

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

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

DATE

4/18/2006

WORK ORDER NO.

361-03124

P.O. NUMBER

23525

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 Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face					
MCWF-B4		1-2	✓															
		2-3	✓								2-3							
E.I.O. C040851		3-4	✓								1-2							
		4-5	✓								2							
M183510		5-6	✓														✓	
		6-7	✓															
Z103989		7-8	✓														✓	
		8-9	✓														✓	
		9-10	✓															
		10-11	✓															
		11-12	✓								2-3							
		12-13			R						4							
		13-14	✓															
		14-15	✓															
		15-16	✓															
		16-17	✓															
		17-18			R									R				
		18-19	✓															
		19-20	✓															
		20-21	✓								2							
		21-22	✓								2							
		22-23	✓															
		23-24	✓														✓	
		24-25	✓														✓	
		25-26	✓														✓	

NO. ACCEPTED

0

NO. REJECTED

1

MQS TECH. NO.

13205

SHT.

REV. 1

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NDT LEVEL (RT)

John Petroske RT II Exp. 01/08

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ACCEPTANCE CRITERIA
 MSS-SP-54-1999

SHEET OF

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accept- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Under Tears	Sur- face		
MCWF-B4		26-27	✓									✓	
		27-28	✓										
E.I.O. C040851		28-29	✓										
		29-31	✓										
M183510		30-31	✓										
		31-32	✓										
Z103989		V33	✓										
		34-35	✓										
		35-36	✓										
		36-37	✓										
		V38	✓										
		39-40	✓										
		40-41	✓						1				
		42-43	✓						1				
		43-44	✓										
		V45	✓										
		46-47	✓										
		47-48	✓										
		48-49	✓										
		49-50	✓						2				
		V51	✓										
		V51A	✓										
		52-53	✓						1-2				
		53-54	✓										
		54-55	✓										

NO. ACCEPTED

Φ

NO. REJECTED 1

MQS TECH. NO. 13205

SHT.

REV. 1

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NOT LEVEL (RT)

John Petroske RT II Exp. 01/08

TEAM COOPERHEAT-MQS, INC.

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		4/18/2006	361-03124
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		23525	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET _____ OF _____	

PART NUMBER	Serial No	View	No Apparent Indications		Reje- cted	Inclu- sion	Dross or Slag	Incomplete Penetration or Por- osity	Lack of Fusion	Gas	Shrinkage		Hot Tears	Under cut	Sur- face	Film Artifacts	REMARKS
			Accep- table								Cracks						
MCWF-B4		55-56	✓														
		56-57	✓														
E.I.O. C040851		58-59	✓							1							
		59-60	✓														*
M183510		60-61			R								R				
		61-62	✓							2							
Z103989		62-63	✓							2					✓	✓	
		64	✓							2-3							
		63-65			R					3-4							
		65-66			R					4							
		66-67			R					4-5							
		67-68			R					2			R				
		69			R	5											
		70-71			R	5											
		71-72	✓														
		73-74			R								R				
		74-75	✓														
		75-76	✓														
		77-78	✓														
		78-79	✓														
		80-81	✓														
		81-82	✓														
		82-83	✓							3							
		84-85			R					4							
		85-86			R					4-5							

NO. ACCEPTED	NO. REJECTED 1	MQS TECH. NO. 13205	SHT.	REV. 1
COMMENTS		CUST. RSS NO.	SHT.	REV.
* Due To Excessive Cure Snd., 50pene Could Not Be placed in The proper Location and was partially cut off.		REVIEWER <i>John Petroske</i>		
		CERTIFIED NOT LEVEL (RT)		
		John Petroske RT II Exp. 01/08		

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		4/18/2006	361-03124
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		23525	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET ____ OF ____	
ASTM E94-93	MSS-SP-54-1999		

PART NUMBER	Serial No	View	No Apparent Indications		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejection	Inclusion	Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	
MCWF-B4	86-87	✓						3	2	✓	
	87-88	✓							2		
J.O. CC40851	88-89	✓							2		
	89-90	✓									
M183510	90-91	✓									
	91-92	✓									
Z103989	93-94	✓					2				
	94-95	✓									
	96-97	✓									
	97-98	✓									
	98-99	✓									
	99-100	✓									
	101-102	✓									*
	102-103	✓			1						
	103-104			R	1				R		
	104-105	✓									
	106-107	✓									
	107-108	✓			2						
	108-109	✓			1		1				
	109-110			R					R		
	110-111	✓									
	111-112	✓									
	112-113	✓									
	113A-114	✓									
	115-116			R					R		

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV. 1
0	1	13205		
COMMENTS		CUST. RSS NO.	SHT.	REV.
* Eliminated The 70+90 penes. Chill or Riser pad has been Arched off were these penes would have gone.		REVIEWER		
		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>4/18/2006</u>	<u>361-03124</u>
ADDRESS <u>8600 COMMERCIAL BLVD</u>		P.O. NUMBER	XRAY X
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>		<u>23525</u>	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 Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face		
MCWF-B4	117-118	✓													
	118-119	✓													
E.I.O. C040851	119-120	✓													
	120-121	✓			2										
M183510	121-122	✓													
	123-124	✓													
Z103989	124-125	✓													
	126-127	✓													
	127-128				R							R			

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	13205	SHT.	REV. 1
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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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		5/15/2006	361-03170
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER 23525	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	1	NO. REJECTED	0	MQS TECH. NO.	13205	SHT.	REV. 1
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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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		5/15/2006	361-03170
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER 23525	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	1	NO. REJECTED	0	MQS TECH. NO.	13205	SHT.	REV. 1
COMMENTS	Reshots			CUST. RSS NO.		SHT.	REV.
				REVIEWER	John Petroske		
				CERTIFIED NDT LEVEL (RT)	John Petroske RT II Exp. 01/08		