

C-2 COIL WELD MAP

X-RAY View < 1.02

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	MAG Permeability Executions
1	18	2 1/2	1 3/4	1/2	NO	17	OK
2	18	1 1/2	3/4	1/8	NO	17	OK
3	18	2 3/4	1 1/4	3/8	NO	7	OK
4	18	2	1 1/2	1/4	NO	7	OK
5	18	2 7/8	1 1/4	3/8	NO	7	OK
6	18	3/4	1/2	3/8	NO	7	OK
7	18	7	1 1/2	3/8	NO ✓	7	OK
8	18	2 1/4	1 1/2	5/8	NO	8	OK
9	18	2 3/4	1 1/4	1/4	NO	8	OK
10	18	3 1/2	1 1/4	1/4	NO	8	OK
11	18	13 1/4	1	3/8	NO	10	OK
12	18	4	3	1/2	NO ✓	11	OK
13	18	13 1/2	3 3/4	1/2	YES ✓	11	OK
14	18	2 1/2	1 1/2	1/8	NO	11	OK
15	18	2 3/4	1	1/4	NO	53	OK
16	18	2 1/2	1 1/2	3/4	NO	53	OK
17	18	4	2 1/2	1/2	NO ✓	54	OK
18	18	2	2	1	YES ✓	54	OK
19	19	1 1/2	3/4	3/4	NO	56	OK
20	19	2	1 1/4	1	YES ✓	57	OK
21	19	6	4	1 1/4	YES ✓	58	OK
22	19	2 3/4	2	7/8	YES	36	OK
23	19	3 1/2	2 7/8	1/4	NO	36	OK
24	19	2 1/2	1 3/4	1/4	NO	36	OK
25	19	5	1	5/8	NO	36	OK
26	19	2	1 5/8	1/2	NO	68	OK
27	19	13 1/4	1 1/2	1/4	NO	69	OK
28	19	6	5	1/4	NO ✓	69	OK
29	19	2	2	1/4	NO	30	OK
30	19	4 7/8	3 3/4	1/4	NO ✓	30	OK
31	19	7	4	7/8	YES ✓	30	OK
32	19	2 1/4	2	1/4	NO	30	OK
33	20	2	1	1/4	NO	30	OK
34	20	2	1 1/4	1/4	NO	41	OK
35	20	2 1/2	2	1/4	NO	41	OK

C-2 COIL WELD MAP

X-RAY TESTED

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
36	20	2	1	1/8	NO	41	OK
37	20	1 1/2	1	1/8	NO	41	OK
38	20	2	1 1/2	3/8	NO	41	OK
39	20	4 1/2	2	1/4	NO	42	OK
40	20	2 1/2	1 1/2	3/8	NO	44	OK
41	21	3	1 1/2	1/4	NO	46	OK
42	21	2 1/2	2 1/2	1/4	NO	46	OK
43	21	3 1/4	3	1/2	NO	5	OK
44	21	2 1/2	3/4	1/2	NO	6	OK
45	21	3 1/4	1	1/4	NO	6	OK
46	22	8 3/4	2	1/4	NO ✓	11	OK
47	22	8	2 1/2	1/4	YES ✓	12	OK
48	22	6	3	1/4	NO ✓	52	OK
49	22	2	1 1/2	1/4	NO	53	OK
50	22	4	2	1/4	NO	53	OK
51	22	2 1/2	2	1/8	NO	12	OK
52	22	3 1/2	2 1/2	1	YES ✓	62	OK
53	22	4 1/2	4	1	YES ✓	13	OK
54	22	1	1	1/4	NO	13	OK
55	22	6 3/4	2 1/2	1/2	YES ✓	13	OK
56	22	1	1	1/4	NO	12	OK
57	22	1 1/2	1	1/4	NO	12	OK
58	22	3 1/2	2	1/8	NO	12	OK
59	22	6 3/4	1	1/8	NO	14	OK
60	22	1 1/2	1 1/2	3/4	YES ✓	16	OK
61	22	4 1/2	3 1/2	1/4	NO ✓	16	OK
62	22	20	5	1	YES ✓	16	OK
63	22	13	4	3	YES ✓	16	OK
64	22	3/4	1/2	1/8	NO	55	OK
65	22	2 1/2	2	1/4	NO	55	OK
66	22	3/4	1/2	1/8	NO	55	OK
67	22	10 1/2	4 1/4	2	YES ✓	58	OK
68	23	3/4	1/2	1/8	NO	59	OK
69	23	4 1/2	3	1/4	NO ✓	60	OK
70	23	3	1 1/2	1/4	NO	60	OK
71	23	3	1	1/2	YES	60	OK
72	23	1	1	1/4	NO	17	OK

