



CHW Forge Private Limited
Ultrasonic Examination Report
(Part No. UCP-210-15076-000)

Doc. No. : QAQC/UT/AUT/E-324/1
Current Rev. : 0
Date of Rev. : 12-12-2024
No. of Pages : Page 1 of 19

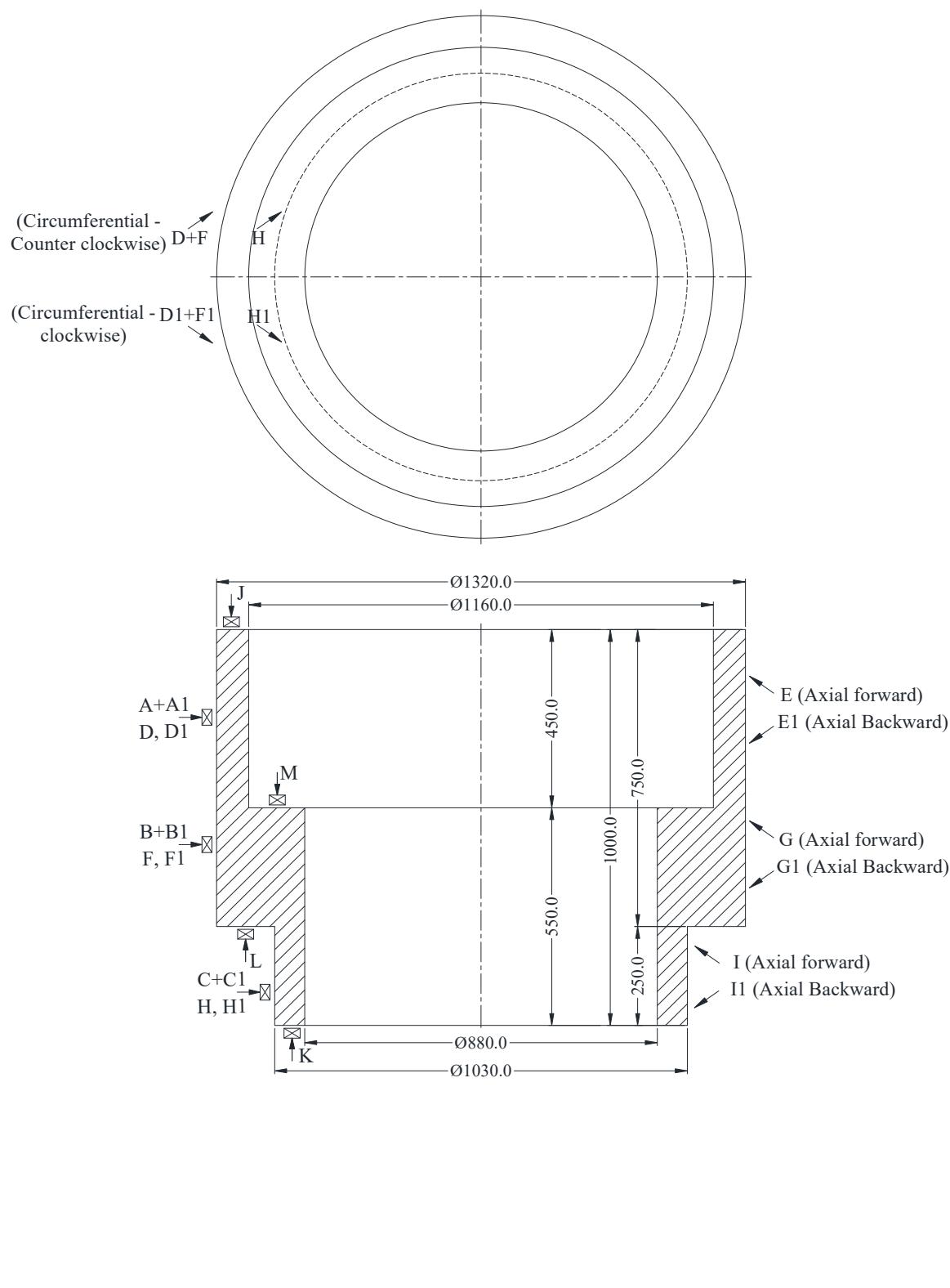
Ultrasonic Inspection Report

Document No.	QAQC/UT/AUT/E-324/1
Test Date	11-12-2024
Customer Name	Israel Aerospace Industries (IAI)
PO No	H000131338
Item Description	REAR SECTION FORGING
Part No.	UCP-210-15076-000
Material Grade	CLASS 316L AS PER AMS-QQ-S-763, CONDITION A
Drawing No.	UCP-210-15076 Rev. A
Work Order No.	WO/24-25/E-324 AS
PO Sr. No.	2
Quantity	01 no

Sample details:					
PO SI No.	2	Serial No	01	Qty.	01 No
Thickness	75mm,80mm 220mm	Type of scan	Ring scan		
Testing equipment	Eddyfi- Panther2	TCG applied	Yes		
Technique Sheet No.	QAQC/UT/TS/E-324/1 Rev.0				
Test Standard	AS PER ASTM A745				
Acceptance Criteria	Applicable class as per ASTM A745				

Observations:	Results
No Recordable indication observed in scanning.	Accepted
No back wall Loss greater than 50% observed during the scanning.	Accepted
Remarks:	

Tested By	Approved By
Suneel Sharma 	





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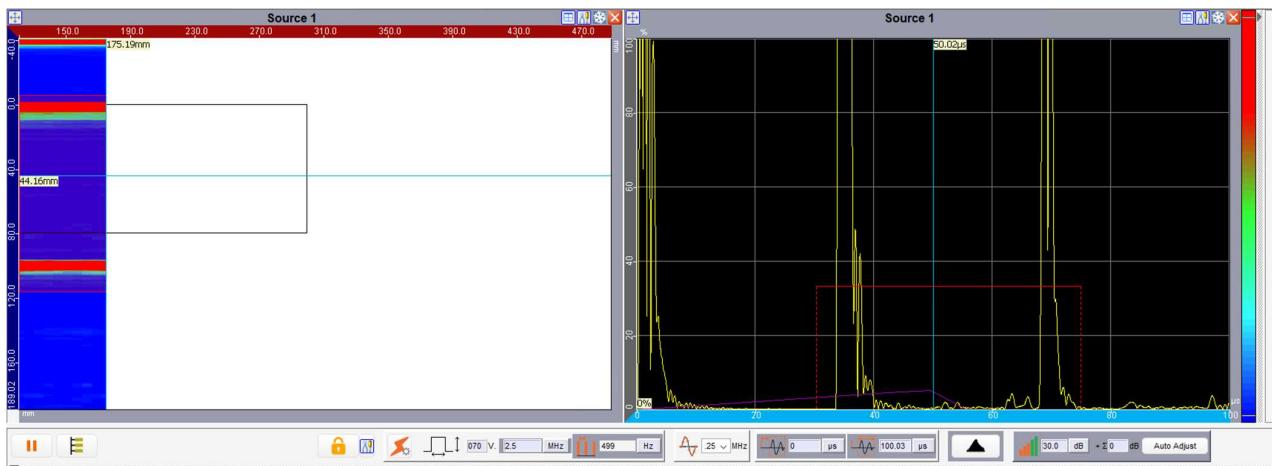
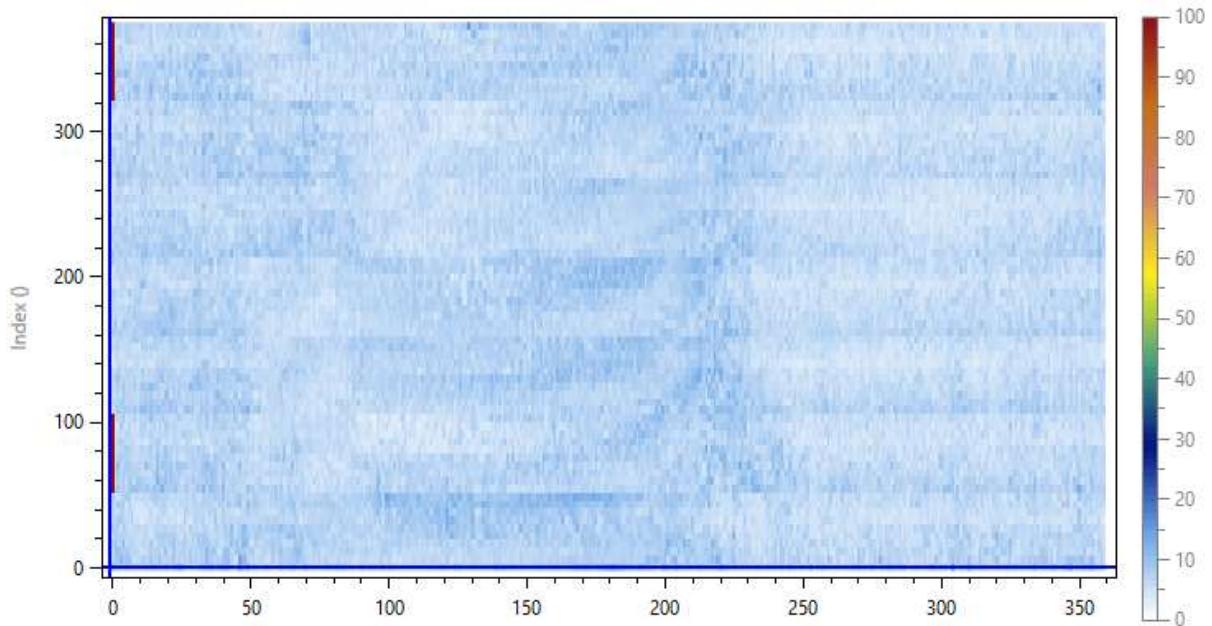
Search Unit Details

