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|  | CHW Forge Private Limited | Doc. No. : QAQC/UT/AUT/E-324/1 |
| | Ultrasonic Examination Report | Current Rev. : 0 |
| | (Part No. UCP-210-15076-000) | 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 | | | | |

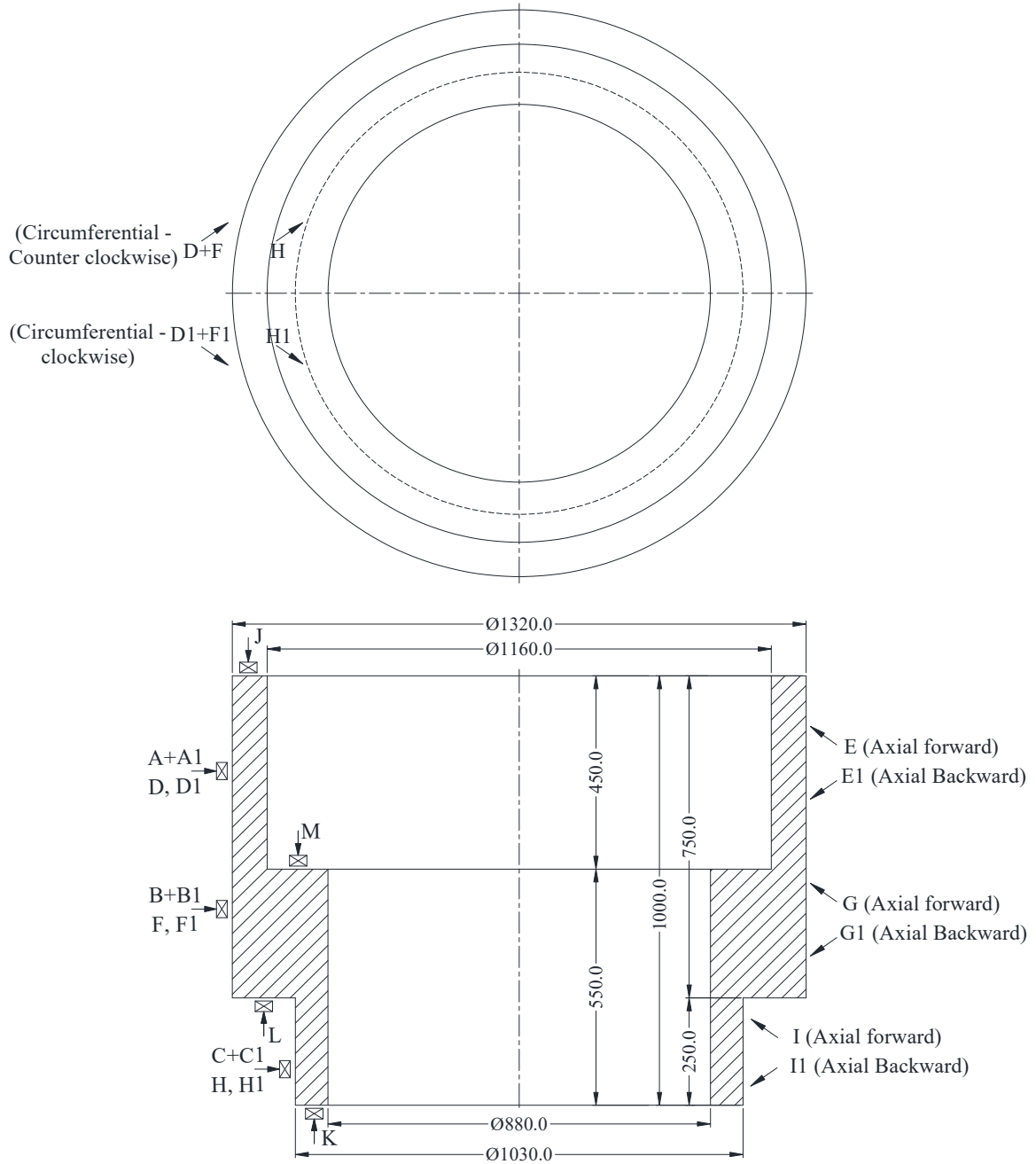
| | |
|--|-----------------|
| Observations: | Results |
| No Recordable indication observed in scanning. | Accepted |
| No back wall Loss greater than 50% observed during the scanning. | Accepted |
| Remarks: | |


