Prepared By: Ron Kelley Level: II Date: 2-11-06
 Technique Approved By: _____ Level: _____ Date: _____