

# TEAM COOPERHEAT-MQS, INC.

## RADIOGRAPHIC TECHNIQUE SHEET

FORM 20.3-61 Rev. 4

5512 W. State St-Milwaukee, WI 53208 (414) 771-3060 Fax (414)771-9481 (800) 818-6403 www.cooperheat-mqs.com

CUSTOMER RSS NO.: \_\_\_\_\_ SHEET: \_\_\_\_\_ REV: \_\_\_\_\_ MQS TECH. NO.: 13043  
 MQS RSS NO.: \_\_\_\_\_

CUSTOMER METALTEK INTERNATIONAL / CARONDOLET DIV. DATE: 6/16/2005  
 PART NO. MCWF-A DESCRIPTION A-COIL MATERIAL SS  
 TOTAL NUMBER OF VIEWS 117 NUMBER X-RAY VIEWS 117 NUMBER GAMMA RAY VIEWS 0  
 MACH(s) MAKE(s) VARIAN MODEL(s) L2000 S/N(s) 20 MAX KV(s) 7500  
 SOURCE(s) N/A  
 PROCEDURE SPECIFICATION ASTM E94-93 ACCEPTANCE CRITERIA MSS-SP-54-1999  
 MQS PROCEDURE NO. 20.H.010 REV. 0 PENETRATOR SPEC. ASTM E142-86  
 PROCESSING: AUTOMATIC  PROCESSOR B2000 MANUAL \_\_\_\_\_ TEMPERATURE 27.5°  
 TECHNICIAN JP,SS,ST NDT LEVEL II APPROVED BY C RUDOLPH NDT LEVEL III

VIEW IDENTIFICATION	SEE ATTACHED				
SOURCE/X-RAY MACH USED	VARIAN				
CURIES OR KV	7500 KV				
MA OR PULSES	N/A				
SOURCE TO FILM DISTANCE	*				
EXPOSURE TIME OR RADS	*				
MATERIAL THICKNESS	*				
MATERIAL GROUP	1				
PENETRATOR SIZE/(AMT)	GP. 1	*			
SHIM BLOCK SIZE	GP. <input type="checkbox"/>	N/A			
FILM SIZE	*				
FILM TYPE/BRAND	*				
PB SCREEN, FRONT	.010				
PB SCREEN, BACK	.010				
SENSITIVITY	2-2T				
FILTER TYPE/LOCATION	N/A				
MASKING TYPE/LOCATION	N/A				
ANGLE	N/A				
NO. OF FILMS IN CASSETTE	*				
VIEWING: SING./DOUB./BOTH	B				
FOCAL SPOT SIZE	2 MM				
SKETCH AND/OR REMARKS	*				
GEOMETRIC UNSHARPNESS	N/A				

\*\*ATTACHED PHOTOS PG. 1-15

CUSTOMER: METALTEK INT./CARONDOLET RSS # 13043 PART NO. MCWF-A

**RAIL**

VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
1-2	58"	62 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
2-3	58"	62 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
3-4	60"	62 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
4-5	65"	80 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
5-6	54"	70 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
6-7	50"	52 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
7-8	54"	70 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
8-9	56"	70 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
9-10	60"	75 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
10-11	65"	80 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
11-12	70"	80 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
12-13	77"	90 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
13-14	77"	90 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
V15	60"	65 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
16-17	60"	60 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
17-18	60"	60 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
18-19	60"	60 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
19-20	60"	60 KR	AA-M100-T	14 X 17	2.75 - 5.5	50(2), 80, 100
20-21	61"	56 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80, 100
21-22	57"	62 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80, 100
22-23	65"	60 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80, 100
23-24	65"	72 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80, 100
24-25	65"	60 KR	AA-M100	14 X 17	2.75 - 5.0	50(2), 80
25-26	65"	75 KR	AA-M100-T	14 X 17	2.75 - 7.0	50(2), 80, 100, 120
26-27	65"	75 KR	AA-M100-T	14 X 17	2.75 - 7.0	50(2), 80, 100, 140
27-28	65"	60 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80, 100
28-29	65"	60 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80
29-1	65"	60 KR	AA-M100	14 X 17	2.75 - 5.5	50(2), 80, 100