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| Tested By | Approved By |
| Suneel Sharma  | |



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Doc. No. : QAQC/UT/AUT/E-324/1
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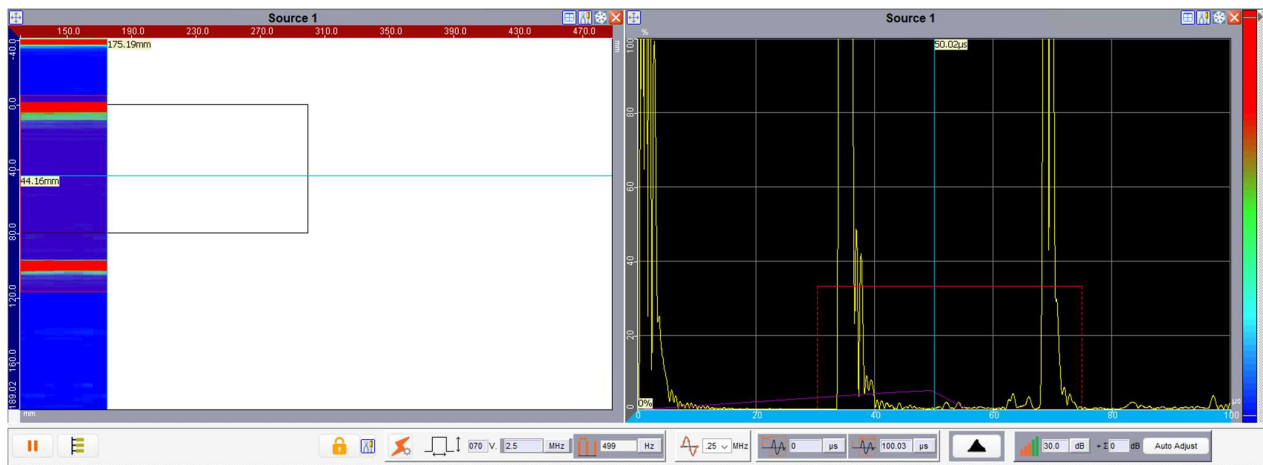
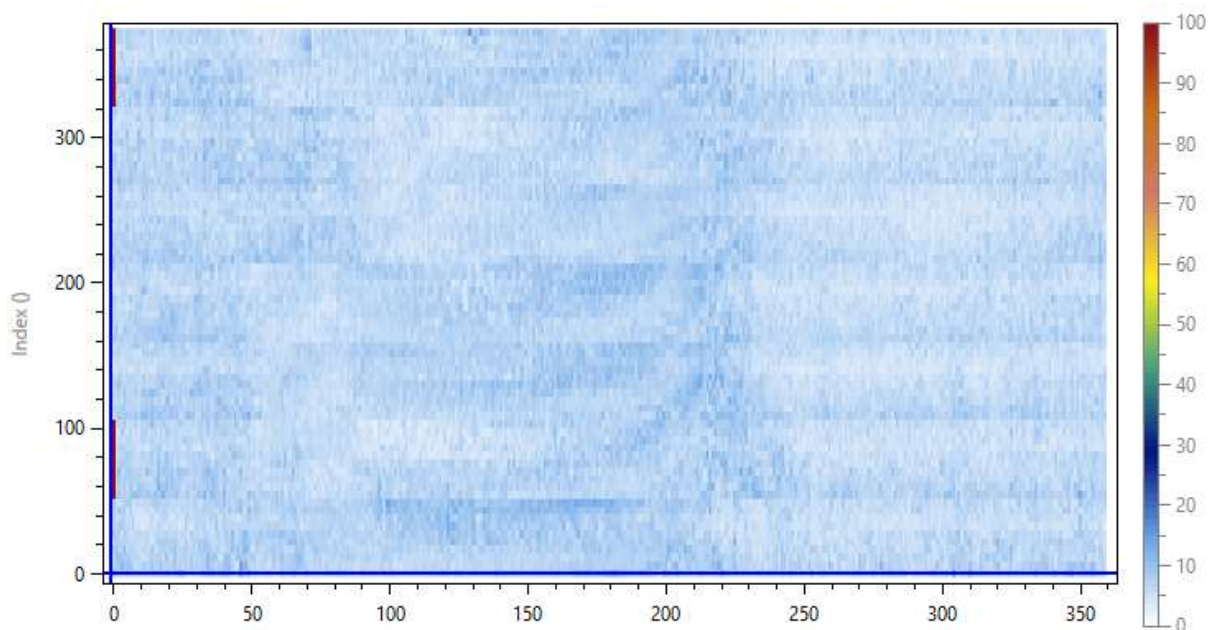
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|  | <p>CHW Forge Private Limited</p> <p>Ultrasonic Examination Report</p> <p>(Part No. UCP-210-15076-000)</p> | <p>Doc. No. : QAQC/UT/AUT/E-324/1</p> <p>Current Rev. : 0</p> <p>Date of Rev. : 12-12-2024</p> <p>No. of Pages : Page 3 of 19</p> |
|--|--|---|