C-2 COIL WELD MAP

X-RAY VIEW

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
73	23	7 1/4	1/4	1/8	NO	17	OK
74	23	1 1/2	1 1/2	5/4	YES	18	OK
75	23	3/4	3/4	1/8	NO	18	OK
76	23	2	1/2	3/16	NO	18	OK
77	23	4	2 1/2	1/2	YES	18	OK
78	23	1	1/2	1/4	NO	18	OK
79	23	2 1/2	2	1/4	NO	19	OK
80	23	7	3	3/8	YES ✓	61	OK
81	23	2 1/2	2	1/4	NO	67	OK
82	23	1 1/2	1 1/2	1/4	NO	61	OK
83	23	4	2 1/2	5/8	NO	61	OK
84	23	2	1/2	1/4	NO	67	OK
85	23	1 1/2	1	3/4	NO	67	OK
86	23	7 1/2	5	3	YES ✓	19	OK
87	23	3 1/2	2	1/4	NO	68	OK
88	23	4	2 1/2	5/8	NO	20	OK
89	23	3 1/2	3	1/2	YES	20	OK
90	23	2 1/2	2	1/4	NO	20	OK
91	23	2	3/4	1/4	NO	69	OK
92	23	9	4	1	YES ✓	70	OK
93	23	1 1/2	1	1/4	NO	70	OK
94	23	4	3	1 1/4	NO ✓	70	OK
95	23	4 1/8	4	1/4	NO ✓	21	OK
96	23	6	3	1/4	NO ✓	22	OK
97	23	3	2 1/2	3/4	YES	22	OK
98	23	2 1/2	1	3/4	YES	22	OK
99	23	4	4	1 1/4	YES ✓	24	OK
100	23	2 1/2	2 1/2	1/2	NO	24	OK
101	23	2 1/2	2 1/2	1 1/2	YES ✓	24	OK
102	23	2 1/2	2 1/2	1/2	YES	24	OK
103	23	2	1	1/4	NO	26	OK
104	23	24	6	1	YES ✓	26	OK
105	24	3	2	1/4	NO	26	OK
106	24	2 1/2	1 1/2	3/4	YES	28	OK
107	24	1	1	1/4	NO	28	OK
108	24	3/4	3/4	1/8	NO	28	OK
109	24	6	3	1	YES ✓	28	OK

C-2 COIL WELD MAP

X-RAY VIEW

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
110	24	1	1	1/8	NO	1	OK
111	24	8	5	1	YES ✓	1	OK
112	24	7	4	1	YES ✓	1	OK
113	24					1	OK
114	24	2 1/2	2	1	YES ✓	2	OK
115	24	3 1/2	7/8	3/4	YES	2	OK
116	24	5	3	3/4	YES	2	OK
117	24	1 1/2	1 1/2	1/4	NO	3	OK
118	24	2 1/2	1 3/4	1/4	NO	3	OK
119	24	10	5	1	YES ✓	3	OK
120	24						OK
121	24	1	1/2	1/2	YES	43	OK
122	24	10	2 1/2	1 3/4	YES ✓	43	OK
123	24	2 1/2	2	1/4	NO	44	OK
124	24	2	1 1/2	1/2	YES	44	OK
125	24	3	2 3/4	1	YES ✓	44	OK
126	24	4 1/2	3 1/2	3/4	YES ✓	50	OK
127	24	1 1/2	1	1/4	NO	50	OK
128	24	4	2 1/2	1/4	NO	50	OK
129	24	2	1 1/2	1/4	NO	45	OK
130	24	2	1	1/4	NO	51	OK
131	24	2	1/2	1/4	NO	51	OK
132	25	1 1/2	1	1/4	NO	90	OK
133	25	2 1/2	1	1/2	YES	90	OK
134	25	3	1	1/2	YES	89	OK
135	25	2 1/2	2	1/2	YES	89	OK
136	25	2	1	1/4	NO	89	OK
137	25	1	1	1/4	NO	88	OK
138	25	2	1	1/4	NO	88	OK
139	25	7	5 1/2	1/2	YES ✓	88	OK
140	25	2	1	1/4	NO	88	OK
141	25	5	2	1/2	YES ✓	87	OK
142	25	2 1/2	2	1/4	NO	87	OK