CUSTOMER METALTEK INT./CARONDOLET RSS # 13043 PART NO. MCWF-A

VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
30-31	75"	35 KR	T	14 X 17	2.75"	50 (2)
31-32	75"	35 KR	T	14 X 17	2.75"	50 (2)
32-33	75"	35 KR	T	14 X 17	2.75"	50 (2)
33-34	75"	35 KR	T	14 X 17	2.75"	50 (2)
34-35	75"	35 KR	T	14 X 17	2.75"	50 (2)
35-36	75"	35 KR	T	14 X 17	2.75"	50 (2)
37-38	75"	35 KR	T	14 X 17	2.75"	50 (2)
38-39	75"	35 KR	T	14 X 17	2.75"	50 (2)
39-40	75"	35 KR	T	14 X 17	2.75"	50 (2)
41-42	75"	90 KR	AA-M100-T	14 X 17	2.75 X 5.5"	50 (2), 100 (2)
43-44	75"	90 KR	AA-M100-T	14 X 17	2.75 X 5.5"	50 (2), 100 (2)
44-45	75"	75 KR	AA-M100	14 X 17	2.75 X 5.5"	50 (2), 100 (2)
45-46	75"	75 KR	AA-M100	14 X 17	2.75 X 5.5"	50, 100 (2)
46-47	75"	75 KR	AA-AA	14 X 17	5.5"	100 (2)
47-48	75"	75 KR	AA-AA	14 X 17	5.5"	100 (2)
48-49	75"	75 KR	AA-AA	14 X 17	5.5"	100 (2)
50-51	75"	35 KR	T	14 X 17	2.75"	50 (2)
51-52	75"	35 KR	T	14 X 17	2.75"	50 (2)
52-53	75"	35 KR	T	14 X 17	2.75"	50 (2)
54-55	75"	35 KR	T	14 X 17	2.75"	50 (2)
55-56	75"	35 KR	T	14 X 17	2.75"	50 (2)
57-58	97"	45 KR	M125-T	14 X 17	1.5 - 1.75"	30, 35
58-58A-59	80"	110 KR	D8-R50-T-D8	14 X 17	1.5 - 8"	30, 100, 140, 160
59-60	80"	30 KR	M125-T	14 X 17	1.5"	30 (2)
60-61	80"	30 KR	M125-T	14 X 17	1.5"	30 (2)
61-62	80"	30 KR	M125-T	14 X 17	1.5"	30 (2)
62-63	85"	90 KR	D8-M125-D8	14 X 17	3 - 8"	60, 120, 160
62A-63A	85"	90 KR	D8-M125-Dumb	14 X 17	3 - 6"	60, 120
63-64	80"	45 KR	AA-M125-M100-T	14 X 17	1.5 - 4"	30 (2), 50, 80
64-65	80"	45 KR	M125-M100	14 X 17	1.5"	30 (2)
65-65A-66	80"	95 KR	AA-M125-T	14 X 17	1.5 - 5.5"	30, 100 (2)
66-67	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
67-68	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
68-69	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
69-70	80"	40 KR	AA-M100-T	14 X 17	1.5 - 3"	30 (2), 50, 60
70-71	80"	40 KR	AA-M100-T	14 X 17	1.5 - 4"	30 (2), 60, 80
71-72	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
72-73	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
73-74	80"	60 KR	AA-AA	14 X 17	3 - 6"	60, 100, 120
74-75	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
75-76	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
76-77	80"	40 KR	M125-M100	14 X 17	1.5"	30 (2)
77-78	80"	150 KR	D8-AA-T-D8	14 X 17	3 - 8"	60, 80, 100, 120, 160
78-79	80"	40 KR	AA-M125-T	14 X 17	1.5 - 3"	30 (2), 40, 60
79-80	85"	50 KR	T/M100	14 X 17	1.5 - 3"	30 (2), 40, 50, 60
80-81	80"	40 KR	T/M100	14 X 17	1.5 - 2.5"	30 (2), 40, 50

