

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

03/04/2006

WORK ORDER NO.

361-03001-2

P.O. NUMBER

23292

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
			Acceptable	Rejected	Inclusion	Slag	Porosity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Surface					
MCWFA-6		1-2	✓															
		2-3	✓															
Z103990		3-4	✓															
HT# M176210		4-5	✓															
CO 40851		5-6	✓							3								
		6-7	✓							1								
		7-8	✓							1								
		8-9	✓															
		9-10	✓															
		10-11			R	5												
		11-12	✓															
		12-13	✓															
		13-14	✓															
		14-15	✓										1					
		16-17	✓															
		17-18	✓														✓	
		18-19	✓															
		19-20	✓														✓	
		20-21	✓							2								
		21-22	✓							1		1-2					✓	
		22-23	✓							1		1-2						
		23-24	✓			2											✓	
		24-25	✓							1-2								
		25-26	✓							1								*

NO. ACCEPTED

0

NO. REJECTED

1

MQS TECH. NO.

12970

SHT.

REV.

COMMENTS

* 120 Para Not in View. Area for this Para on Next View.

CUST. RSS NO.

SHT.

REV.

REVIEWER

John Petroske
 CERTIFIED NDT LEVEL (RT)

John Petroske RT II Exp. 01/08

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NAME <u>METAL TEK INTERNATIONAL</u>		<u>03/04/2006</u>	361-03001-2
ADDRESS <u>8600 COMMERCIAL BLVD</u>		P.O. NUMBER 23292	XRAY X
CITY <u>PEVELY</u> STATE <u>MO</u> ZIP <u>63070</u>			GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET <u>2</u> OF <u>6</u>	

[illegible]

NÖ. ACCEPTED	NO. REJECTED	MQS TECH. NO.	12970	SHT.	REV.
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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PROCEDURE SPECIFICATION
 ASTM E94-93

ACCEPTANCE CRITERIA
 MSS-SP-54-1999

SHEET 3 OF 6

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Accept- table	Reje- Inclu- cted sion	or Por- Slag osity	Lack of Fusion Gas Cracks	Hot Under Sur- Tears cut face						
MCWFA-6		36-31	✓			2							
		31-32	✓										
Z103990		32-33		R	5								
HT# M176210		33-34	✓										
CO 40851		34-35	✓									✓	
		35-36		R						R			✓
		37-38	✓									✓	
		38-39	✓					1					
		39-40	✓										
		41-42		R	4								
		43-44	✓										
		44-45		R				4				✓	
		45-46	✓										
		46-47	✓										
		47-48	✓										
		48-49	✓										
		50-51	✓										
		51-52	✓										
		52-53	✓									✓	
		54-55	✓									✓	
		55-56		R				2	4				
		57-58	✓										
	58-59	58-59		R						R			
		59-60	✓										
		60-61	✓										

NO. ACCEPTED

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 MSS-SP-54-1999

SHEET 4 OF 6

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 Under Tears	Sur- face		
MCWFA-6		61-62	✓										
		62-63		R						R			
Z103990	62A-63A	✓											
HT# M176210	63-64			R				4					
CO 40851	64-65	✓											
	65-65A-66	✓										✓	
	66-67	✓										✓	
	67-68	✓										✓	
	68-69	✓										✓	
	69-70			R					4				
	70-71	✓										✓	
	71-72			R					3-4				
	72-73	✓						1				✓	
	73-74	✓											
	74-75	✓											
	75-76	✓										✓	
	76-77			R					4				
	77-78	✓							*				See 76-77
	78-79	✓			2-3								
	79-80	✓											
	80-81	✓										✓	

NO. ACCEPTED

0

NO. REJECTED

1

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John Petroske RT II Exp. 01/08

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DATE

03/04/2006

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P.O. NUMBER

23292

XRAY

X

GAMMA

PROCEDURE SPECIFICATION
 ASTM E94-93

ACCEPTANCE CRITERIA
 MSS-SP-54-1999

SHEET 5 OF 6

PART NUMBER	Serial No	View	No Apparent Indications		Dross		Incomplete Penetration		Shrinkage		Hot Under Tears cut		Film Artifacts		REMARKS
			Accep- table	Reje- cted	Inclu- sion	or Slag	Por- osity	Lack of Fusion	Gas	Cracks					
MCWFA-6	81-82	✓			2					2			✓	✓	
	82-83	✓								2			✓		
Z103990	84-85	✓											✓	✓	
HT# M176210	85-86	✓											✓		
CO 40851	86-87	✓											✓		
	87-88	✓													
	89-90	✓													
	90-91	✓													
	92-93	✓											✓		
	94-95	✓								2-3					
	95-96				R					4					
	96-97				R					4					
	97-98				R					4					
	98-99	✓													
	99-100				R					4					
	100-101	✓													
	102-103	✓								2					
	103-104	✓								2					
	104-105	✓								2					
	106-107				R	4-5									
	107-108	✓													
	108-109	✓								3			✓		
	109-110				R					4			✓	✓	
	111-112	✓				1-2									
	112-113	✓							1-2						

NO. ACCEPTED

4

NO. REJECTED

1

MQS TECH. NO. 12970

SHT.

