

X-Ray Results for AES-008

This document shows the x-ray results for the helium vessel #9 that became part of dressed cavity AES-008.

ALLOYWELD INSPECTION COMPANY, INC.
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X-RAY READER SHEET

TO:

HI-TECH MFG. LLC
 4637 N. 25TH AVE.
 SCHILLER PARK, IL 60176

DATE: **DECEMBER 17, 2009**

ORDER NO: **27003**

REGISTER NO: **2091**

WORK ORDER NO: **60922**

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#9

INSPECTION INFORMATION

PART NUMBER	DB12765	MATERIAL	HEAT CODE
FILM NUMBER	U840	NO OF VIEWS	16
		NO OF FILM	(16)CR SHOTS
PROCESSED IN ACCORDANCE WITH: ASME B31.3 PARA. 344.5, ACCEPTANCE PER TABLE K, 341.3.2			

Po: 27003 - Job# 001
 62933A

X-RAY SERIAL NUMBER	Accept	Non-Conforming	Cracks	Shrinkage	Shrink Cavities	Porosity	Gas Holes	Voils	Surface	REMARKS OR OTHER DISCONTINUITIES
9-W1 A-B	X									
B-C	X									
C-D	X									
D-A		X								INCOMPLETE FUSION
9-W2 A-B	X									
B-C	X					X				
C-D	X									
D-A	X									
9-W3 A-B	X									
B-C	X									
C-D	X									
D-E	X									
E-F	X									
F-G	X									
G-H	X					X				
H-A	X									
9-W4 A-B	X									
B-C	X									
C-D	X									
D-E	X					X				
E-F	X					X				
F-G	X					X				
G-H	X					X				
H-A	X					X				

This report is limited to the defects of the type that can be located with the above method. Any changes to shaded areas make this report

ALLOYWELD INSPECTION - RADIOGRAPHER SIGNATURE

ACCEPTABLE 0 PCS.
 NON-CONFORMING 1 PCS.


 JENNIFER ANAYA
 NAS 413/MIL-STD-410E LEVEL II

WELDING: ARC-BLENDING, BRAZING, SHWER AND SOFT SOLDERING • INSPECTION: MAGNETIC PARTICLE, PENETRANT, X-RAY, COMPUTED RADIOLOGY, IMAGERY/ULTRASONICS, PASSIVATING, NITAL ETCH, SURFACE TEMPER ETCH, STRESS RELIEF

This map identifies the names and locations of the welds that were x-rayed.