Probe Details (Crystal Size, Type, Angle, Probe Sl. No)	Frequency	Make	Wave Mode	Scanning Directions	Page no.
128ele, PAUT, 0 degree, SL NO.1551801001	2.25 MHz	Imasonic	Longitudinal	A Direction	4
128ele, PAUT, 0 degree, SL NO.1551801001	2.25 MHz	Imasonic	Longitudinal	C Direction	5
24 mm Ø, Normal 0°, SL No. 837AAF	1 MHz	EECI	Longitudinal	B Direction	6
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	D Direction (Circumferential, Clockwise)	7
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	D1 Direction (Circumferential, Anti-Clockwise)	8
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	F Direction (Circumferential, Clockwise)	9
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	F1 Direction (Circumferential, Anti-Clockwise)	10
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	H Direction (Circumferential, Clockwise)	11
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	H1 Direction (Circumferential, Anti-Clockwise)	12
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	E Direction (Axial, FWD)	13
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	E1 Direction (Axial, BWD)	14
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	G Direction (Axial, FWD)	15
20X22 MM, Angle 38°, SL NO. 870HAC	2 MHz	EECI	Shear	G1 Direction (Axial, BWD)	16
24 mm Ø, Normal 0°, SL No. 837AAF	1 MHz	EECI	Longitudinal	J Direction(Face 1)	17
24 mm Ø, Normal 0°, SL No. 837AAF	1 MHz	EECI	Longitudinal	A1 Direction (Back Wall)	18
24 mm Ø, Normal 0°, SL No. 837AAF	1 MHz	EECI	Longitudinal	B1 Direction (Back Wall)	18
Remarks	-	-	-	-	19

C-Scan Images

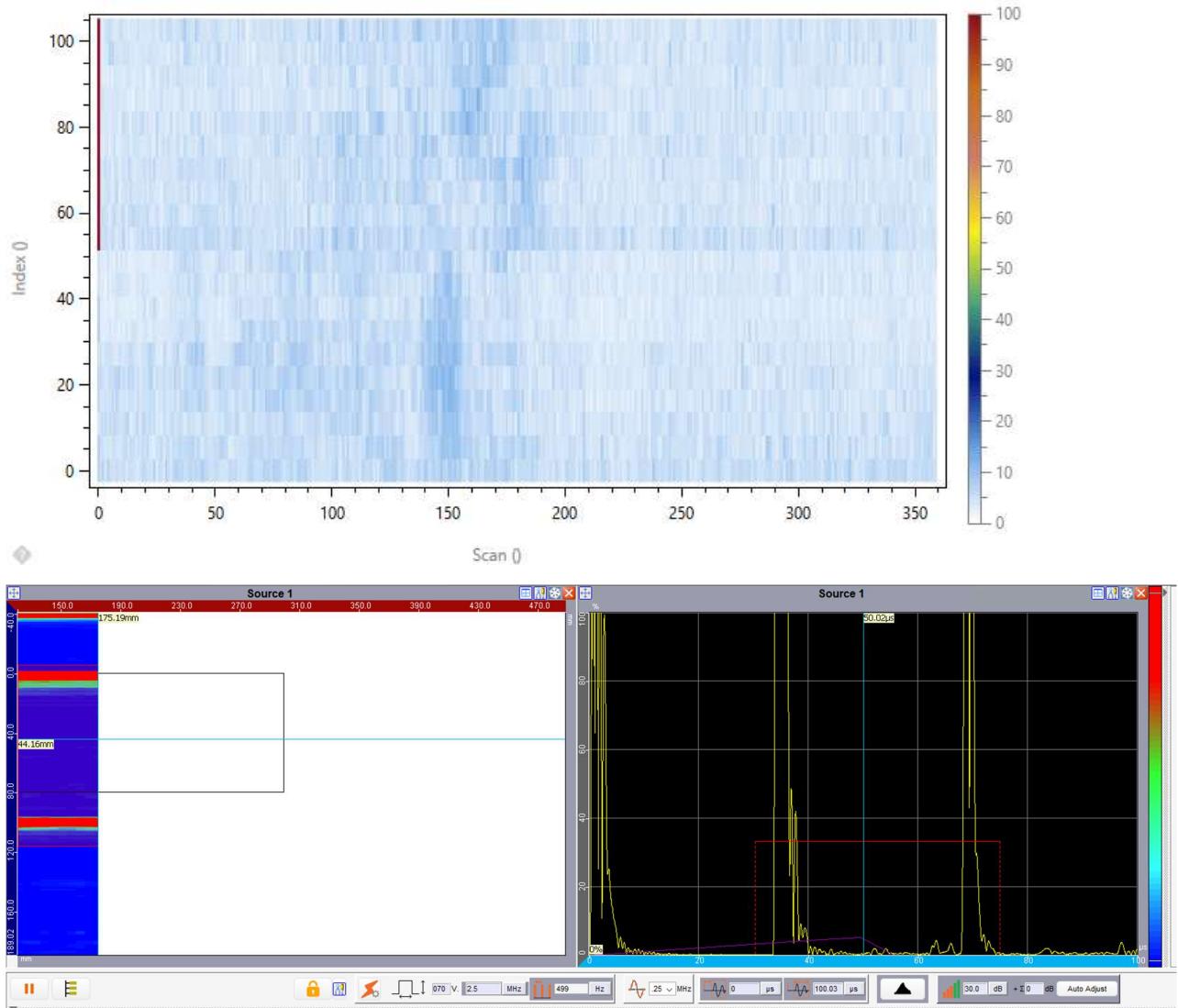
Scan 1

Scan type	A Direction- 0°
Scan length	360 degree
Index length	360
Probe	PAUT
No of Element	128



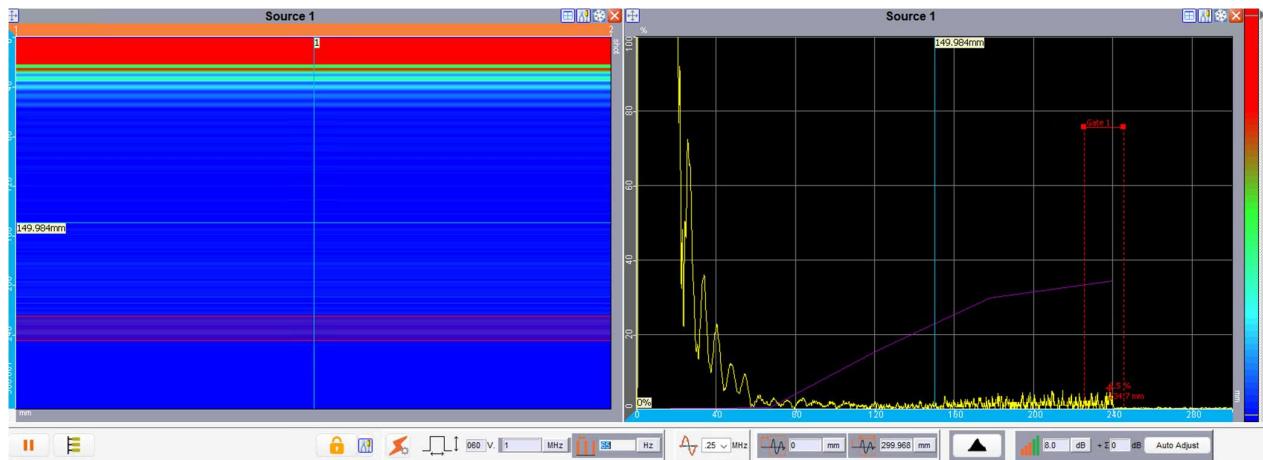
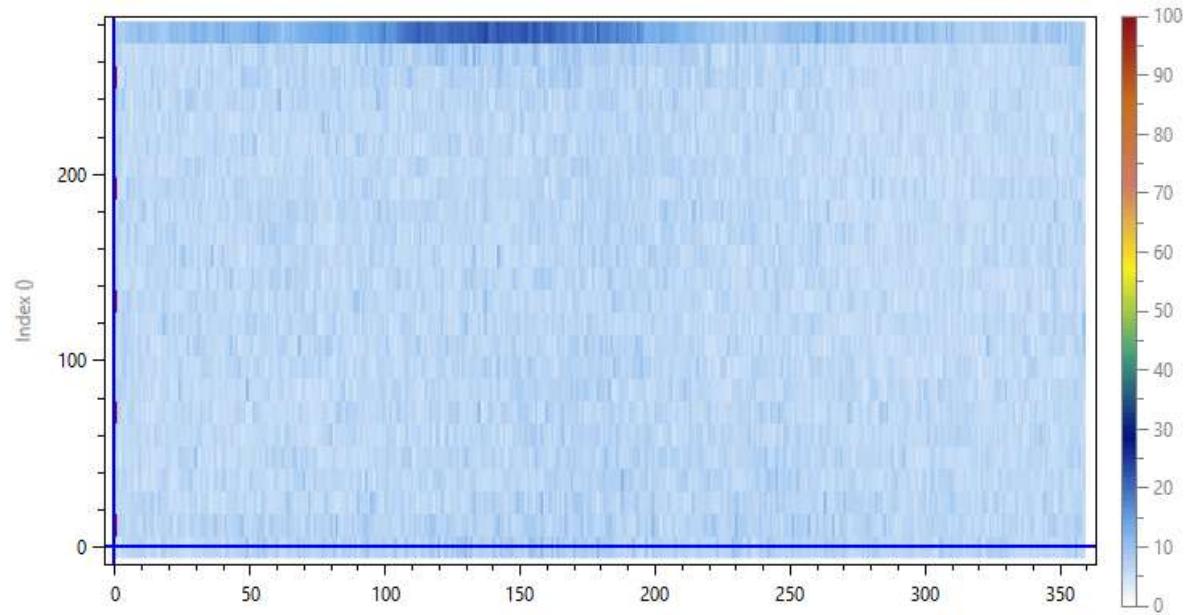
Scan 2