REV.

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

John Petroske
 CERTIFIED NOT LEVEL (RT)

John Petroske RT-II Exp. 01/08

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		03/04/2006	361-03001-2
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		23292	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET 6 OF 6	
ASTM E94-93	MSS-SP-54-1999		

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	
MCWFA-6	113	114	✓							1			
	115	116	✓							2			
Z103990	116	117	✓							3			
HT# M176210	118	119	✓									✓	
CO 40851	119	120	✓						2				✓
	121	122	✓										
	122	123	✓										✓
	123	124	✓										
	124	125	✓							2			✓
	125	126			R					2	R		
	126	127	✓									✓	
	127	128	✓										
	128	129	✓						2	2			
	130	131	✓										
	131	132	✓										
	V133		✓										
	V134		✓										
	88-89		✓										

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		REVIEWER	John Petroske		
		CERTIFIED NOT LEVEL (RT)			
		John Petroske RT II Exp. 01/08			

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CUSTOMER

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

DATE

04/1/2006

WORK ORDER NO.

361-03094

P.O. NUMBER

23292

XRAY X

GAMMA

PROCEDURE SPECIFICATION
 ASTM E94-93

ACCEPTANCE CRITERIA
 MSS-SP-54-1999

SHEET OF

PART NUMBER	Serial No	View	No Apparent Indications	Rejection	Inclu- sion	Dross	or Por- osity	Incomplete Penetration	Lack of Fusion	Gas	Shrinkage Cracks	Hot Under Tears	Sur- face	Film Artifacts	REMARKS
MCWFA-6	R1	10-11	✓												
		32-33	✓												
Z103990		35-36	✓												
HT# M176210		41-42	✓												
CO 40851		44-45	✓								2-3				
		55-56	✓								1				
		58-59	✓												
		62-63	✓												
		63-64									4				
		69-70	✓												
		71-72										4			
		76-77	✓												
		95-96	✓												
		96-97	✓									2			
		97-98	✓												
		99-100										4			
		101-102	✓												
		109-110	✓												
		125-126	✓									1			

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RADIOGRAPHIC INTERPRETATION REPORT

FORM CC034



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>E.I.O.</u>	Pattern Number <u>MCWFA-6</u>
Material <u>CF8M/N/MoA</u>	Traceability Number
Film Manufacturer <u>FUJI</u>	Source Number <u>CO</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>6364</u>	<u>71-72</u>	<u>99-100</u>									
Thickness (IN.)	<u>1 1/2" x 4"</u>	<u>1 1/2"</u>	<u>2 3/4"</u>									
S/F Distance (IN.)	<u>20"</u>	<u>→</u>	<u>→</u>									
Penetrameter	<u>30x2</u> <u>50 80</u>	<u>30x2</u>	<u>x2</u> <u>50</u>									
Time (MIN.)	<u>2 min</u>	<u>5W45s</u>	<u>8W25s</u>									
Focal Spot (IN.)	<u>.1</u>	<u>→</u>	<u>→</u>									
Film Size (IN.)	<u>14x17</u>	<u>→</u>	<u>→</u>									
Screen Size (Pb)	<u>.01</u>	<u>→</u>	<u>→</u>									
Front/Back	<u>SWE</u>	<u>→</u>	<u>→</u>									
S.W.E./D.W.E.	<u>SWV</u>	<u>→</u>	<u>→</u>									
S.W.V/D.W.V.	<u>29</u> <u>59 80</u>	<u>80</u>	<u>→</u>									
Film Type	<u>E444</u> <u>E186</u>	<u>→</u>	<u>→</u>									
Acceptance Standard	<u>See Spec</u>	<u>→</u>	<u>→</u>									
Severity Level												

Shooting Sketch (Use Additional Pages as Needed)

Accept to MSS-SP-54-1999

Technique Prepared By: Ron Kelly Level: 4E Date: 4-4-06
 Technique Approved By: _____ Level: _____ Date: _____