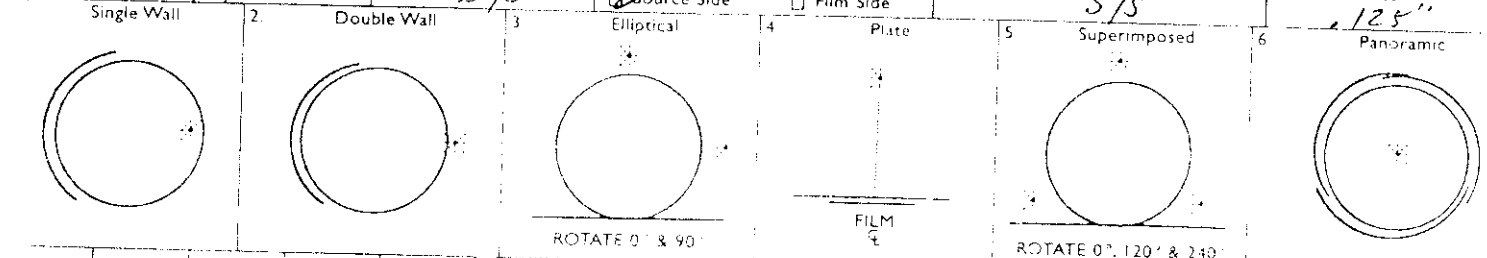
LHe Tank Radiograph Reports

CONAM

Radiographic Inspection Report

Page 1 Of 1

Customer: Meyer Tool + Mfg Inc	Contract # /PO: 008904-00	Job #: 2467/6449	Date: 8-6-03
Specification: ASME SEC V	Method Specification: 96-RT-004 R15	Acceptance Standard: ASME SEC VIII Div 1 UW51	
Plate Thickness: .375"	Pipe Diameter: —	Weld Thickness: .375" + Crown	Joint Type: Butt
Material: STEEL	Radiation Source: Ir192	Source Strength: 440	Focal Spot Size: .148"
Technique Used: #4	Part Description:	Film Technique: ☑ Single ☐ Multiple	Film to Source Distance: 21"
Exposure Time: 4:45 min	Film Processing: ☑ Automatic ☐ Manual	Intensifying Screens: Pb	Front: .010"
Center: —	Back: .010"	Type Penetrameter: ASTM #17	Material: S/S
Penetrameter Location: ☑ Source Side ☐ Film Side	Shim Material: S/S	Shim Thickness: .125"	



Size	14x17	11x14	10x12	8x10	3x17	4x17	5x7	4x10
TYPE & NO.								KODAK S-M

Job Location: LAB

Rad ID #		Original or Repair	Geometric Unsharpness	Accept	Reject	Porosity	Inclusions	Cracks	Incomplete Fusion	Inadequate Penetration	Undercut	Burn Thru	Root Concavity	Film Artifact	Remarks	Penetrometer Density	Weld Density
25I573-D	A	OR	.003"		X			X								2.0-4.0	2.0 4.0
	B			✓				✓							LACK OF FUSION IN AREA TO BE REMOVED		
	C				X			X									
	D			✓			✓										
25I573-H	A			✓													
	B			✓				✓							LACK OF FUSION IN AREA TO BE REMOVED		
	C			✓	✓												
	D	✓	✓	✓	✓											✓	✓

Film Reviewer/Inspector: JEFF OURS RT II Signature: Jeff Ours Date: 8/6/03

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ORIGINAL

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Radiographic Inspection Report

Page 1 Of 1

Customer: MEYER TOOL & MFG	Contract # /PO: 00918-0051	Job #: 2467/G449	Date: 8/19/03
Specification: ASME SEC. V	Method Specification: 96-RT-005 R/4	Acceptance Standard: ASME SEC. VIII	
Plate Thickness: ~~N/A~~ .375"	Pipe Diameter: N/A	Weld Thickness: .375" + CAP	Joint Type: Butt; Material: S/S
Radiation Source: IR-192	Source Strength: 38-CI	Focal Spot Size: .148"	Technique Used: #4
Part Description: S/S CHAMBER	Film Technique: ☒ Single ☐ Multiple	Film to Source Distance: 12"	Exposure Time: 1.5 MIN.
Film Processing: ☒ Automatic ☐ Manual	Intensifying Screens: Pb	Front: .010"	Center: —; Back: .010"
Type Penetrameter: ASTM-15	Material: S/S	Penetrameter Location: ☒ Source Side ☐ Film Side	Shim Material: S/S; Shim Thickness: .090"

1. Single Wall
2. Double Wall
3. Elliptical — ROTATE 0° & 90°
4. Plate — FILM
5. Superimposed — ROTATE 0°, 120° & 240°
6. Panoramic

Size	14x17	11x14	10x12	8x10	3½x17	4½x17	5x7	4½x10	KODAK
TYPE & NO.								2	M

Job Location: LAB-TTS-96

Rad. ID #	Original or Repair	Geometric Unsharpness "Ug"	Accept	Reject	Porosity	Inclusions	Cracks	Incomplete Fusion	Inadequate Penetration	Undercut	Burn Thru	Root Concavity	Film Artifact	Remarks	Penetrometer Density	Weld Density
S/N: 25I573-D																
#A-R1	~~OK~~ R	.005"	/										/		2.37	2.48
#C-R1	R	↓	/												2.50	2.58

Reviewer/Inspector: DENNIS KUTSCHKAU Signature: Dennis J Kutschkau LVL III Date: 8/19/03

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