| 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

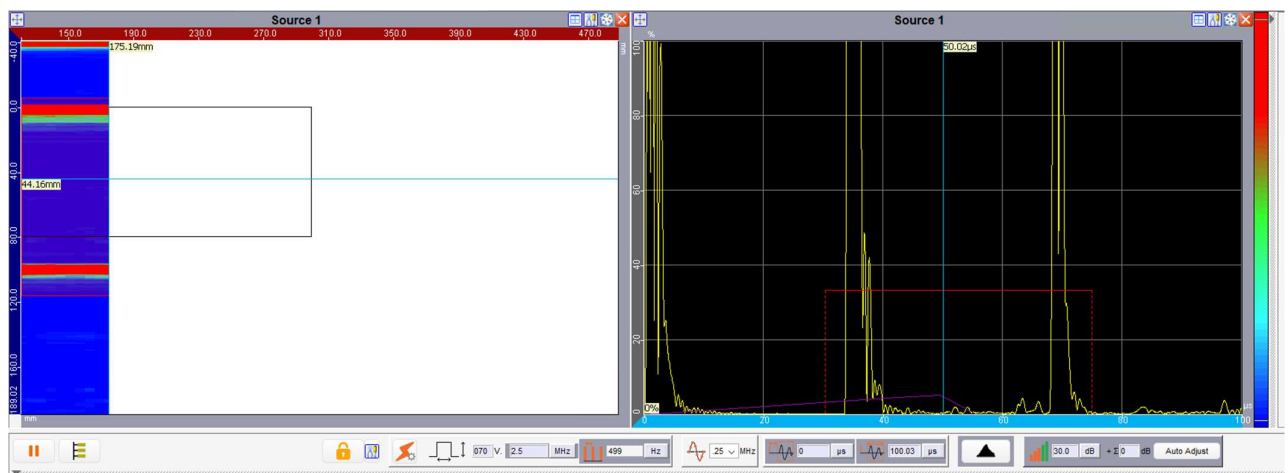
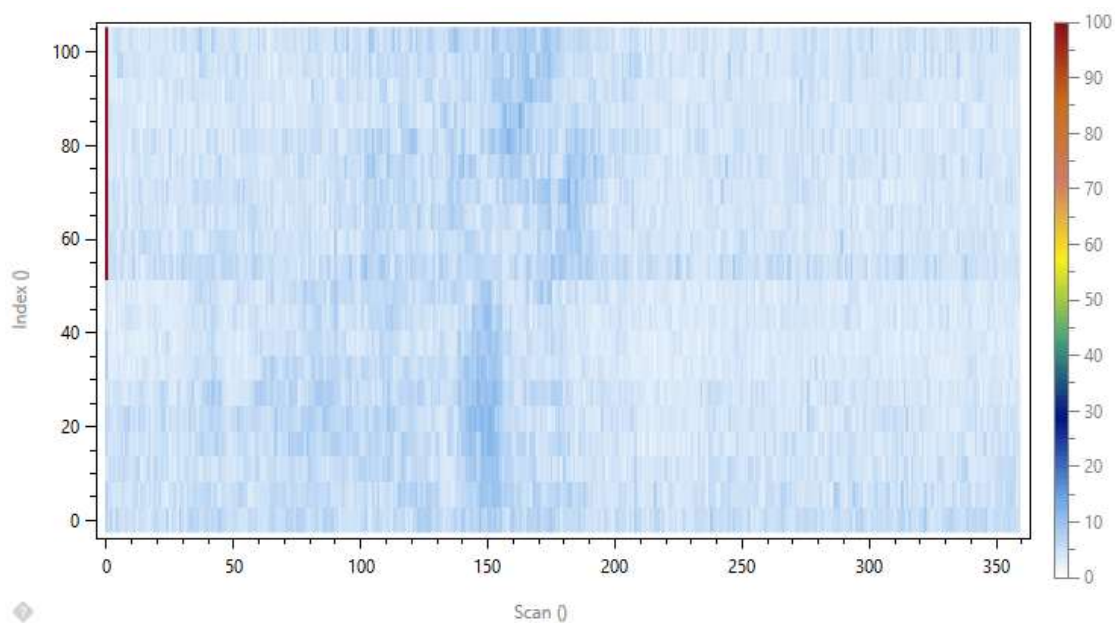
Scan 1

