



CAPITAL NDT SERVICES

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RADIOGRAPHIC EXAMINATION REPORT

Customer : MICROFUSION CAST & ALLOYS, METODA	Report No. : 17095/24-25
Customer's Client :	Date : 19/12/2024
Job Description : NPS 4 X NPS3 FIG 2660N #600 BODY MARK-2 (WITH STEM & SEAT SEALANT)	Date of Test : 13/12/2024
Die / Tool No. : 1981-A Drg. No. : -	Offer No. : 806
Heat No. : 76E4 PO No. : -	WAS No. :
Material : WCB	Test Carried Out At: OUR TEST LAB
Procedure Followed : ASME BPVC Sec V,Arti-2 & 22,2023	RT Coverage : ASME B16.34 CRITICAL AREA
Evaluation Standard : ASTM E-446 (Vol II),2020	Procedure No. : PS05/16 REV.4
Acceptance Standard : ASME B16.34 APPENDIX- 1-2020	Shooting Sketch No. :

Radiation Source : Ir-192 Screen : LEAD 0.10mm Front , 0.10mm Back Film Processing : MANUAL
 Source Strength : 2.12 Ci Exposure Time : VARIOUS Processing Time : MANUAL
 Source Size : 2.7mmD x 1.2mmH Film Brand & Type : CARESATREAM AA400

Sr. No.	Identification	Location	Film Size (inch)	Techq	Thck. (mm)	Density	SFD (inch)	IQI	Sensitivity	Findings	Result
1	RT 6998	A	12x15	DWSI	15+15	1.5 TO 4.0	24	ASTM 12/1B	S 4TW7	CB - II	Acceptable
2	RT 6998	B	12x15	DWSI	15+15	1.5 TO 4.0	24	ASTM 12/1B	S 4TW7	B/CB - I/I	Acceptable
3	RT 6998	C	12x15	DWSI	15+15	1.5 TO 4.0	24	ASTM 12/1B	S 4TW7	B - I	Acceptable
4	RT 6998	PA-B	8X8	SWSI	70	1.5 TO 4.0	5	ASTM 50/1C	F 2TW1 3	NSD	Acceptable

INSPECTED / REVIEWED & ACCEPTED
 N. MUTHUKRISHNAN
 ASNT RT, UT, MT, PT, VT Level - II
 Certificate due date: 01.01.2027
 Q.A./Q.C - JC Valvulas

Total No. of Films : 4 Nos., Total Sq. Inches : 604.00

Film Size Summary : 12x15 - 3, 8X8 - 1

Density of each film is measured and confirm between 1.5 to 4.0
 NSD=No Significant Discontinuity, A=Gas Porosity, B=Inclusion, CA/CB/CC/CD=Shrinkage,
 D=Crack, E=Hot Tears, F=Insert, SD=Surface Depression, G=Mottling

Note :

- Report relates items tested only.
- Test Results are in compliance with requirements and / or specifications of technique used.
- Test Reports shall not be reproduced except full in written approval of the Laboratory.

For, Capital NDT Services	Customer Representative :	Customer's Client :	Inspection Agency :
KAUSHIK USDAD ASNT RT-II			