Form 20.4 - 61 Attachment A

CUSTOMER METALTEK INT./CARONDOLET RSS # 13043 PART NO. MCWF-A

VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
81-82	80"	40 KR	T-M100	14 X 17	1.5 - 2.5"	30(2),40,50
82-83	80"	40 KR	T-M100	14 X 17	1.5 - 2.50"	30(2),40,50
84-85	75"	90 KR	D8-R50-M125-T	14 X 17	1.5 - 6"	30,50,60,80,100,120
85-86	75"	60 KR	T-R50-M125	14 X 17	1.5 - 4"	30,40,50,60,80
86-87	75"	60 KR	AA-M125-T	14 X 17	1.5 - 5"	30, 50, 60, 80, 100
87-88A	70"	60 KR	AA-M125-T	14 X 17	3" - 5"	60,80,100
88-89	80"	40 KR	M125-M100	14 X 17	1.5"	30(2)
89-90	80"	40 KR	M125-M100	14 X 17	1.5"	30(2)
90-91	80"	40 KR	M125-M100	14 X 17	1.5"	30(2)
92-93	65"	30 KR	T-M125	14 X 17	1.5 - 3"	30(2),40,60
94-95	84"	40 KR	T	14 X 17	2.75"	50(2)
95-96	84"	40 KR	T	14 X 17	2.75"	50(2)
96-97	84"	40 KR	T	14 X 17	2.75"	50(2)
97-98	84"	40 KR	T	14 X 17	2.75"	50(2)
98-99	84"	40 KR	T	14 X 17	2.75"	50(2)
99-100	84"	40 KR	T	14 X 17	2.75"	50(2)
100-101	84"	40 KR	T	14 X 17	2.75"	50(2)
102-103	84"	40 KR	T	14 X 17	2.75"	50(2)
103-104	84"	40 KR	T	14 X 17	2.75"	50(2)
104-105	84"	40 KR	T	14 X 17	2.75"	50(2)
106-107	84"	40 KR	T	14 X 17	2.75"	50(2)
107-108	84"	40 KR	T	14 X 17	2.75"	50(2)
108-109	84"	40 KR	T/M125	14 X 17	1.5 - 2.75"	30,50(2)
109-110	84"	40 KR	T/M125	14 X 17	1.5 - 2.75"	30,50(2)
111-112	84"	40 KR	T	14 X 17	2.75"	50(2)
112-113	84"	40 KR	T	14 X 17	2.75"	50(2)
113-114	84"	40 KR	T	14 X 17	2.75"	50(2)
115-116	84"	40 KR	T	14 X 17	2.75"	50(2)
116-117	84"	40 KR	T	14 X 17	2.75"	50(2)
118-119	80"	55 KR	M125/M100	14 X 17	1.5"	30(2)
119-120	80"	55 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
121-122	80"	40 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
122-123	80"	40 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
123-124	80"	40 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
124-125	80"	40 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
125-126	80"	40 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
126-127	80"	40 KR	M125/M100	14 X 17	1.5 - 2"	30(2), 40
127-128	80"	50 KR	D8/M100/M125	14 X 17	1.5 - 6"	30(2),120
128-129	80"	40 KR	M125/M100	14 X 17	1.5"	30(2)
130-131	80"	40 KR	M125/M100	14 X 17	1.5"	30(2)
131-132	80"	40 KR	M125/M100	14 X 17	1.5"	30(2)
V133	80"	50 KR	D8/M125/AA	7 X 17	1.5 - 6"	30(2),120,140
V134	80"	50 KR	D8/M125/AA	7 X 17	1.5 - 6"	30(2),120,140

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