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



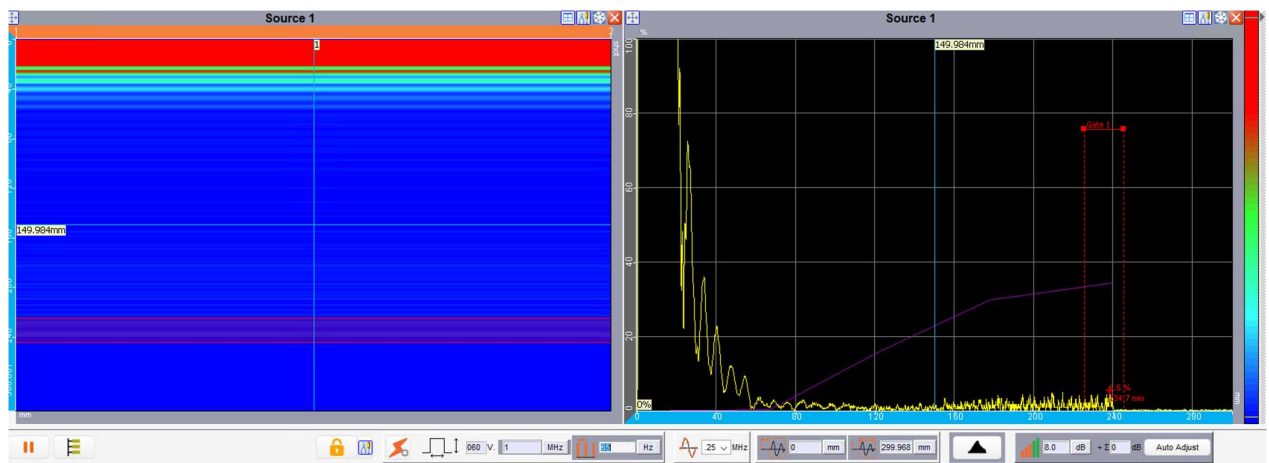
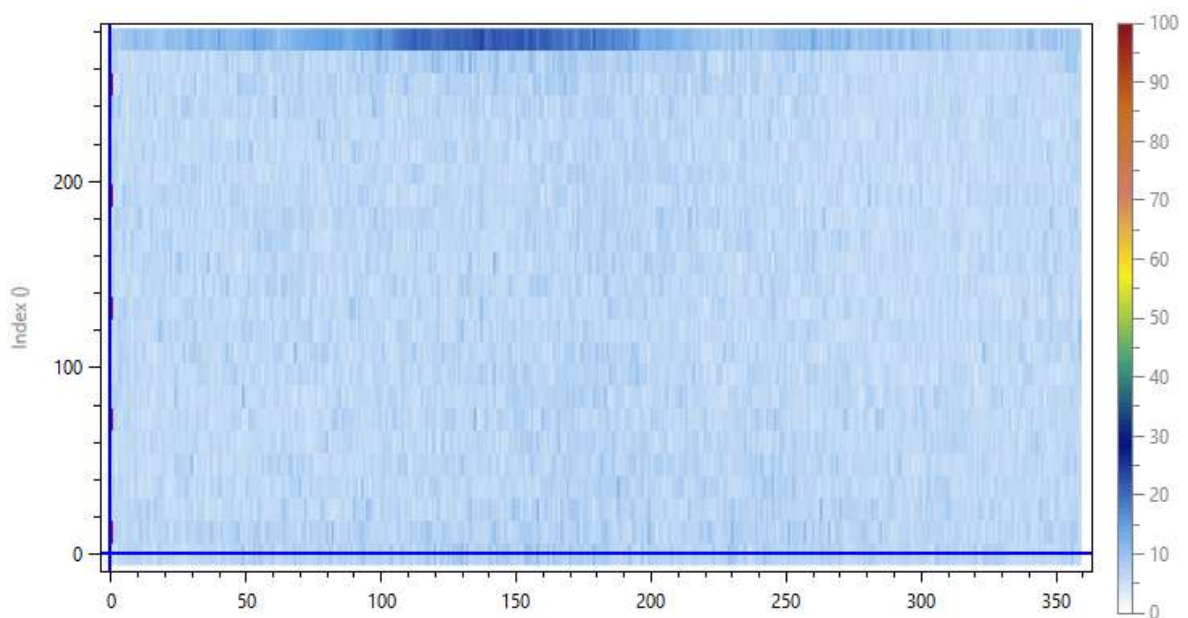
Scan 2

