

Fermilab

Material Submittal for Approval

Date July 14, 2015

Fermi National Accelerator laboratory

Page 1 Of 1

Submitted To P.O. Box 500, Batavia, IL 60510

Attn: Tom Lackowski - FESS/Engineering MS214

NOTE:

Include only one submittal item per line.

Attach additional pages for more items.

Include only one type of submittal per page. If this is a resubmittal, indicate the first submittal number.

Submitted By Whittaker Construction & Excavating, Inc.

105 Park Street - P.O. Box 21

Earlville, Illinois 60518

Include address, fax, phone (Fax:) 815-246-7118 (Phone:) 815-246-7119

Project No. 6-10-2 & 6-10-22 Project Name **Mu2e Conventional Facility & MC Beamline**

Submittal No. 243

Subcontract No. _____

Resubmittal? Previous Submittal #. _____

Spec Section	Description	Vendor/Mfg/Subcontractor	Dwg Number
15010-002	Radiographic Test Report	RJO	Test Report

Contractor Note

All material submitted herewith complies with exhibit A. special conditions of the subcontract specifications

**For information only.
No action required.**

By: Sara Benson

Title: Contract Administrator

Radiographic Procedure Qualification Record

Procedure Number: Applicable Code:

SOURCE

Type of Energy:	<input type="text" value="Gamma"/>	Manufacturer:	<input type="text" value="SPEC"/>
Isotope:	<input type="text" value="Ir-192"/>	Curies:	<input type="text" value="85"/>
Effective Focal Spot Size:	<input type="text" value="0.146"/>	mA Rating:	<input type="text" value="n/a"/>
		Kv Rating:	<input type="text" value="n/a"/>

MATERIALS

Material Type:	<input type="text" value="stainless steel"/>
Thickness From:	<input type="text" value="> .148"/>
Thickness To:	<input type="text" value="0.248"/>
Nominal Pipe Size	<input type="text" value="8 inch"/>

FILM

Film Brand	<input type="text" value="Agfa"/>	Film Type:	<input type="text" value="D3"/>
# of Film in cassette:	<input type="text" value="1"/>	Film Class	<input type="text" value="I"/>
Viewing for multiple film technique:	<input type="text" value="n/a"/>		

SCREENS

Type of Screen:	<input type="text" value="Lead"/>
Front Thickness:	<input type="text" value=".010"/>
Back Thickness:	<input type="text" value=".010"/>

EXPOSURE GEOMETRY

SWE-SWV DWE-SWV DWE-DWV Mark ONLY the ONE applicable

Source to Film Distance: Number of Penetrators per Exposure:

Distance between Location Markers: Number of Location Markers:

The area of interest is between location markers which are placed adjacent to weld.
 Film is approximately centered over the weld in the area of interest with sufficient overlap to show location markers.

CHECK ALL THAT APPLY

1 One penetrator diametrically opposed to the source.

2 One penetrator within an inch of the end of the film to be interpreted.

3 Four penetrators spaced approximately equally around the circumference of the weld.

4 One placed adjacent to repaired area(s) (when applicable).

Number of Exposures for 1 Complete Weld:

EXPOSURE CONDITIONS

Exposure Time:	<input type="text" value="33 seconds"/>
Curie-Minutes	<input type="text" value="45"/>
Kv:	<input type="text" value="n/a"/>
mA:	<input type="text" value="n/a"/>
mA-Minutes	<input type="text" value="n/a"/>


PROCESSING

<input type="checkbox"/> Automatic	<input checked="" type="checkbox"/> Manual
Developer Time:	<input type="text" value="4 minutes"/>
Developer Temperature:	<input type="text" value="80"/> Degrees F
Stop Bath Time:	<input type="text" value="1 minute"/>
Fixing Time	<input type="text" value="5 minutes"/>
Washing Time:	<input type="text" value="10 minutes"/>
Drying Method:	<input type="text" value="electric"/>

PENETRATORS

Penetrator Type:	<input type="text" value="ASME"/>
Penetrator Material:	<input type="text" value="Steel"/>
Identification:	<input type="text" value="A"/>
Essential Hole:	<input type="text" value="n/a"/>
Essential Wire:	<input type="text" value=".08"/>
Shim Material	<input type="text" value="n/a"/>
Shim Thickness:	<input type="text" value="n/a"/>

Approved by:
 McNDT Pipeline, Ltd.

Signature: 
 Date:

Accepted by:
 Company:

Signature: _____
 Date: _____

MCNDT Pipeline, Ltd.

P.O. Box 545 Channahon, IL 60410

(815) 467-5200

Customer: R J O'Neil Job Site: Fermi Lab Batavia II W.O. No.: 62567 Date: 5/16/2015

RT CR UT VT Acceptance Standard: ASME B31.3 Page 1 of 1
 MT WMT PT Spec/Procedure: RT1 Material Type: SS

RADIOGRAPHIC TECHNIQUE Film or IP Plate

Isotope: IR192 Curies: 85 Source to Object: 8.875 EFSpot: .146 SWE DWE Mfg. Type: Agfa D3
 Object to Film: # Film: 1 SWV DWV
 kV: mA: ASTM Penetrameter Size: A Source Side Film Side

Hours Worked: Notes: Job No.: Total Hours: 9
 From: 7:00 AM Number of Technicians: 2 Per Diem
 To: 2:00 PM Travel Time To: 1 Travel Time From: 1 Total Miles Traveled: 100