Scan type	C Direction- 0°
Scan length	360 degree
Index length	105 mm
Probe	PAUT
No of Element	128



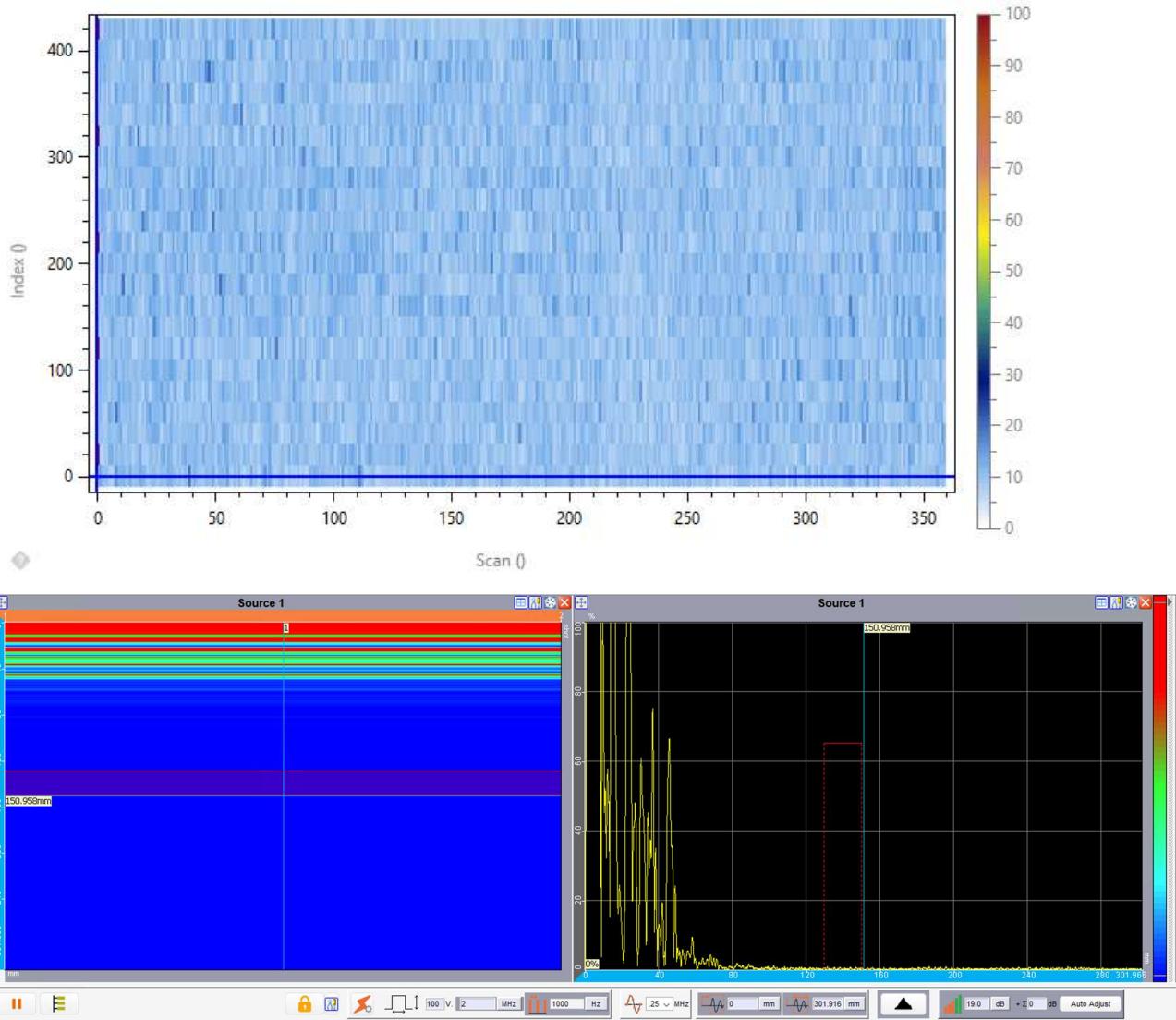
Scan 3

Scan type	B Direction, 0°
Scan length	360 degree
Index length	280 mm
Probe	Normal, 1 MHz
No of ELEMENT	1



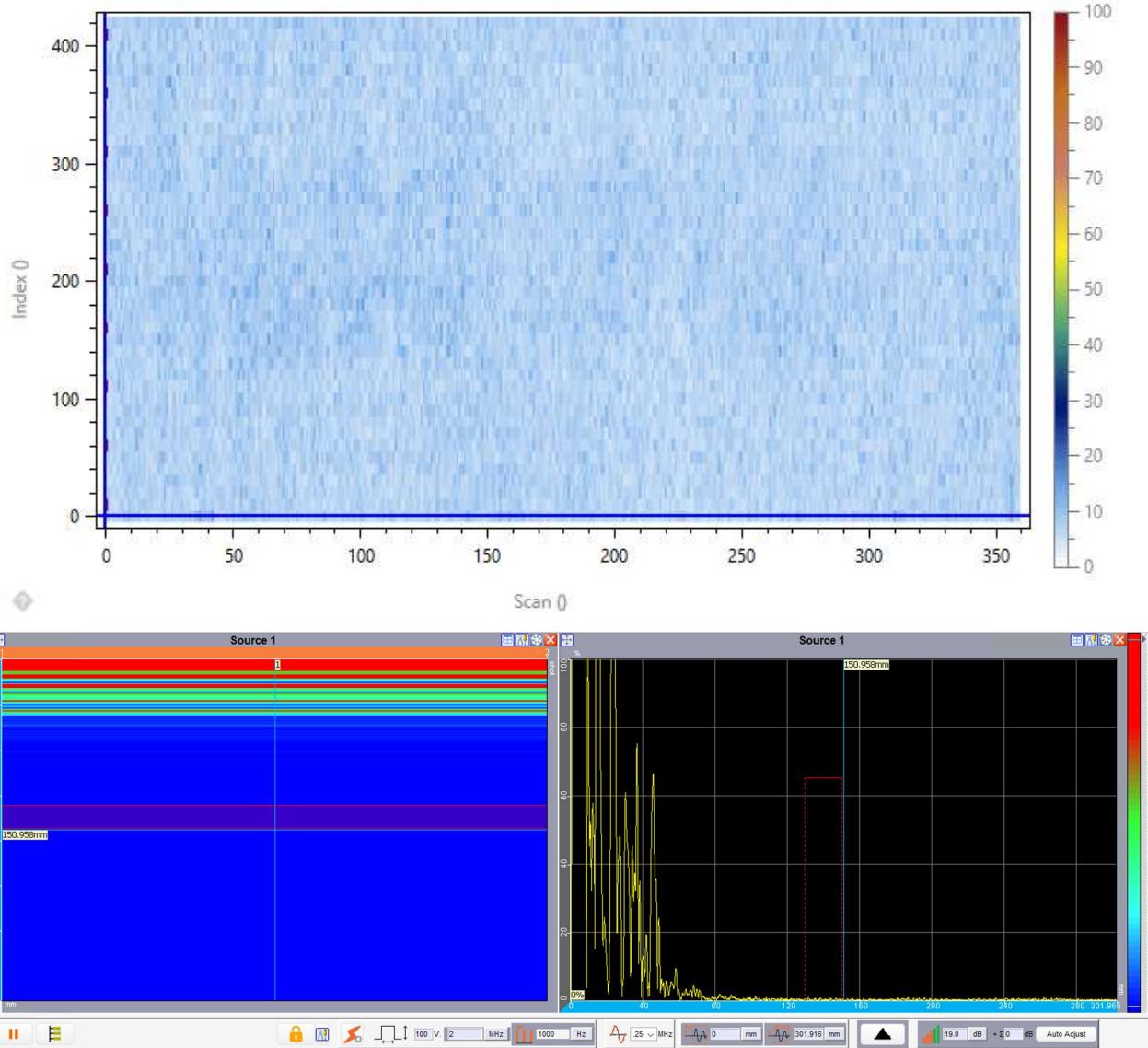
Scan 4

Scan type	D Direction, 38°, Circumferential, Clockwise
Scan length	360 degree
Index length	420
Probe	Angle, 38°
No of Element	1