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



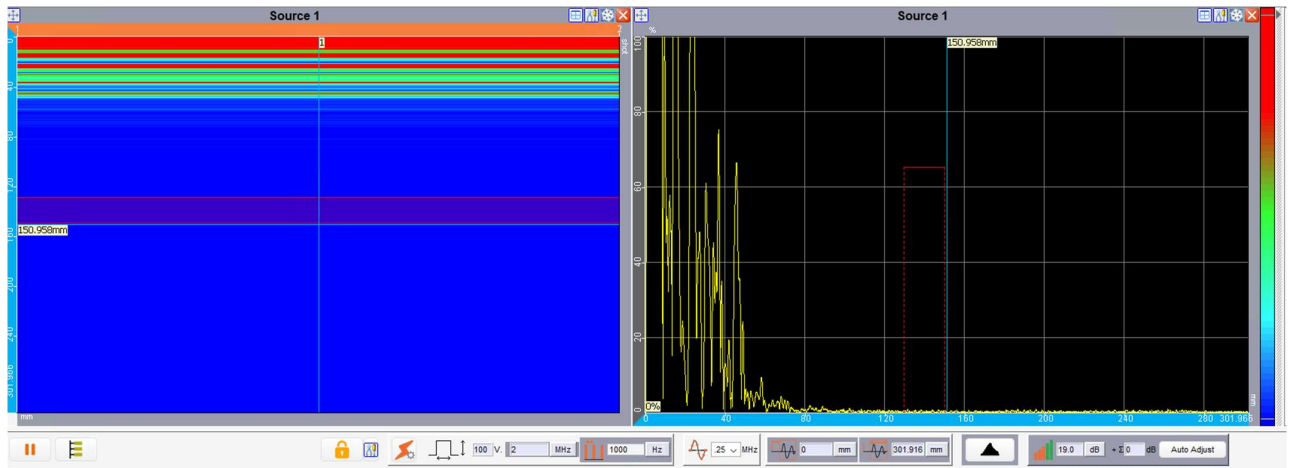
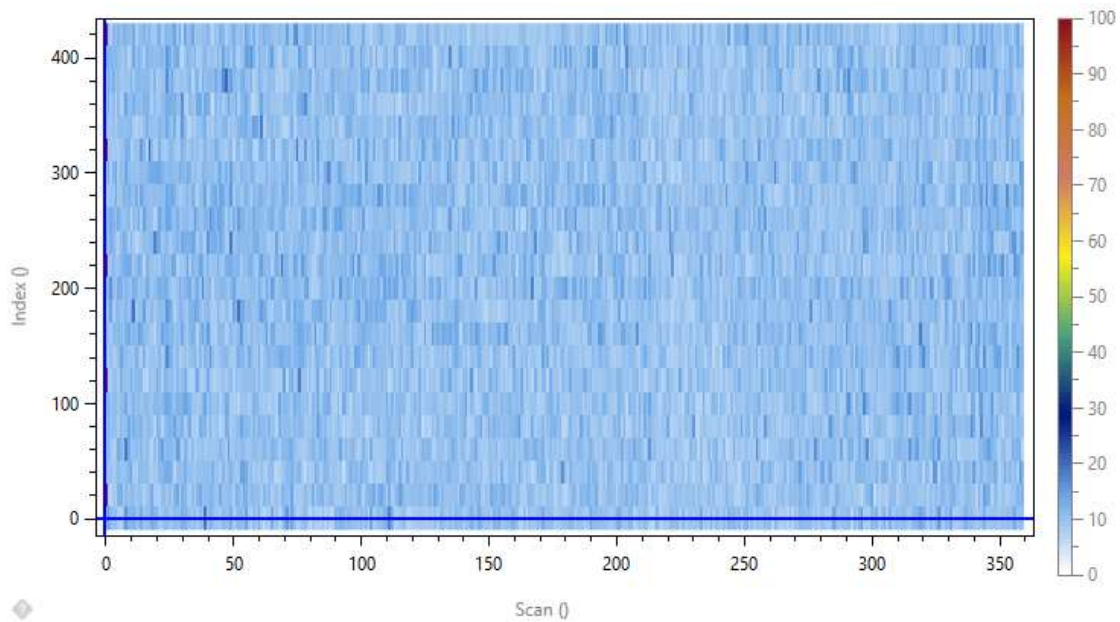
Scan 3

