



CAPITAL NDT SERVICES

Survey No. 72, Paikee 1 / Paikee 2 / Paikee 2, Plot No. 5, Dev Industrial Area, Village Bhunava, Tal Gondal, Dist. Rajkot (Gujarat, India)
 Phone : +91 95861 23523, +91 95862 23523, Email : capitalndts@gmail.com



RADIOGRAPHIC EXAMINATION REPORT

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| Customer : MICROFUSION CAST & ALLOYS, METODA | Report No. : 17382/24-25 |
| Customer's Client : | Date : 22/12/2024 |
| Job Description : 4" (DN100) FIG-2590N BODY #900 | Date of Test : 18/12/2024 |
| Die / Tool No. : 623 Drg. No. : - | Offer No. : 806 |
| Heat No. : 77E4 PO No. : - | WAS No. : 1824 - 22-12-2024 |
| Material : WCB | Test Carried Out At : At Our Lab |

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| Procedure Followed : ASME BPVC Sec V,Art-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. : |

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| Radiation Source : Ir-192 | Screen : LEAD 0.10mm Front , 0.10mm Back | Film Processing : MANUAL |
| Source Strength : 2.02 Ci | Exposure Time : VARIOUS MIN | Processing Time : MANUAL |
| Source Size : 2.7mmD x 1.2mmH | Film Brand & Type : CARESATREAM AA400 | |

| Sr. No. | Identif-ication | Location | Film Size (inch) | Techq. | Thck. (mm) | Density | SFD (inch) | IQI | Sensi tivity | Findings | Result |
|---------|-----------------|----------|------------------|--------|------------|------------|------------|------------|--------------|------------|------------|
| 1 | RT 6994 | N A-B | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 7 | ASTM 17/1B | F 2-2T | CB - II | Acceptable |
| 2 | RT 6994 | N B-C | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 7 | ASTM 17/1B | F 2-2T | B/CB - I/I | Acceptable |
| 3 | RT 6994 | N C-D | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 7 | ASTM 17/1B | F 2-2T | B - I | Acceptable |
| 4 | RT 6994 | N1 A-B | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 6 | ASTM 17/1B | F 2-2T | CB - I | Acceptable |
| 5 | RT 6994 | N1 B-C | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 6 | ASTM 17/1B | F 2-2T | CB - I | Acceptable |
| 6 | RT 6994 | N1 C-D | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 6 | ASTM 17/1B | F 2-2T | NSD | Acceptable |
| 7 | RT 6994 | N1 D-A | 4x12 | SWSI | 22 | 2.0 TO 4.0 | 6 | ASTM 17/1B | F 2-2T | CB - I | Acceptable |
| 8 | RT 6994 | S A-B | 4X9 | SWSI | 32 | 2.0 TO 4.0 | 8 | ASTM 20/1B | F 2-2T | B - I | Acceptable |
| 9 | RT 6994 | S B-C | 4X9 | SWSI | 32 | 2.0 TO 4.0 | 8 | ASTM 20/1B | F 2-2T | B - II | Acceptable |
| 10 | RT 6994 | S C-D | 4X9 | SWSI | 32 | 2.0 TO 4.0 | 8 | ASTM 20/1B | F 2-2T | B - I | Acceptable |
| 11 | RT 6994 | S D-A | 4X9 | SWSI | 32 | 2.0 TO 4.0 | 8 | ASTM 20/1B | F 2-2T | B - I | Acceptable |
| 12 | RT 6994 | P A-B | 9X9 | SWSI | 45 | 2.0 TO 4.0 | 8 | ASTM 35/1B | F 2-2T | B - I | Acceptable |
| 13 | RT 6994 | P1 A | 4X6 | SWSI | 36 | 2.0 TO 4.0 | 8 | ASTM 30/1B | S 2-2T | NSD | Acceptable |

Total No. of Films : 13 Nos., Total Sq. Inches : 585.00
 Film Size Summary : 4x12 - 7, 4X9 - 4, 9X9 - 1, 4X6 - 1

Density of each film is measured and confirm between 2.0 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 :
 1. Report relates items tested only.
 2. Test Results are in compliance with requirements and / or specifications of technique used.
 3. Test Reports shall not be reproduced except full in written approval of the Laboratory.

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