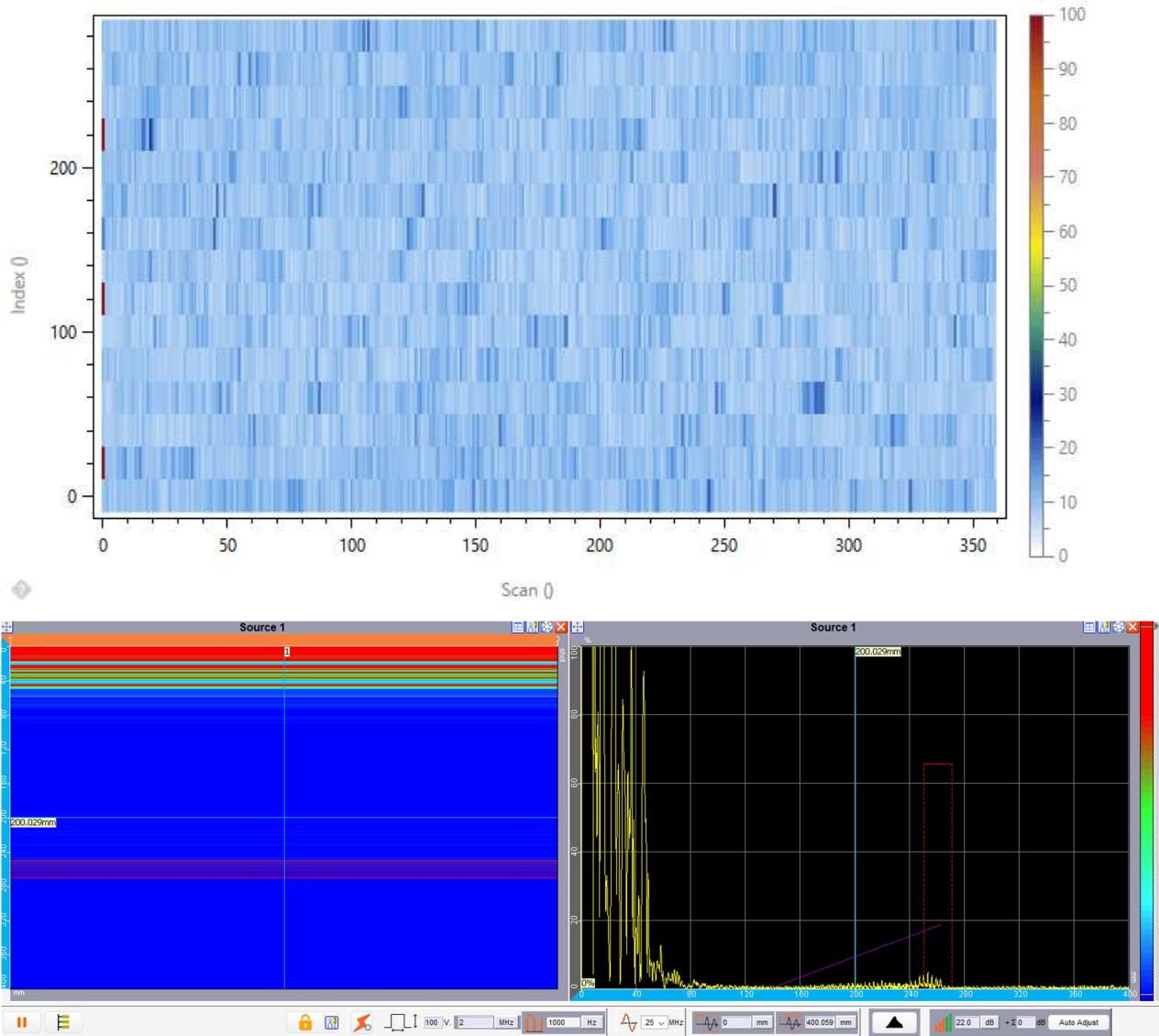
Scan 5

Scan type	D1 Direction, 38°, Circumferential, Counter Clockwise
Scan length	360 degree
Index length	420
Probe	Angle, 38°
No of Element	1



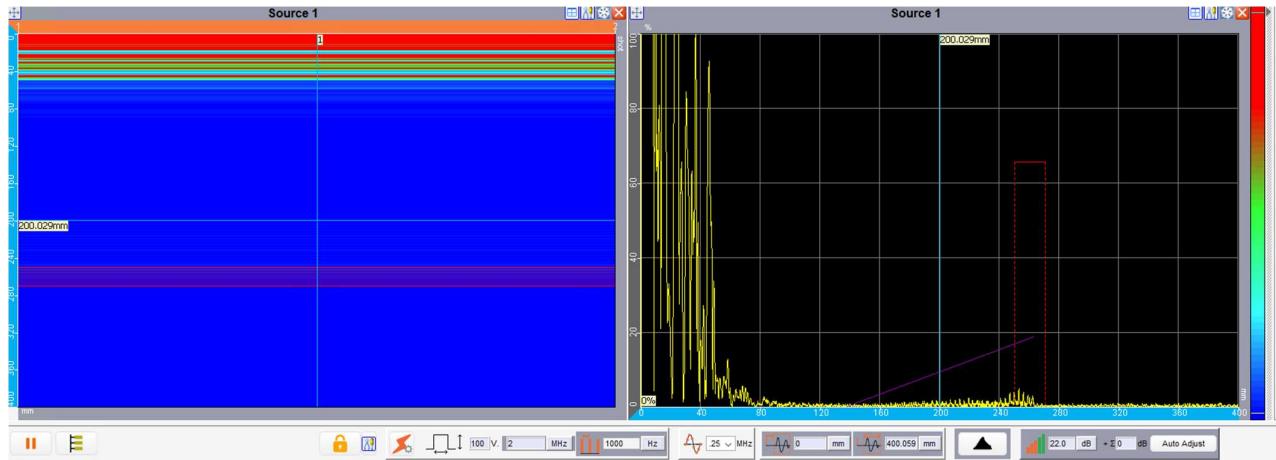
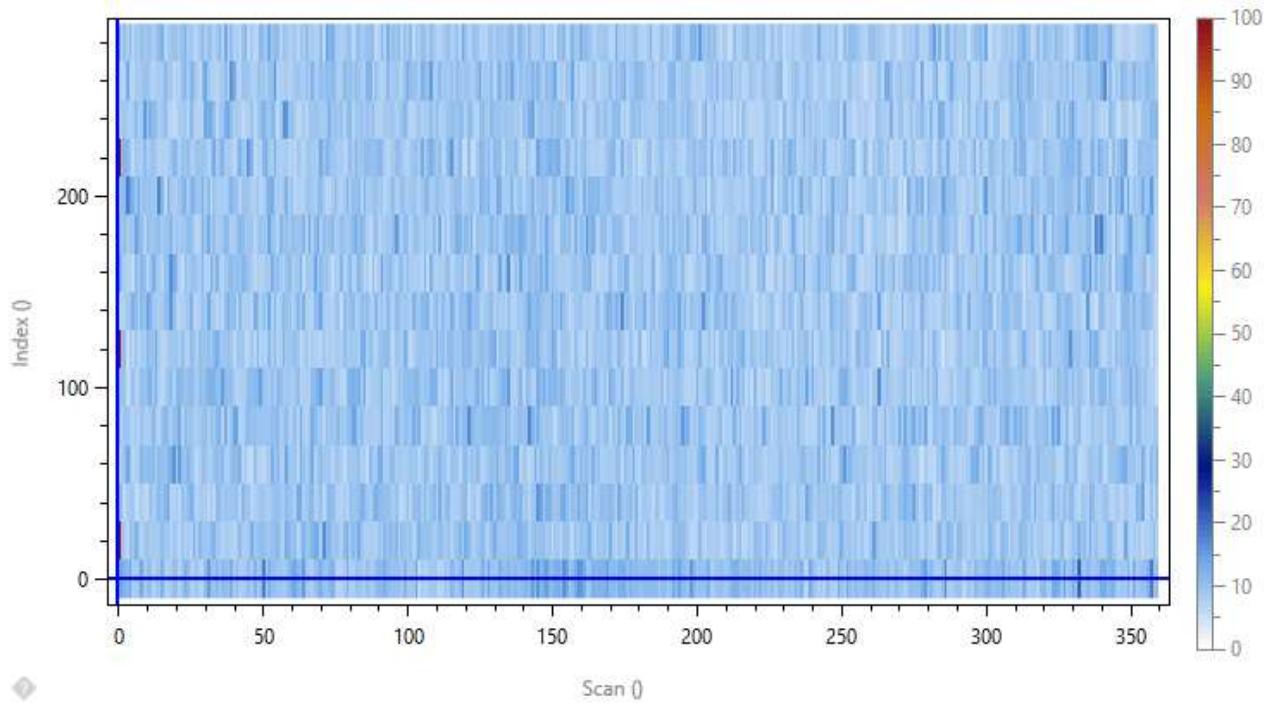
Scan 6

Scan type	F Direction, 38°, Circumferential, Clockwise
Scan length	360 degree
Index length	290 mm
Probe	Angle 38°, 2 MHz
No of Element	1