C-2 COIL WELD MAP

X-RAY VIEW

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
143	25	5	2 3/4	1/8	NO	93	OK
144	25	5	2 1/2	1/4	NO	93	OK
145	25	1 1/2	1	1/8	NO	93	OK
146	25	3	2 1/2	1/4	NO	93	OK
147	25	3	2 1/2	1/4	NO	92	OK
148	25	12	3	1	YES	85	OK
149	26	1 1/2	1	1/4	NO	14	OK
150	26	3	2	1/8	NO	115	OK
151	26	6	2	1/8	NO	14	OK
152	26	1 1/2	1 1/2	1	YES	14	OK
153	26	3	1 1/2	1/8	NO	13	OK
154	26	2 3/4	1	1/8	NO	13	OK
155	26	3	1 1/2	1	YES	117	OK
156	26	2	1	1/4	NO	36	OK
157	26	2	1	1/2	YES	36	OK
158	26	2	1	1/4	NO	36	OK
159	26	3	2 3/4	1 1/2	YES	30	OK
160	26	3	2	5/8	YES	39	OK
161	26	6	2	1	YES	39	OK
162	26	4 1/2	1	3/4	YES	39	OK
163	27	1	1/2	1/2	YES	97	OK
164	27	2 1/2	1	1/8	NO	97	OK
165	27	2	1 1/4	1/4	NO	37	OK
166	27	3	2	1/4	NO	36	OK
167	27	1 1/2	1	1/8	NO	35	OK
168	27	3	2	1/8	NO	35	OK
169	27	13	2	1 3/4	YES	35	OK
170	27	2	1	1/2	YES	39	OK
171	27	2	1	1/8	NO	39	OK
172	27	2 1/2	1 3/4	1/4	NO	38	OK
173	27	2	1	1/8	NO	38	OK
174	27	2	1	1/8	NO	38	OK
175	27	3	2 1/2	1/8	NO	8	OK
176	27	2	1	1/8	NO	8	OK
177	27	2	2	1/8	NO	8	OK

C-2 COIL WELD MAP

X-RAY VIEW

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
178	27	3	1 3/4	1/4	NO	100	OK
179	27	2	1	1/8	NO	100	OK
180	27	3 1/2	2	1/4	NO	100	OK
181	27	3	1/4	1/8	NO	101	OK
182	27	4	2	1/4	NO	101	OK
183	27	3	2	1/2	YES	102	OK
184	27	1	1	1/4	NO	103	OK
185	27	2 3/4	1	1	YES ✓	104	OK
186	27	1	1	1/4	NO	105	OK
187	27	2	1	1/4	NO	23	OK
188	27	3 1/2	2	1/4	NO	24	OK
189	27	3	2	1/4	NO	25	OK
190	27	2 1/2	2	1/4	NO	100	OK
191	27	2 1/2	1	3/4	YES	100	OK
192	27	4	3	1/2	YES ✓	100	OK
193	27	8	1 1/2	1	YES ✓	100	OK
194	27	19	2	1/2	YES ✓	100	OK
195	27	2 3/4	2	1/2	YES	100	OK
196	27	6	1 3/4	2	YES ✓	5	OK
197	27	1 1/2	1	1/2	YES	5	OK
198	27	3	2	1/4	NO	5	OK
199	27	2	1 1/4	1/4	NO	5	OK
200	27	4	3	1/4	NO ✓	5	OK
201	27	1 1/2	1	1/2	YES	101	OK
202	27	7 3/4	2	1	YES ✓	102	OK
203	27	6 3/4	1 1/2	1/2	YES	102	OK
204	27	3	2	1/2	YES	102	OK
205	27	2	1 1/4	1/4	NO	103	OK
206	27	4	2	1/4	NO	103	OK
207	27	2	1 1/2	1/4	NO	103	OK
208	27	1	1	1/4	NO	103	OK
209	27	3 1/2	1 1/2	1	YES ✓	4	OK
210	27	1	3/4	1/4	NO	4	OK
212	27	4	2 1/2	1/4	NO	3	OK
213	27	6	2 1/2	3/4	YES ✓	34	OK
214	27	4	2	3/4	YES	34	OK

