LHe Tank Radiograph Reports

CONAM

Radiographic Inspection Report

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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 R/5	Acceptance Standard: ASME SEC VIII Div 1 UW51	
Plate Thickness: .375"	Pipe Diameter: —	Weld Thickness: .375" + Crown	Joint Type: Bu-H / Material: STEEL
Radiation Source: Ir 192	Source Strength: 44 ci	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"

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 "M"	Job Location: LAB
TYPE & NO.								8		

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
25I573-0	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			✓			✓										
25I573-4	A			✓													
	B			✓				✓							LACK OF FUSION IN AREA TO BE REMOVED		
	C			✓		✓											
	D	✓	✓	✓		✓										✓	✓

Film Reviewer/Inspector: JEFF OURS RT II Signature: [signature] Date: 8/6/03

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