

# 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		3/21/2006	361-03040
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
			Accept- table	Reje- Incl- cted sion	or Por- Slag osity	Lack of Fusion Gas	Cracks	Hot Under Tears cut	Sur- face						
MCWF-B2		1-2	✓												
		2-3		R							R				
E.I.O. C040851		3-4		R							R				
		4-5	✓												
M581340		5-6	✓												
		6-7	✓					2							
Z103989		7-8	✓										✓		
		8-9	✓					2-3					✓		
		9-10	✓										✓		
		10-11	✓												
		11-12	✓												
		12-13	✓										✓		
		13-14		R							R				
		14-15	✓												
		15-16	✓												
		16-17	✓										✓		
		17-18	✓					2							
		18-19	✓												
		19-20	✓												
		20-21	✓										✓	✓	
		21-22	✓												
		22-23	✓												
		23-24	✓							1					
		24-25	✓											✓	
		25-26	✓												

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV. 1
	1	13205		
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

DATE 3/21/2006

WORK ORDER NO.  
361-03040

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- Incl- cted sion	or Por- Slag osity	Lack of Fusion Gas	Cracks	Hot Under Tears cut	Sur- face				
MCWF-B2		26-27	✓										
		27-28	✓										
E.I.O. C040851		28-29	✓										
		29-1	✓										
MS81340		30-31		R						R			
		31-32	✓										
Z103989		V33	✓										
		34-35	✓										
		36-37	✓									✓	
		V38	✓										
		39-40	✓										
		40-41	✓		2				1				
		42-43	✓										
		43-44	✓										
		V45	✓										
		46-47	✓										
		48-49	✓		1								
		49-50	✓										
		V51	✓										
		V51A	✓										
		52-53	✓										
		53-54	✓										
		54-55	✓										
		55-56	✓										
		56-57	✓										

NO. ACCEPTED

4

NO. REJECTED

1

COMMENTS

MQS TECH. NO.

13205

SHT.

REV. 1

CUST. RSS NO.

SHT.

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ASTM E94-93

ACCEPTANCE CRITERIA  
MSS-SP-54-1999

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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	
MCWF-B2	58-59	✓											
	59-60	✓							2				
E.I.O. C040851	60-61			R						R			
	61-62	✓							2				
M581340	62-63	✓							2				
	64	✓											
Z103989	63-65	✓							2				
	65-66	✓											
	66-67	✓							2				
	67-68	✓							2-3				
	69			R					R			✓	
	70-71	✓											
	71-72	✓											
	73-74	✓										✓	
	74-75	✓											
	75-76	✓										✓	
	77-78	✓										✓	
	78-79	✓											
	80-81	✓						2					
	81-82	✓											
	82-83			R					4				
	84-85			R					4				
	85-86			R					4				
	86-87	✓							1				
	87-88			R					3-4				

NO. ACCEPTED

Φ

NO. REJECTED

1

MQS TECH. NO.

13205

SHT.

REV. 1

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CUST. RSS NO.

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REV.

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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
			Accept- table	Reje- cted	Inclu- sion	or Slag	Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face		
MCWF-B2	88-89			R							4				
	89-90			R								R			
E.I.O. C040851	90-91	✓							2-3						
	91-92	✓													
M581340	93-94	✓													
	94-95			R	4			4							
Z103989	96-97	✓													
	97-98	✓													
	98-99	✓													
	99-100	✓			2										
	101-102	✓													
	102-103	✓													
	103-104			R							3-4				
	104-105			R							3-4				
	106-107	✓													
	107-108	✓													
	108-109	✓													
	109-110	✓													
	110-111	✓													
	111-112			R								R			
	112-113			R								R			
	113A-114			R								R			
	115-116			R								R			
	117-118	✓													
	118-119	✓													

NO. ACCEPTED

0

NO. REJECTED

1

MQS TECH. NO.

13205

SHT.

REV. 1

COMMENTS

CUST. RSS NO.

SHT.

REV.

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CERTIFIED MET LEVEL (RT)

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		3/21/2006	361-03040
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	

[illegible]

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	13205	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  
ADDRESS 8600 COMMERCIAL BLVD  
CITY PEVELY STATE MO ZIP 63070

WORK ORDER NO.  
361-03104

P.O. NUMBER  
Chuck Rudd

XRAY X

GAMMA

PROCEDURE SPECIFICATION  
ASTM E94-93

ACCEPTANCE CRITERIA  
MSS-SP-54-1999

SHEET                      OF

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	13205	SHT.	REV. 1
COMMENTS		CUST. RSS NO.		SHT.	REV.
		REVIEWER <i>John Petroske</i>			
		CERTIFIED NOT LEVEL (RT)			
		John Petroske RT II Exp. 01/08			

## RADIOGRAPHIC INTERPRETATION REPORT

FORM CC034



# RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>Energy Ind. of OHIO</u>	Pattern Number <u>MCWFB-2</u>
Material <u>CF8MNMV mod</u>	Traceability Number
Film Manufacturer <u>Fuji</u>	Source Number <u>21.5 ci co 60</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>60-61</u>	<u>89-90</u>	<u>94-95</u>	<u>115-116</u>								
Thickness (IN.)	<u>1 3/4"</u>	<u>2 1/4"</u>	<u>→</u>	<u>1 3/4"</u>								
S/F Distance (IN.)	<u>20"</u>	<u>→</u>	<u>→</u>	<u>→</u>								
Penetrameter	<u>30/100</u>	<u>50X2</u>	<u>→</u>	<u>30X2</u>								
Time (MIN.)	<u>17m</u> <u>1h 55m</u>	<u>9m</u>	<u>→</u>	<u>17m</u>								
Focal Spot (IN.)	<u>.1</u>	<u>→</u>	<u>→</u>	<u>→</u>								
Film Size (IN.)	<u>14X17</u>	<u>→</u>	<u>→</u>	<u>→</u>								
Screen Size (Pb)	<u>.01</u>	<u>→</u>	<u>→</u>	<u>→</u>								
Front/Back	<u>.01</u>	<u>→</u>	<u>→</u>	<u>→</u>								
S.W.E./D.W.E.	<u>SWE</u>	<u>→</u>	<u>→</u>	<u>→</u>								
S.W.V/D.W.V.	<u>SWV</u>	<u>→</u>	<u>→</u>	<u>→</u>								
Film Type	<u>29/80</u>	<u>80X2</u>	<u>→</u>	<u>29/59</u>								
Acceptance Standard	<u>E446</u> <u>E280</u>	<u>E186</u>	<u>→</u>	<u>E446</u>								
Severity Level	<u>see spec</u>											

Shooting Sketch (Use Additional Pages as Needed)

view 60-61 is shot with 29 film for 30pene  
Then shoot a seperate shot with 80 film for 100pene.

Technique Prepared By: Doug Midgett Level: II  
Technique Approved By: \_\_\_\_\_ Level: \_\_\_\_\_

Date: 4-18-06  
Date: \_\_\_\_\_