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



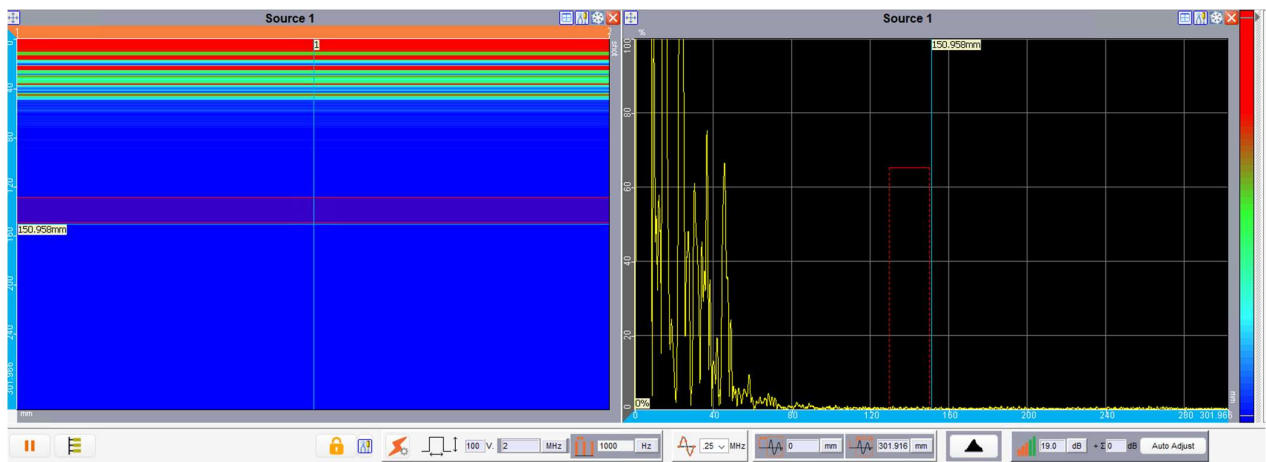
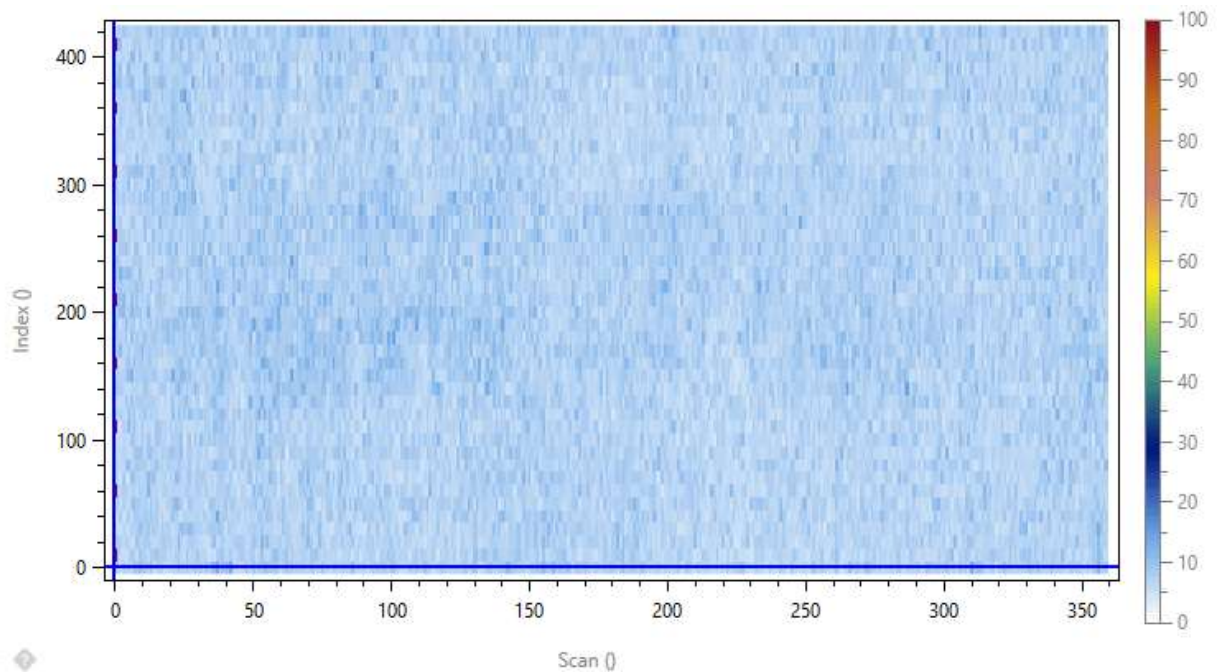
Scan 4

