

Chart Heat Exchangers L.P.
Inspection & Test Report

Stacking & Brazing

ell 4

ales Order # 509. 4-5

Modue # _____

Manufacturing # 15775B-1

operation	Instruction	Operator Clock #	Date & Inspector Initials	W/H Points Int & Date
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STACKING ASSEMBLY

WI9-040-002

1 Layer *A-Stream*

WI10-02

46357 *ready 4-2-05*

2 Layer *B-Stream*

WI10-02

46357 *ready 4-2-05*

Layer

WI10-02

Layer

WI10-02

Layer

WI10-02

Layer

WI10-02

Layer

WI10-02

Layer

WI10-02

Layer

WI10-02

Layer

WI10-02

Half Primary Stacking & Squareness

WI10-02

46394 *Hay 4-2-05*
1-30 LAGUS

Primary Stacking & Squareness

WI10-02

46425/75340 *Hay 4-3-05*

Compression & Dimensional Record

46425/75340

Braze Core / Module

Date 04/04/05

46394

Fixture Removal / Dimensional After Brazing

Date 4/06/05

75398/75403

Header Inspection Log									
			Sales Order #			509.4-5			
Header Assy. Item #	Stream Identification	Header Body Trace	End Piece Trace	Nozzle Trace	Misc. Material Trace	Final Insp. Initials & Date	X-Ray Initials & Date	X-Ray #	A.I. Review Initials & Date
8002	A-IN	S472C	S515C	T187C		JL 4-7-05			HAL 4-7-05
8003	A-OUT	S472C	S515C	T172C		JL 4-7-05			HAL 4-7-05
8004	B-IN	S472C	S546C	T187C		JL 4-7-05			HAL 4-7-05
8005	B-OUT	S472C	S546C	T138C		JL 4-7-05			HAL 4-7-05

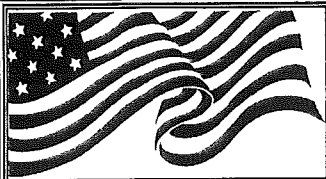


Chart Heat Exchangers

Post Braze Inspection and Test Report

National Board Number:

5158

Job Number/Serial Number 509.4-5

Drawing Number: 15775A

Mfg. Number: 15775B-1

Review of Design Calculations, Assembly Drawings and I&T Report

QC Review and approval of ITR: David EganDate: 3-15-05AI Review and acceptance of ITR: [Signature]Date: 3-15-05

General Documentation

Nameplate Verification

QC Inspection	Date	Authorized Inspector	Date
<u>PS</u>	<u>4-21-05</u>	<u>H/ABH</u>	<u>4/21/05</u>

General Operations					
Centerline Layout		Emp #	Date	QC Insp	AI Init & Date
		46447	4-6-05		
Header Fit-up and Inspection					
Header	AI Hold (H)	Clean Check / Header Fit-up (Stamp # & Date)			
		Visual Inspection before fit up			
A-In		P20 4-13-05			
A-Out		P20 4-13-05			
B-In		P20 4-13-05			
B-Out		P20 4-13-05			
n ¹ AI to review header welds prior to fit-up of inactive vent or pan headers. LPT header welds if specified on assembly drawings					
Pre-hydro Inspection and Tests					
		Emp #	Date	QC Insp	AI Init & Date
1st Air Test		P31#	4-14-05		
Support angle fit-up		P31#	4-14-05		
Visual Inspection, final welds (Weld Check)				Sm-H	4-14-05
Dimension Check				Sm-H	4-14-05
LPT complete per drawing requirement				R	4-14-05

Pneumatic and Leak Test							
Stream Identification	Pneumatic Test Pressure (PSIG)	Leak Test Pressure (PSIG)	Testor Emp # and Date	Inspector or 2nd Testor Emp# and Date	Internal Leak Test Emp # and Date	External Leak Test Emp# and Date	AI Hold Point Init & Date
A	164	109	46416 4-14-05	RSO 4-14-05	✓OK	✓OK	4/14/05
B	110	73	46416 4-14-05	RED	✓OK	✓OK	4/14/05
TUV							
A	164	109	46353	PJ 4-21-05	✓OK	✓OK	4/21/05
B	110	73	46353	PJ 4-21-05	✓OK	✓OK	4/21/05

Final Inspection			
	Emp #	Date	QC Insp Date
Helium leak test	46416	4-14-05	
Header clean check inspection	46488	4-21-05	4-22-05
Shipping pressure and labeling	46488	4-21-05	
Final inspection			4-22-05
Crate check(Tester)	46488	4-21-05	
Loose parts verification	46488	4-21-05	
ITR review and return to QC Office			