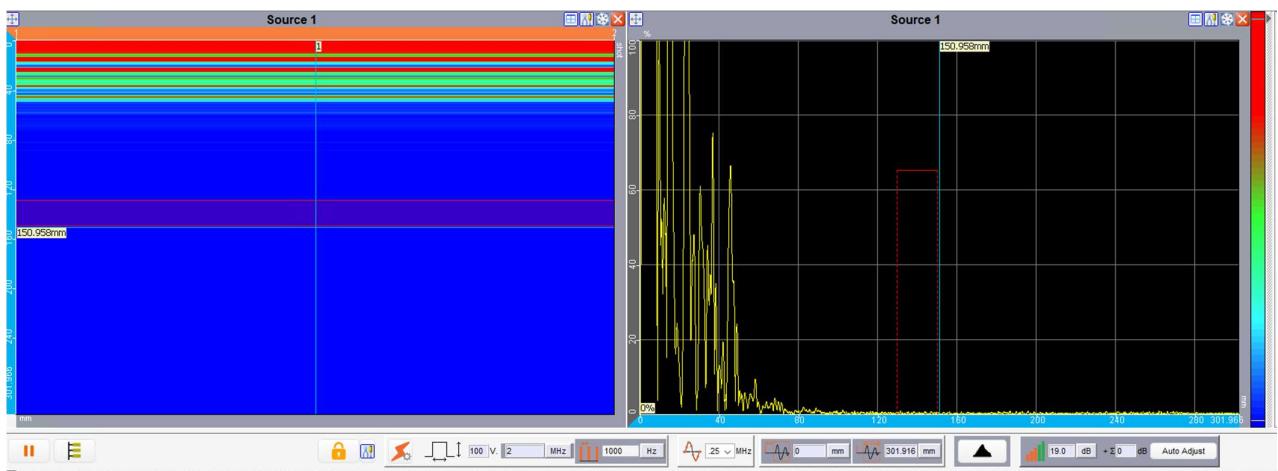
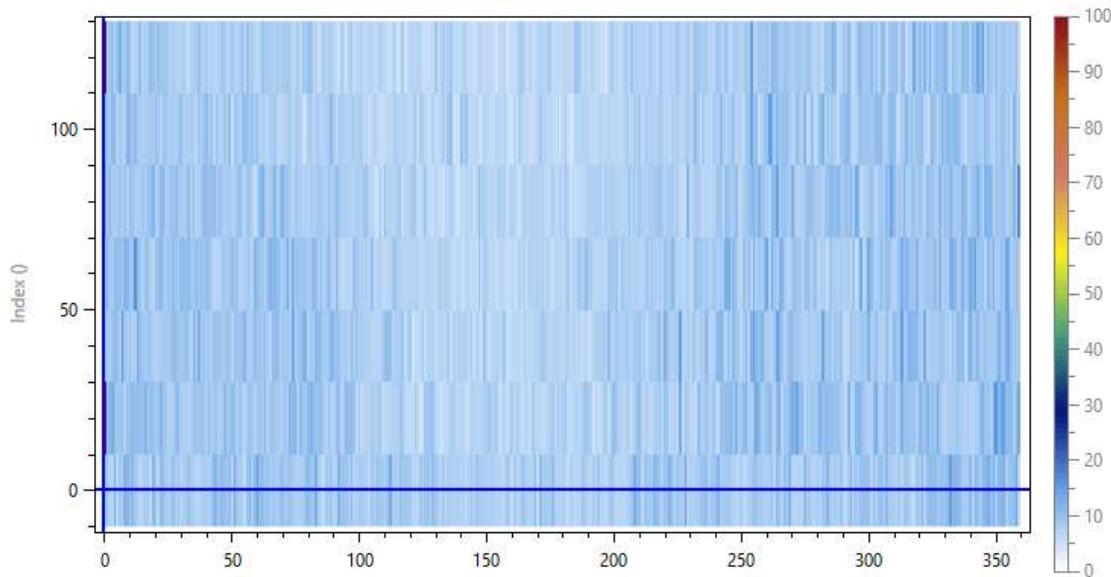
Scan 7

Scan type	F1 Direction 38°, Circumferential, Counter Clockwise
Scan length	360 degree
Index length	290 mm
Probe	Angle 38°, 2 MHz
No of Element	1



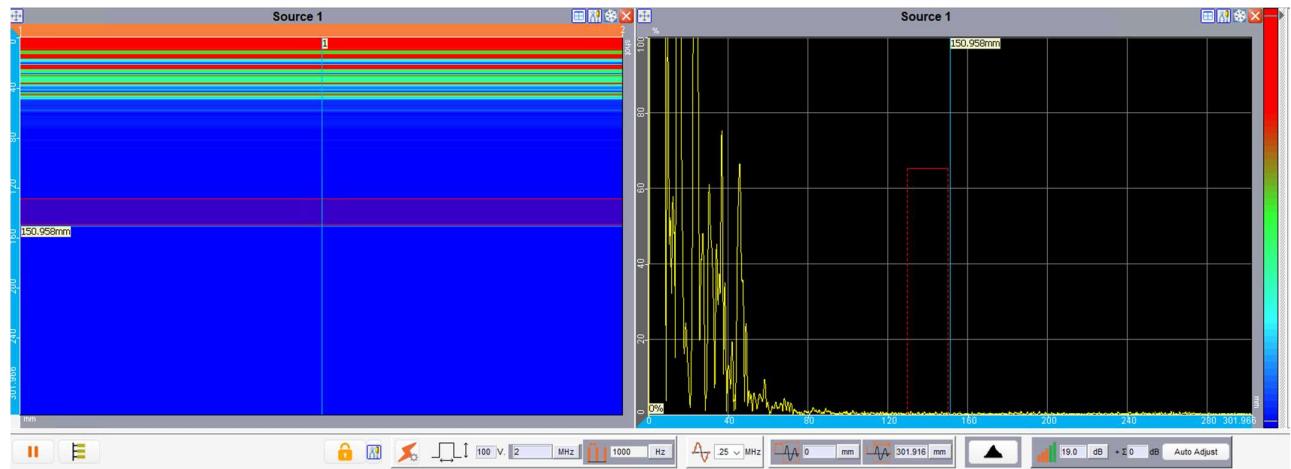
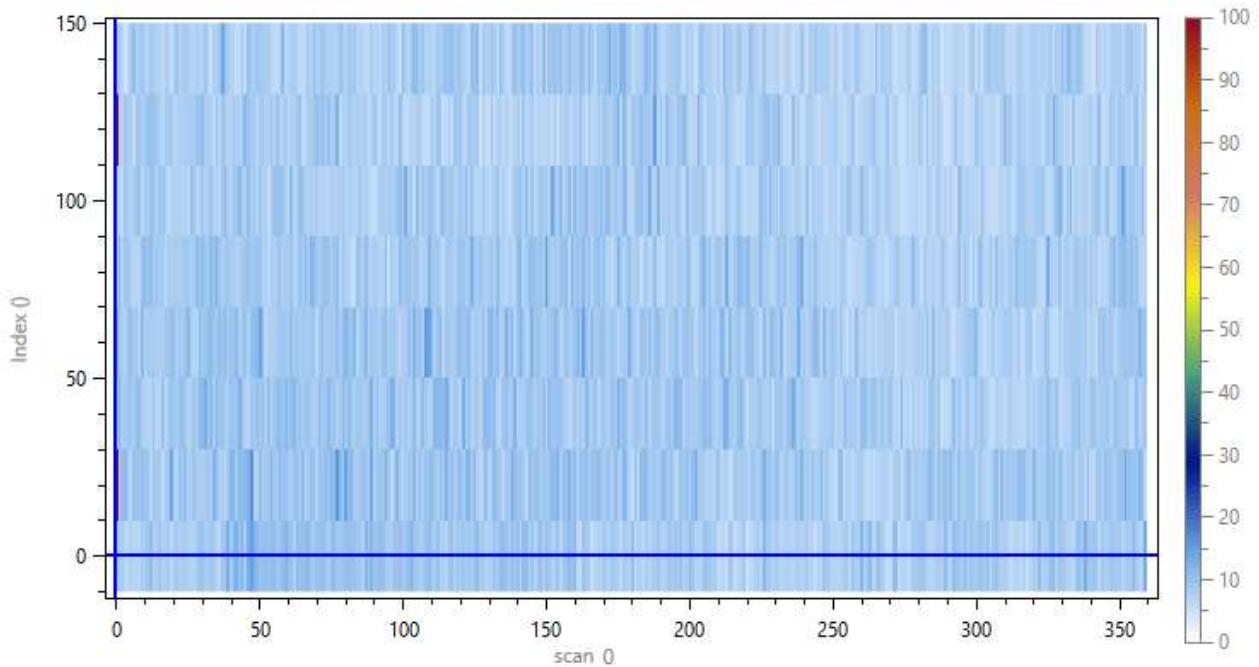
Scan 8

Scan type	H Direction 38°, Circumferential Clockwise
Scan length	360 degree
Index length	130 mm
Probe	Angle 38°, 2 MHz
No of Element	1