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



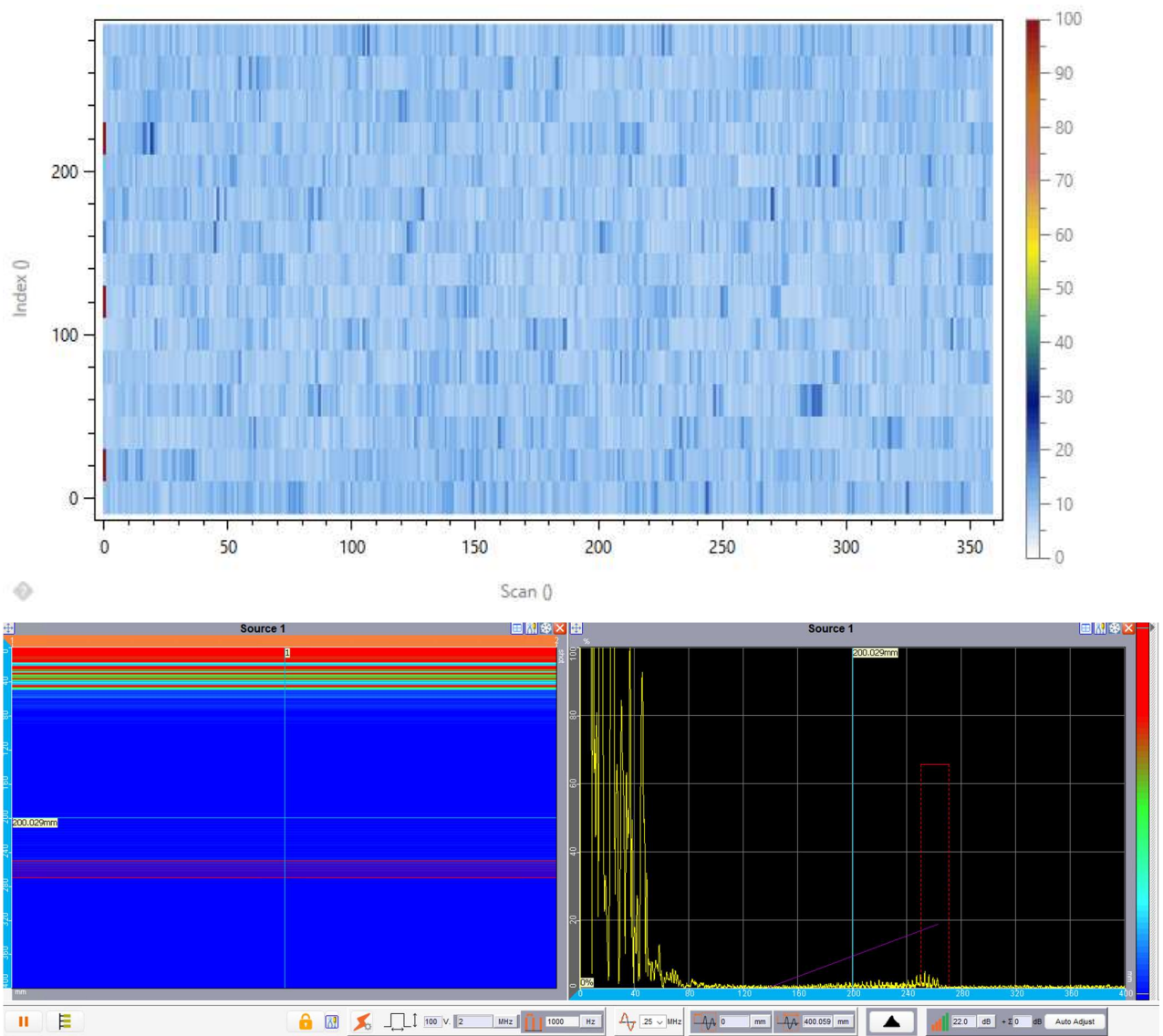