C-2 COIL WELD MAP

X-RAY VIEW

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
215							
216	27	3 1/2	1	3/4	YES	31	OK
217	27	2	2	1	YES ✓	2	OK
218	27	2	1	3/4	YES	33	OK
219	27	2	1	1/4	NO	2	OK
220	28	3	1	1	YES ✓	106	OK
221	28	5	4	1/4	NO ✓	23	OK
222	28	4	1	1/4	NO	23	OK
223	28	13	4	1/2	YES ✓	24	OK
224	28	2	1	1/4	NO	24	OK
225	28	9 1/2	7	1/2	YES ✓	22	OK
226	28	3	1 1/4	1/2	YES	20	OK
227	28	1 1/2	1	1/4	NO	20	OK
228	28	1 1/2	1	1/4	NO	19	OK
229	28	2 1/2	1	1	YES ✓	109	OK
230	29	6	2	1 1/2	YES ✓	17	OK
231	29	7	1 1/2	3/4	YES	17	OK
232	29	3	1 1/4	3/4	YES	17	OK
233	29	3	1 1/4	3/4	YES	17	OK
234	29	3	2	1/8	NO	15	OK
235	30	1 1/2	3/4	1/4	NO	15	OK
236	30	1	3/4	1/8	NO	15	OK
237	30	2	3/4	1/4	NO	15	OK
238	30	2	1	1/4	NO	15	OK
239	30	1 3/4	1	1/4	NO	15	OK
240	30	8 1/8	3 3/4	1/4	YES ✓	15	OK
241	30	3	1/4	1/8	NO	11	OK
242	31	1/2	1/2	1/8	NO	11	OK
243	31	1 1/2	1 1/2	1/4	NO	11	OK
244	31	1/2	1/2	1/4	NO	112	OK
245	31	6	1	3/4	YES	11	OK
246	31	9	2	1/4	YES ✓	112	OK
247	22	8 3/8	3 3/4	1/2	YES ✓	14	OK
248	22 A	1	1	1/2	NO	14	OK
249	22 A	1	1	1/2	NO	14	OK
250	22 A	1	1	1/2	NO	14	OK
251	22 A	5 1/2	1 1/2	1/8	NO	64	OK

C-2 COIL WELD MAP

X-RAY VIEW

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result	
252	22 A	2 1/2	2 1/4	1/4	NO	64	OK
253	22 A	9	4 1/2	1/2	YES ✓	64	OK
254	22 A	13	2 1/4	1/2	YES ✓	63	OK
255	22 A	1	7	1/8	NO	63	OK
256	22 A	1	1	1/8	NO	63	OK
257	22 A	1 1/2	1	1/8	NO	63	OK
258	23 A	1	1/2	1/8	NO	63	OK
259	23 A	4	1	1/8	NO	63	OK
260	23 A	1 1/2	1	1/4	NO	63	OK
261	23 A	6 1/2	5 1/2	1/2	YES ✓	63	OK
262	24 A	2 1/2	1	1/4	NO	63	OK
263	24 A	8	2 3/4	3/4	YES ✓	63	OK
264	24 A	10	4 1/4	1/2	YES ✓	63	OK
265	24 A	2 1/2	1 1/2	1/2	NO	63	OK
266	24 A	2 1/2	1 1/2	1/2	NO	62	OK
267	24 A	2 1/4	1	1/4	NO	62	OK
268	24 A	6 1/2	4 1/2	1	YES ✓	62	OK
269	24 A	6 1/2	3 3/4	3/4	YES ✓	62	OK
270	24 A	13 1/2	3 3/4	3/4	YES ✓	71	OK
271	24 A	7	3/4	1/2	NO	71	OK
272	25 A	9	2	1/2	NO ✓	10	OK
273	25 A	7	2 1/2	1/2	NO ✓	83	OK
274	25 A	17	1	3/4	YES ✓	71	OK
275	25 A	9 3/4	3/4	3/4	YES	72	OK
276	25 A	4	4	3/4	YES ✓	72	OK
277	25 A	14	2 1/4	1 1/2	YES ✓	74	OK
278	25 A	2	1	1/4	NO	75	OK
279	25 A	2	1 1/2	1/4	NO	75	OK
280	25 A	2 1/4	1 1/2	1/4	NO	75	OK
281	25 A	6 1/2	3/4	3/4	YES	82	OK
282	26 A	4	3/4	1/4	NO	76	OK
283	26 A	1	1/4	1/8	NO	77	OK
284	26 A	3	2	1/8	NO	4	OK

X-RAY VIEW

4/1/05

C-2 COIL WELD MAP #2

Submitted 6-15-05 C. Ruud

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Rt View
295	1	4 1/2"	3 1/4"	7/8"	Y	92-93

Photo 1