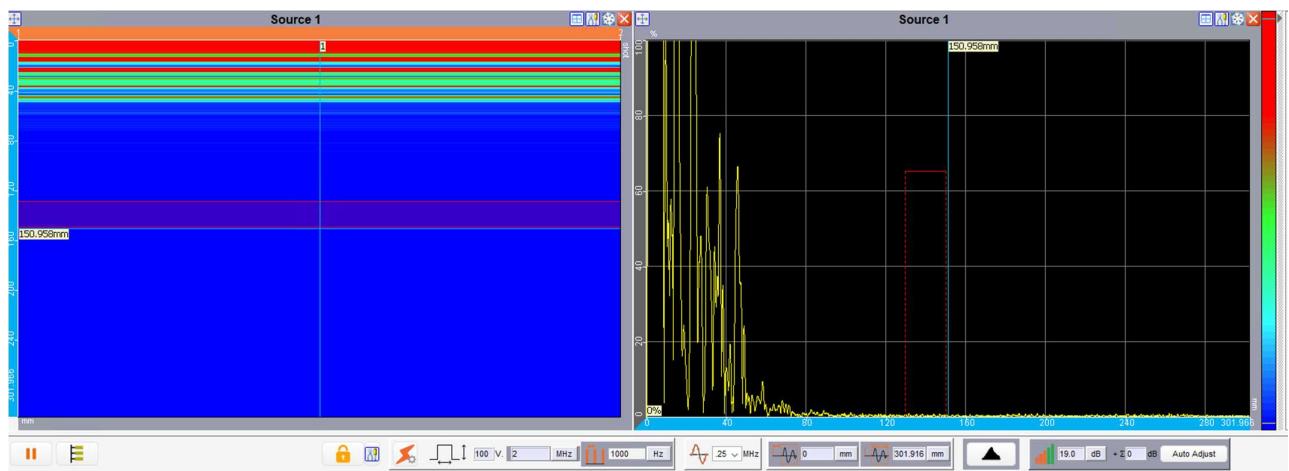
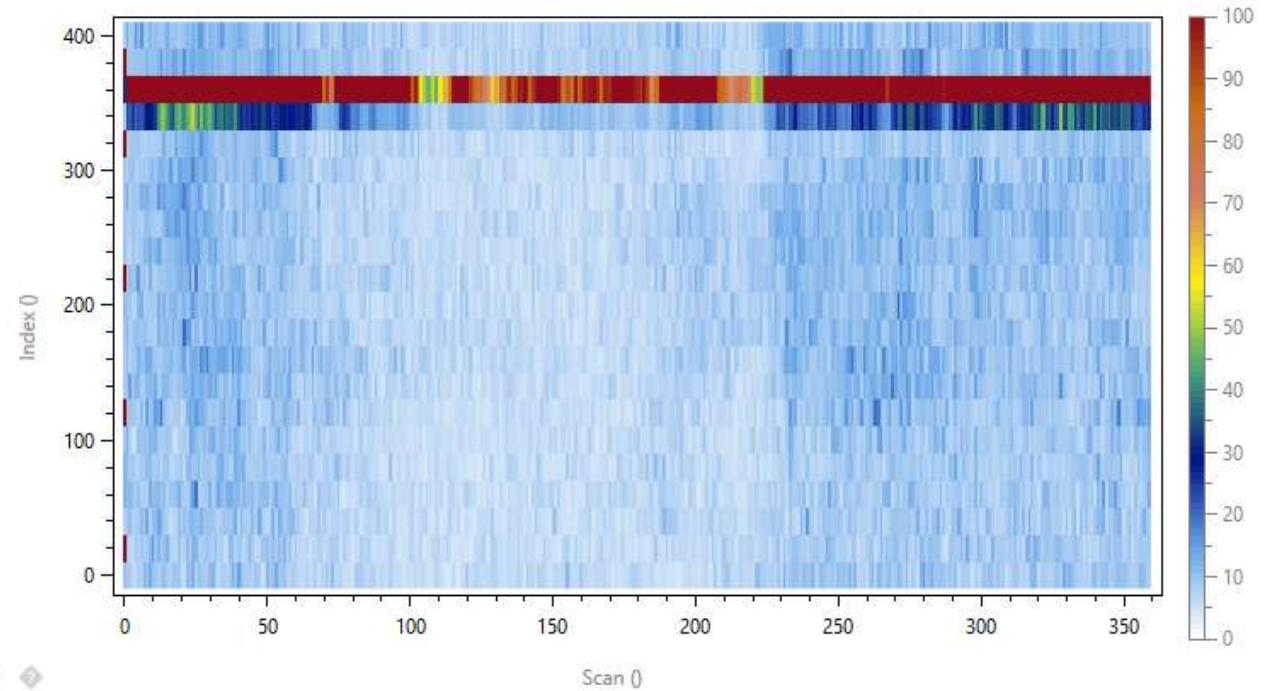
Scan 9

Scan type	H1 Direction 38°, Circumferential, Counter Clockwise
Scan length	360 degree
Index length	150 mm
Probe	Angle 38°, 2 MHz
No of Element	1



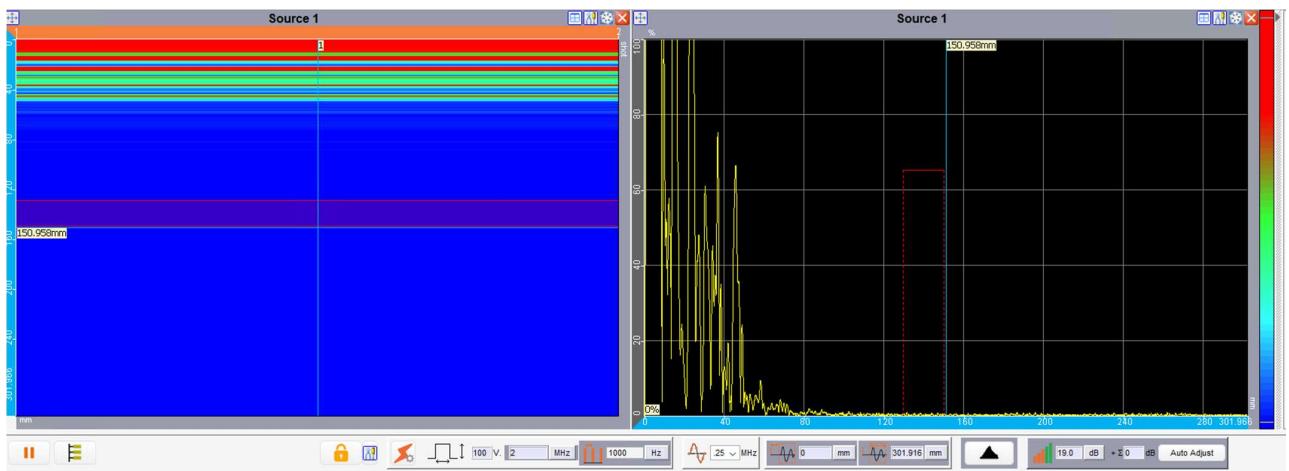
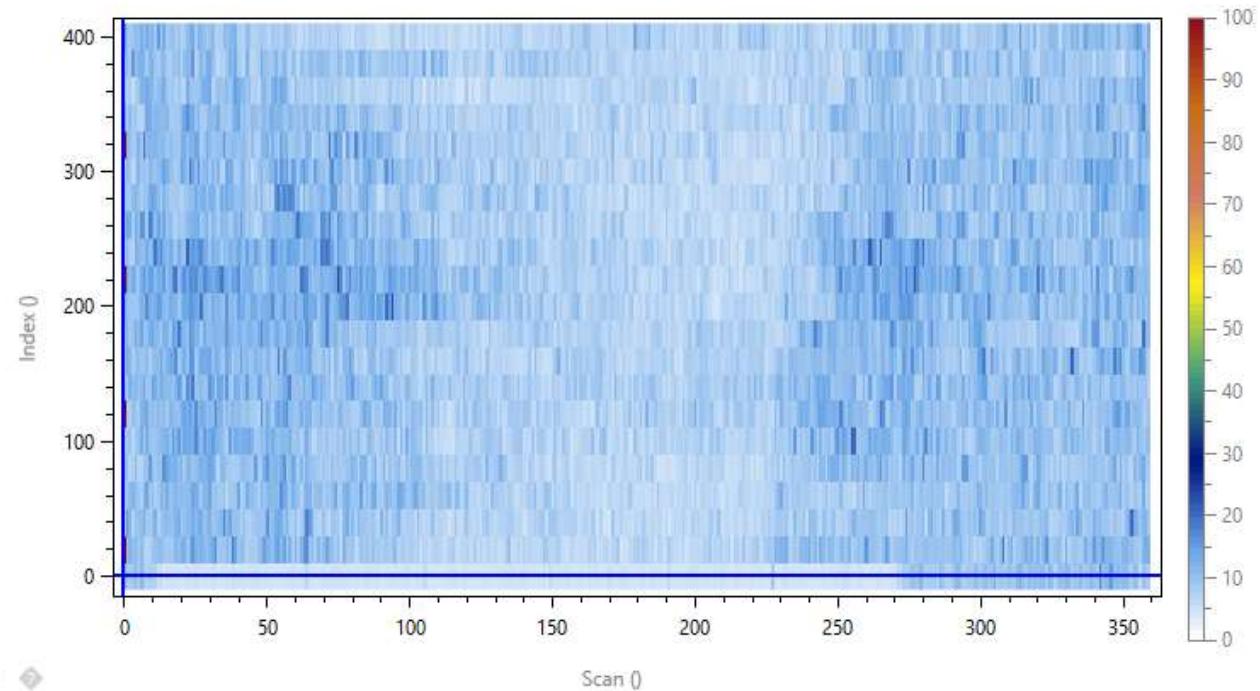
Scan 10

Scan type	E Direction 38°, Axial, Forward
Scan length	360 degree
Index length	420 mm
Probe	Angle 38°, 2 MHz
No of Element	1