FILM OR WELD ID	DISPOSITION		PIPE DIAMETER	NOMINAL WALL	DEFECT TYPE	WELDERS	COMMENT
	Acc	Rej					
W1	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148		Matt Woods	
W2	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148		Matt Woods	
W3	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148		Matt Woods	
W4	<input type="checkbox"/>	<input checked="" type="checkbox"/>	8"	.148	IP	Matt Woods	View B-C
W5	<input type="checkbox"/>	<input checked="" type="checkbox"/>	8"	.148	Int. Concanvity	Matt Woods	View A-B, B-C
W6	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148		Matt Woods	
W7	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148		Matt Woods	
W8	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148		Matt Woods	
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					

Other size
 4-1/2" x 10" 4-1/2" x 17" 70mm x 10" 70mm x 17" 8" x 10" 14" x 17" 5"x7" 70mm x 5"

We hereby certify the parts listed have been inspected and are in accordance with specifications not
 This report represents the evaluation and interpretation of said examination performed by McNDT Pipeline,

Technician: J O'keefe Level: II

Signature:  Date: 5/16/15 Customer Representative: 

The bottom line is....

NDTMatters@McNDT.com

McNDT Pipeline, Ltd.

P.O. Box 545 Channahon, IL 60410

(815) 467-5200

Customer	Job Site	W.O. No.	Date
RJ Oneil	Fermilab Batavia, IL	62567	5/21/2015

<input checked="" type="checkbox"/> RT <input type="checkbox"/> CR <input type="checkbox"/> UT <input type="checkbox"/> VT	Acceptance Standard	API 1104 20th Ed.	Page 1 of 1
<input type="checkbox"/> MT <input type="checkbox"/> WMT <input type="checkbox"/> PT	Spec/Procedure	RT1	Material Type
			Stainless Steel

RADIOGRAPHIC TECHNIQUE				Film or IP Plate	
Isotope	Curies	Source to Object	8.875	EFSpot	.156
Ir-192	48	Object to Film		# Film	
kV		ASTM Penetrameter Size	A	<input type="checkbox"/> SWE <input checked="" type="checkbox"/> DWE	Mfg. Type
mA				<input checked="" type="checkbox"/> SWV <input type="checkbox"/> DWV	Agfa D3
			<input type="checkbox"/> Source Side	<input checked="" type="checkbox"/> Film Side	

Hours Worked	Notes	Job No.	Total Hours
From 6:00 PM			6
To 9:00 PM	Travel Time To 1.5	Travel Time From 1.5	Number of Technicians 2
			<input type="checkbox"/> Per Diem
			Total Miles Traveled 100

FILM OR WELD ID	DISPOSITION		PIPE NOMINAL		DEFECT TYPE	WELDERS	COMMENT
	Acc	Rej	DIAMETER	WALL			
W4R	<input type="checkbox"/>	<input checked="" type="checkbox"/>	8"	.148	IP		
W5R A-B	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148			
W5R B-C	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148			
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
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4-1/2" x 10"	4-1/2" x 17"	70mm x 10"	70mm x 17"	8" x 10	14" x 17	5"x7"	70mm x 5	Other size
				3				

We hereby certify the parts listed have been inspected and are in accordance with specifications not This report represents the evaluation and interpretation of said examination performed by McNDT Pipeline,

Technician J O'Keefe Level II
 Signature [Signature] Date 5/21/15 Customer Representative _____

The bottom line is....

NDTMatters@McNDT.com

McNDT Pipeline, Ltd.

P.O. Box 545 Channahon, IL 60410

(815) 467-5200

Customer: RJ Oneil Job Site: Fermilab Batavia, IL W.O. No.: 62567 Date: 5/26/2015

RT CR UT VT Acceptance Standard: API 1104 20th Ed. Page 1 of 1
 MT WMT PT Spec/Procedure: RT1 Material Type: Stainless Steel

RADIOGRAPHIC TECHNIQUE
 Isotope: Ir-192 Curies: 48 Source to Object: 8.875 EFSpot: .156 SWE DWE
 Object to Film: # Film: SWV DWV Mfg. Type: Agfa D3
 kV: mA: ASTM Penetrameter Size: A Source Side Film Side

Hours Worked: From 8:00 PM To 10:00 PM Notes: Job No.: Total Hours: 4
 Number of Technicians: 2 Per Diem
 Travel Time To: 1 Travel Time From: 1 Total Miles Traveled: 100

FILM OR WELD ID	DISPOSITION		PIPE DIAMETER	NOMINAL WALL	DEFECT TYPE	WELDERS	COMMENT
	Acc	Rej					
W4R2 B-C	<input checked="" type="checkbox"/>	<input type="checkbox"/>	8"	.148			
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					
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	<input type="checkbox"/>	<input type="checkbox"/>					
	<input type="checkbox"/>	<input type="checkbox"/>					

4-1/2" x 10" 4-1/2" x 17" 70mm x 10" 70mm x 17" 8" x 10 14" x 17 5"x7" 70mm x 5 Other size
 3

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Technician: J. Okeefe Level: II
 Signature: *J. Okeefe* Date: 5/26/15 Customer Representative: _____

The bottom line is...
NDTMatters@McNDT.com