

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

10/07/2005

WORK ORDER NO.

361-02661

P.O. NUMBER

22409

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- Incl- cted sion	or Por- Slag osity	Lack of Fusion Gas	Cracks	Hot Under Tears cut	Sur- face				
MCWFA-2	2	1-2	✓									✓	
		2-3		R						R		✓	
Z103990		3-4	✓									✓	
HT# M175410		4-5	✓										
CO 40851		5-6	✓					2-3					
		6-7	✓					2-3					
		7-8		R				4					
		8-9	✓					2					
		9-10	✓										
		10-11	✓					1-2					
		11-12	✓		2								
		12-13		R						R			
		13-14	✓		2					1-2			
		15	✓										
		16-17	✓										
		17-18	✓										
		18-19	✓										
		19-20	✓										
		20-21	✓										
		21-22		R						R		✓	
		22-23	✓									✓	
		23-24		R						R			
		24-25		R						R			
		25-26	✓					2					
		26-27	✓										

NO. ACCEPTED

0

NO. REJECTED

1

MQS TECH. NO.

12970

SHT.

REV.

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NDT LEVEL (RT)

John Petroske RT II Exp. 01/08

TEAM COOPERHEAT-MQS, INC.

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ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		22409	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
			Acceptable	Rejection	Included	or Porosity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Surface	
MCWFA-2	1	27-28	✓	R					R	R			
		28-29	✓									✓	
Z103990		29-31	✓										
HT# M175410		30-31	✓									✓	
CO 40851		31-32		R						R			
		32-33	✓										
		33-34	✓									✓	
		34-35	✓		1								
		35-36		R	5					R			
		37-38		R						R			
		38-39	✓		1								
		39-40	✓										
		41-42	✓									✓	
		43-44		R	4								
		44-45	✓					1					
		45-46	✓										
		46-47	✓									✓	
		47-48	✓										
		48-49	✓										
		50-51	✓									✓	
		51-52	✓										✓
		52-53		R						R			
		54-55	✓					1					
		55-56		R						4	R		
		57-58	✓										

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV.
0	1	12970		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		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

DATE 10/07/2005

WORK ORDER NO.
361-02661

P.O. NUMBER
22409

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 Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face	
MCWFA-2	153-5817-59	✓								1			
	59-60	✓			1								
Z103990	60-61	✓								2			
HT# M175410	61-62	✓								2			
CO 40851	62-63				R						R		
	63-64	✓			R						R		
	64-65	✓										✓	
	65-66	✓										✓	
	66-67				R				R			✓	
	67-68				R					4			
	68-69				R				2	4			
	69-70	✓											
	70-71	✓								1			
	71-72				R					4			
	72-73				R				4				
	73-74	✓											
	74-75	✓							2				
	75-76	✓											
	76-77				R	3-4			4				
	77-78	✓											
	78-79	✓											
	79-80	✓											
	80-81	✓										✓	
	81-82	✓			2								

NO. ACCEPTED

4

NO. REJECTED

1

MQS TECH. NO. 12970

SHT.

REV.

COMMENTS

CUST. RSS NO.

SHT.

REV.

REVIEWER

CERTIFIED NOT LEVEL (RT)

John Petroske RT II Exp. 01/08

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ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		22409	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
			Accep- table	Reje- cted	Inclu- sion	or Por- osity	Lack of Fusion	Gas	Cracks	Hot Tears	Under cut	Sur- face		
MCWFA-2	1	82-83	✓			2								
		84-85	✓										✓	
Z103990		85-86	✓										✓	
HT# M175410		86-87	✓											
CO 40851		87-88A	✓											
		88-89	✓										✓	
		89-90	✓										✓	
		90-91			R			4					✓	
		92-93	✓											
		94-95			R				4				✓	
		95-96			R				4-5				✓	
		96-97			R				5				✓	
		97-98	✓						2-3				✓	
		98-99			R				4				✓	
		99-100			R			4	3-4				✓	
		100-101	✓					3	3				✓	
		102-103			R			4						
		103-104	✓						3					
		104-105	✓						3					
		106-107	✓											
		107-108	✓											
		108-109			R	5			2					
		109-110	✓						2					
		111-112	✓											
		112-113	✓						1					