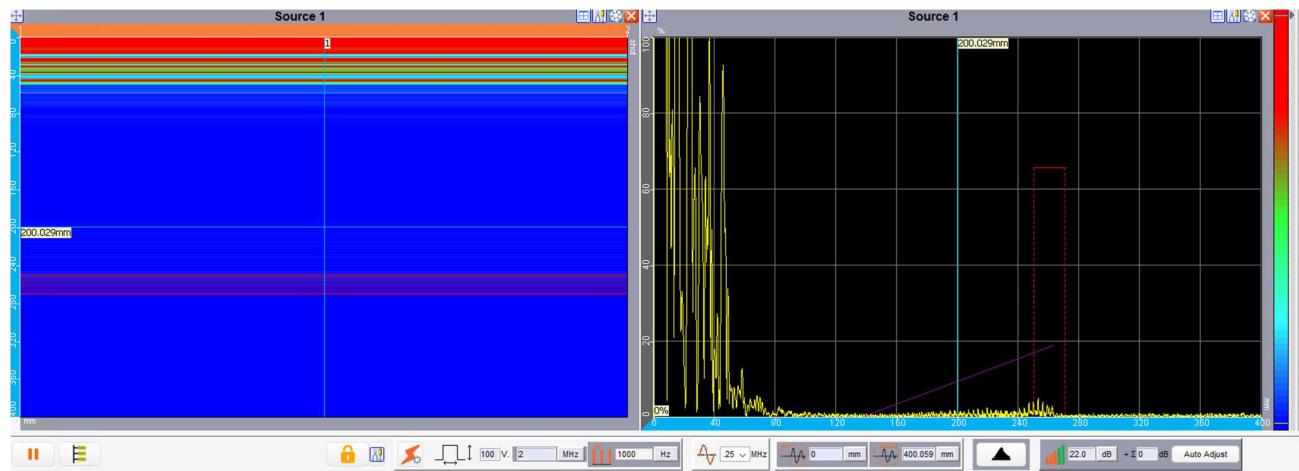
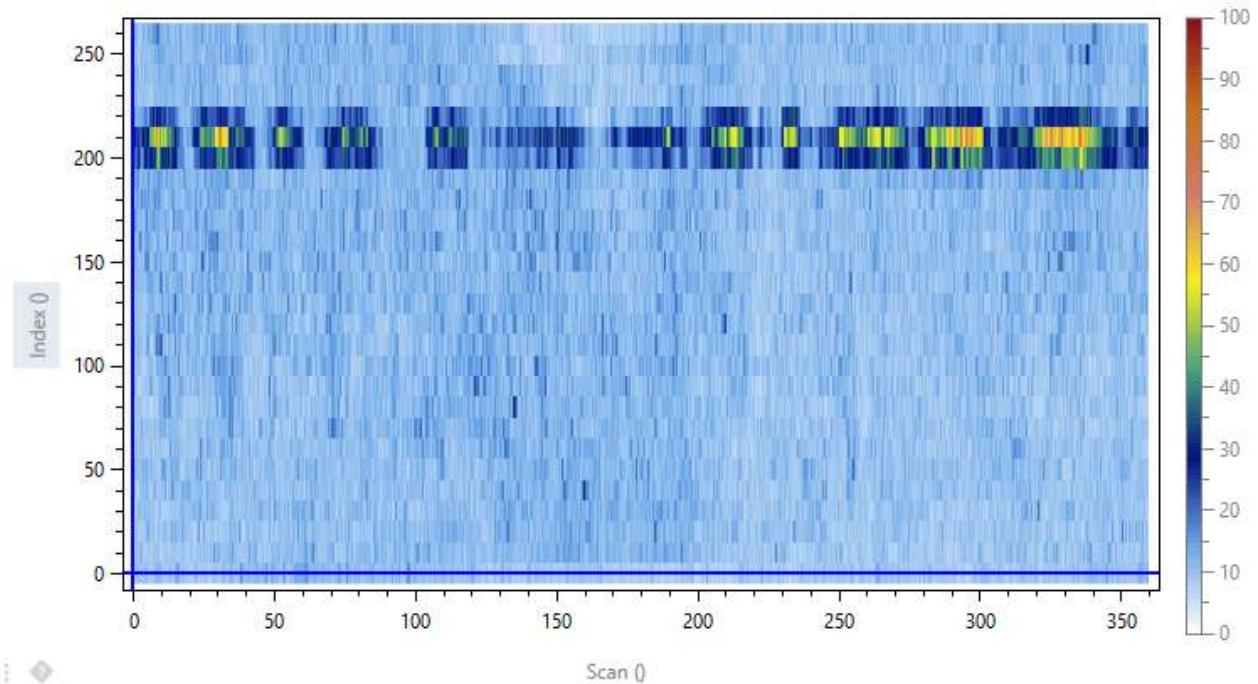
Scan 11

Scan type	E1 Direction 38°, Axial, Backward
Scan length	360 degree
Index length	420 mm
Probe	Angle 38°, 2 MHz
No of Element	1



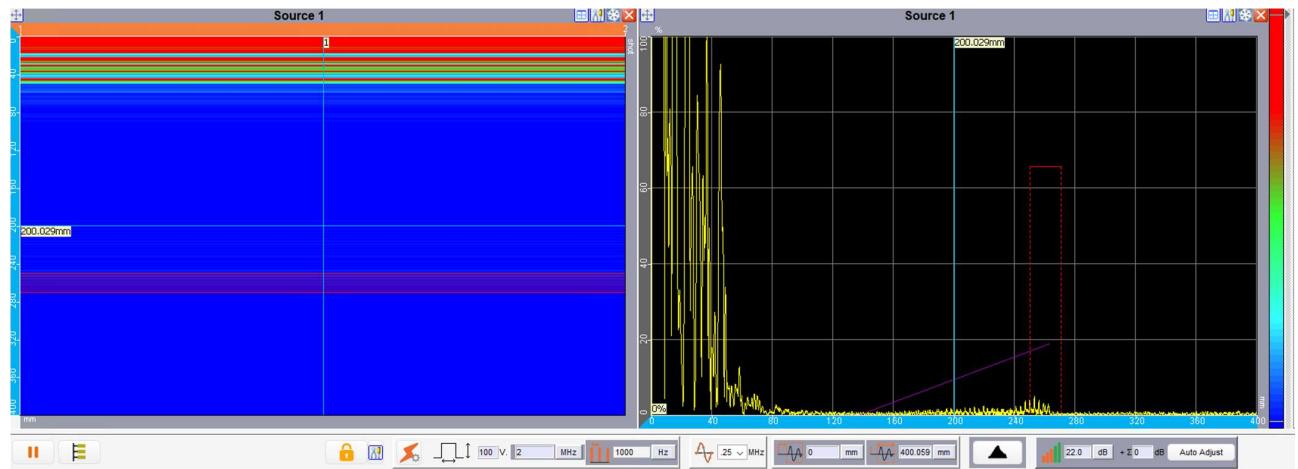
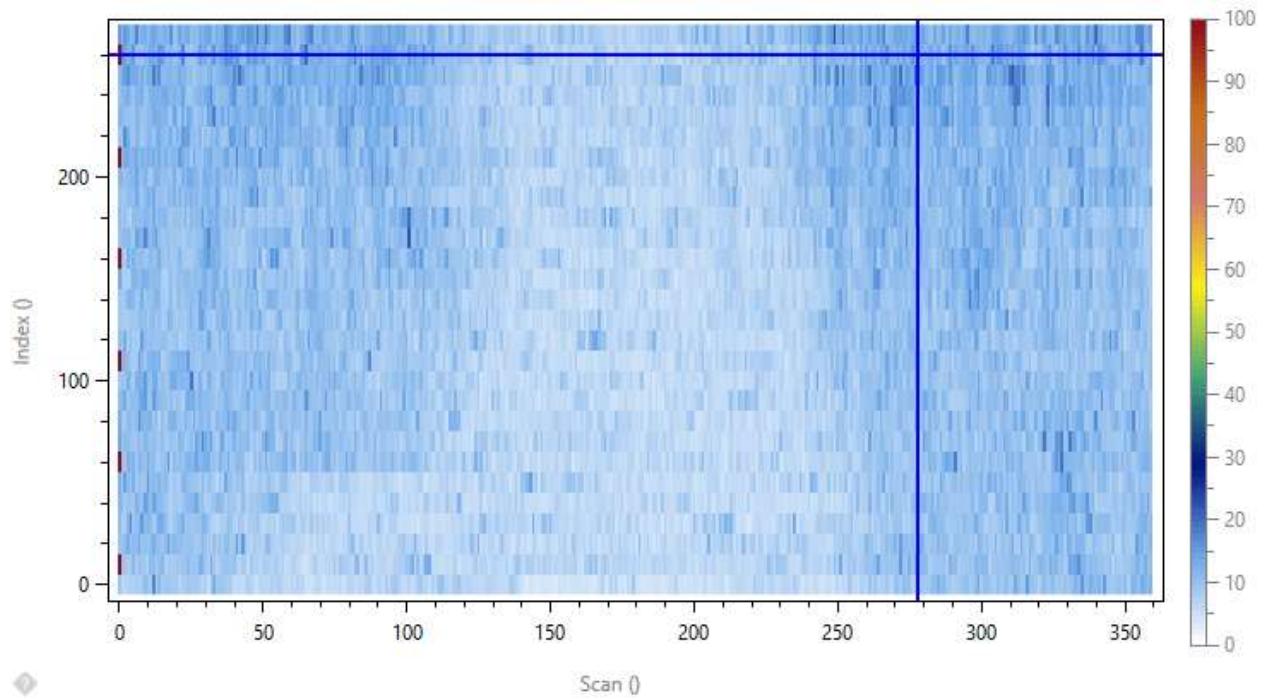
Scan 12