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV.
1	1	12970		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		CERTIFIED NOT LEVEL (RT)		
		John Petroske RT II Exp. 01/08		

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NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	12970	SHT.	REV.
COMMENTS		CUST. RSS NO.		SHT.	REV.
		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		12/19/2005	361-02763
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		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejection	Dross or Porosity	Lack of Fusion	Gas Cracks	Hot Tears	Under cut	Surface	
MCWFA-2		2-3	✓							✓	
	(R1)	7-8	✓				2				
Z103990		12-13	✓				2				
HT# M175410		21-22	✓								
CO 40851		23-24	✓				1				
		24-25	✓							✓	
		31-32	✓								
		35-36	✓								
		37-38	✓								
		43-44	✓								*
		52-53	✓								
		55-56	✓								
		62-63	✓							✓	
		64-65	✓								
		66-67	✓							✓	
		67-68	✓							✓	
		68-69	✓							✓	
		71-72	✓				1-2	1		✓	
		72-73	✓							✓	
		76-77	✓								
		90-91	✓				1			✓	
		94-95	✓								
		95-96	✓								
		96-97	✓								
		99-100	✓				2				

NO. ACCEPTED	1	NO. REJECTED	0	MQS TECH. NO.	12970	SHT.	REV.
COMMENTS	* Extra shot Taken for densities.			CUST. RSS NO.		SHT.	REV.
				REVIEWER	John Petroske		
				CERTIFIED NDT LEVEL (RT)			
				John Petroske	RT II Exp. 01/08		

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		12/19/2005	361-02763
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER Chuck Rudd	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.	12970	SHT.	REV.
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 <u>METAL TEK INTERNATIONAL</u>		<u>12/19/2005</u>	361-02763
ADDRESS <u>8600 COMMERCIAL BLVD</u>		P.O. NUMBER Chuck Rudd	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 _____ OF _____	

[illegible]

NO. ACCEPTED	1	NO. REJECTED	0	MQS TECH. NO.	12970	SHT.	REV.
COMMENTS * Did No Reshoot 25-29, 26-27. These views originally had Larso Chill Blocks in these views. They have since been cut out. Thus the called out pens have no where on part to be placed.				CUST. RSS NO.		SHT.	REV.
				REVIEWER <u>W. Petroske</u> CERTIFIED NDT LEVEL (RT) John Petroske RT II Exp. 01/08			

MetalTek

INTERNATIONAL

RADIOGRAPHIC INTERPRETATION REPORT

[illegible]



RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <i>Energy Industries of OHIO</i>	Pattern Number <i>MCWFA-2</i>
Material <i>CF8MNMN mod</i>	Traceability Number
Film Manufacturer <i>Fuji</i>	Source Number <i>82ci IR. 192</i>
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)	<i>27-28</i>																		
Thickness (IN.)	<i>2 3/4 - 7"</i>																		
S/F Distance (IN.)	<i>18"</i>																		
Penetrameter	<i>50 80 100</i>																		
Time (MIN.)	<i>2hr</i>																		
Focal Spot (IN.)	<i>1</i>																		
Film Size (IN.)	<i>14X17</i>																		
Screen Size (Pb)	<i>101</i>																		
Front/Back	<i>101</i>																		
S.W.E./D.W.E.	<i>SWE</i>																		
S.W.V./D.W.V.	<i>SWV</i>																		
Film Type	<i>2959 80X2</i>																		
Acceptance Standard	<i>E180 E280</i>																		
Severity Level	<i>SP54</i>																		

Shooting Sketch (Use Additional Pages as Needed)

See original Technique Drawing.

Technique Prepared By: *Doug Midgett* Level: *II*
 Technique Approved By: _____ Level: _____

Date: *12-28-05*
 Date: _____