Scan type	G Direction 38°, Axial Forward
Scan length	360 degree
Index length	270 mm
Probe	Angle 38°, 2 MHz
No of Element	1



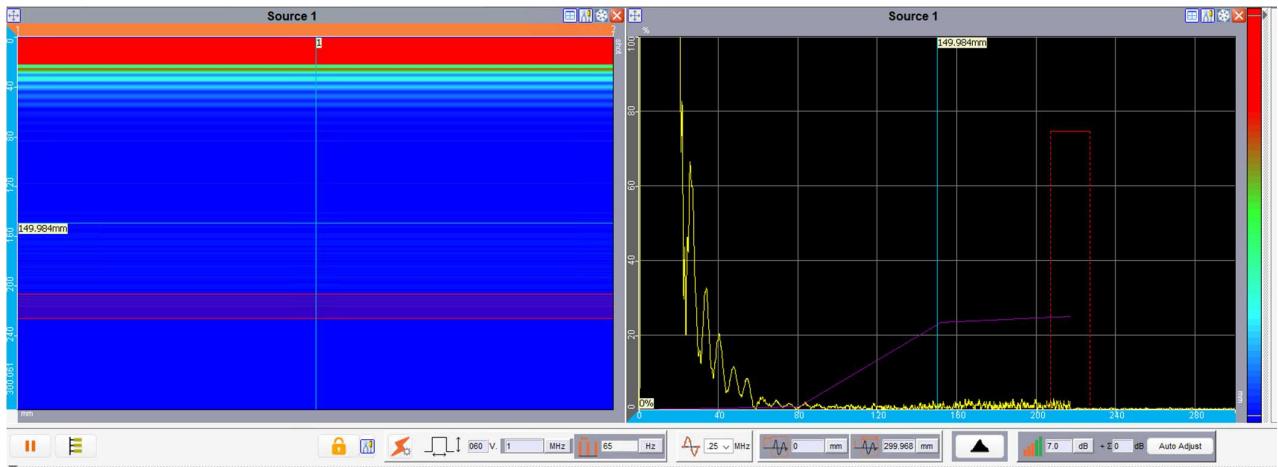
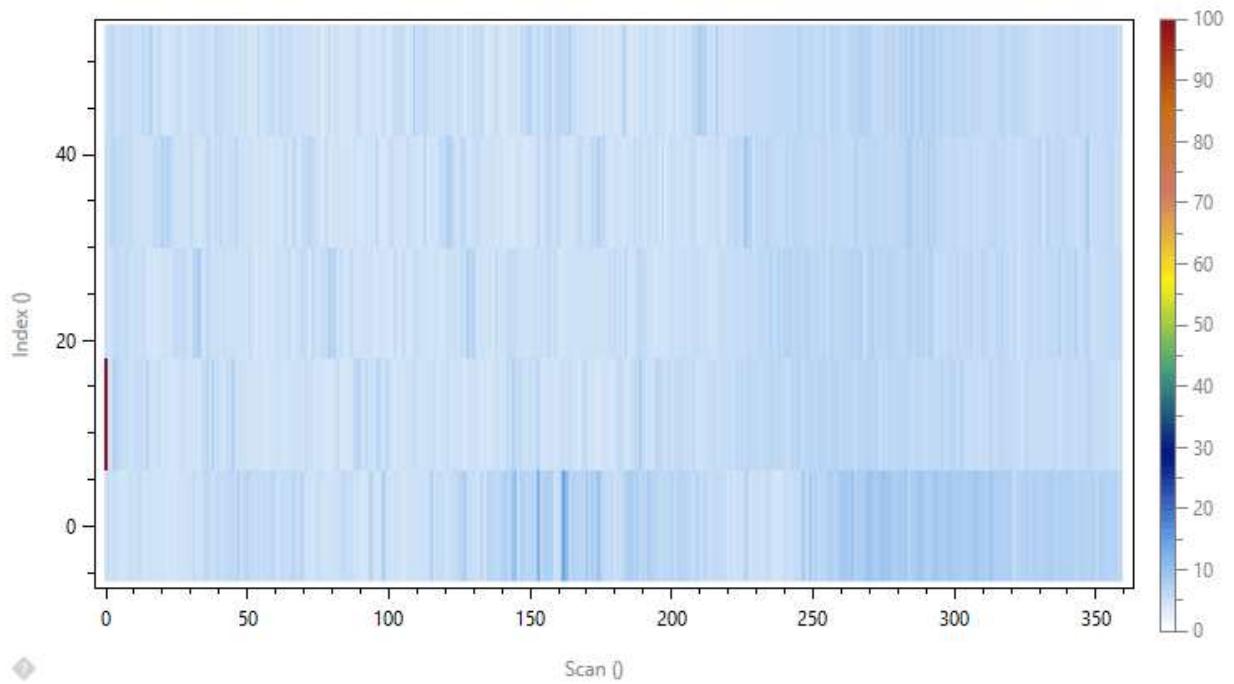
Scan 13

Scan type	G1 Direction 38°, Axial Backward
Scan length	360 degree
Index length	280 mm
Probe	Angle 38°, 2 MHz
No of Element	1



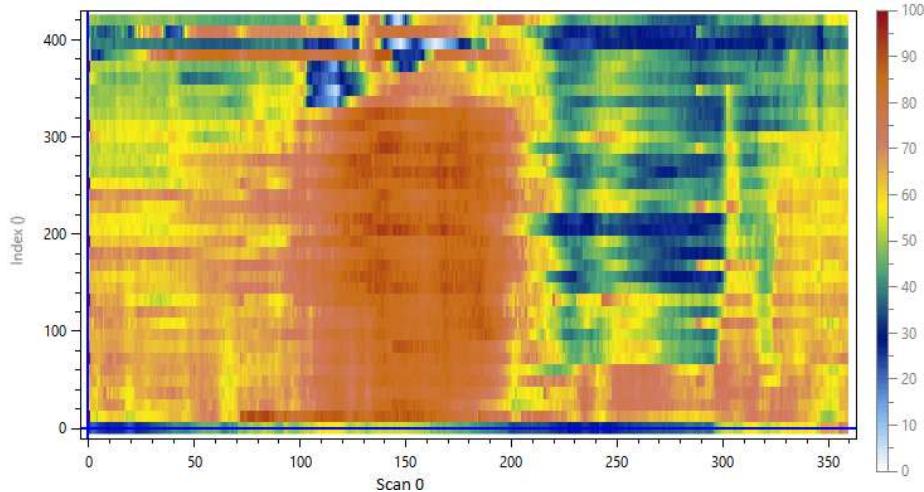
Scan 14

Scan type	J Direction 0°, face1
Scan length	360 degree
Index length	60 mm
Probe	Normal, 1 MHz
No of Element	1

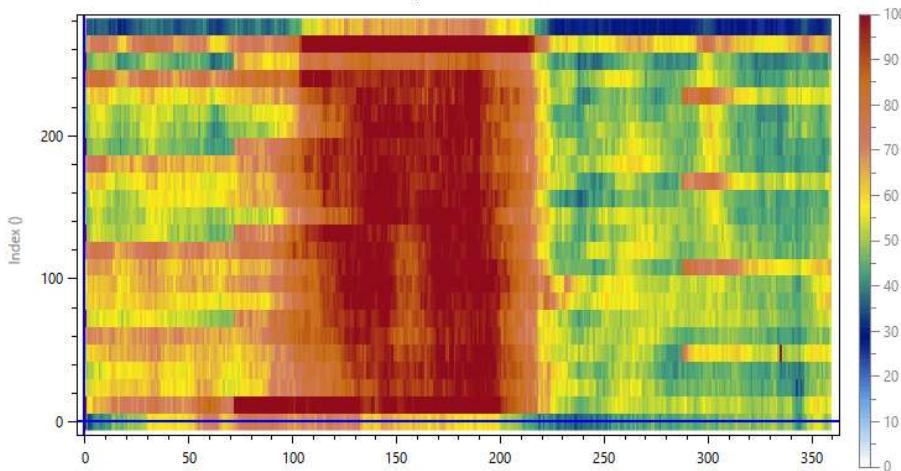


Scan 15

Scan type	A1 Direction 0°
Scan length	360 degree
Index length	420 mm
Probe	Normal, 1 MHz
No of Element	1

**Scan 16**

Scan type	B1 Direction 0°
Scan length	360 degree
Index length	280 mm
Probe	Normal, 1 MHz
No of Element	1



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Remarks: -

1. Inaccessible Dead Zone area in direction B that was not covered in AUT is covered with manual UT using TR Probe.
2. Inaccessible Dead Zone area in Direction J, K, L & M that was not covered in AUT is covered during the manual UT with TR probe according to 6mm FBH.
3. Inaccessible Zone area in direction I (axial forward) and I1 (axial backward) that was not covered in AUT is covered with manual UT using angle probe.
4. Inaccessible Zone area in Direction K, L & M that was not covered in AUT is covered with manual UT using normal probe.