Scan 5

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



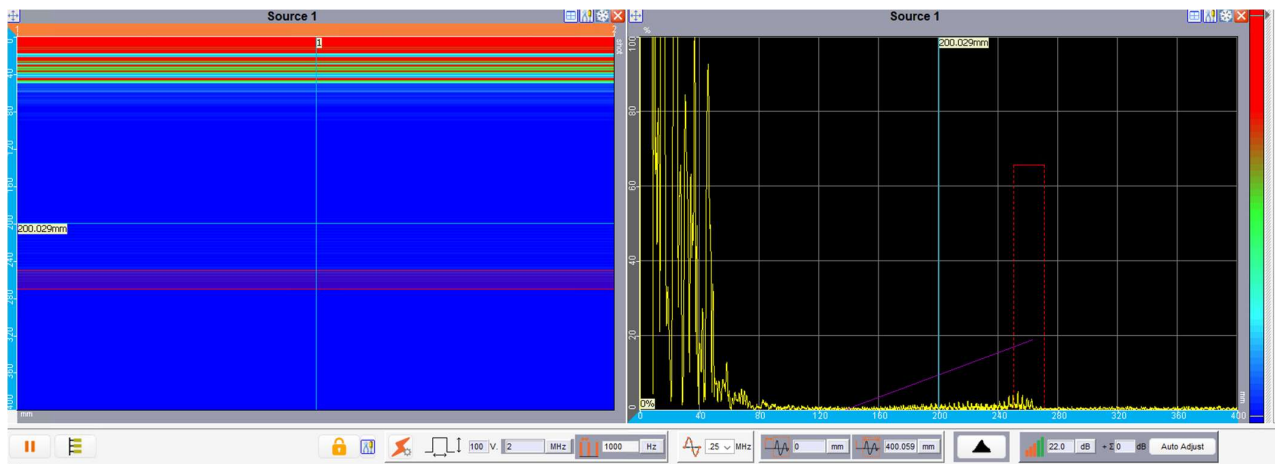
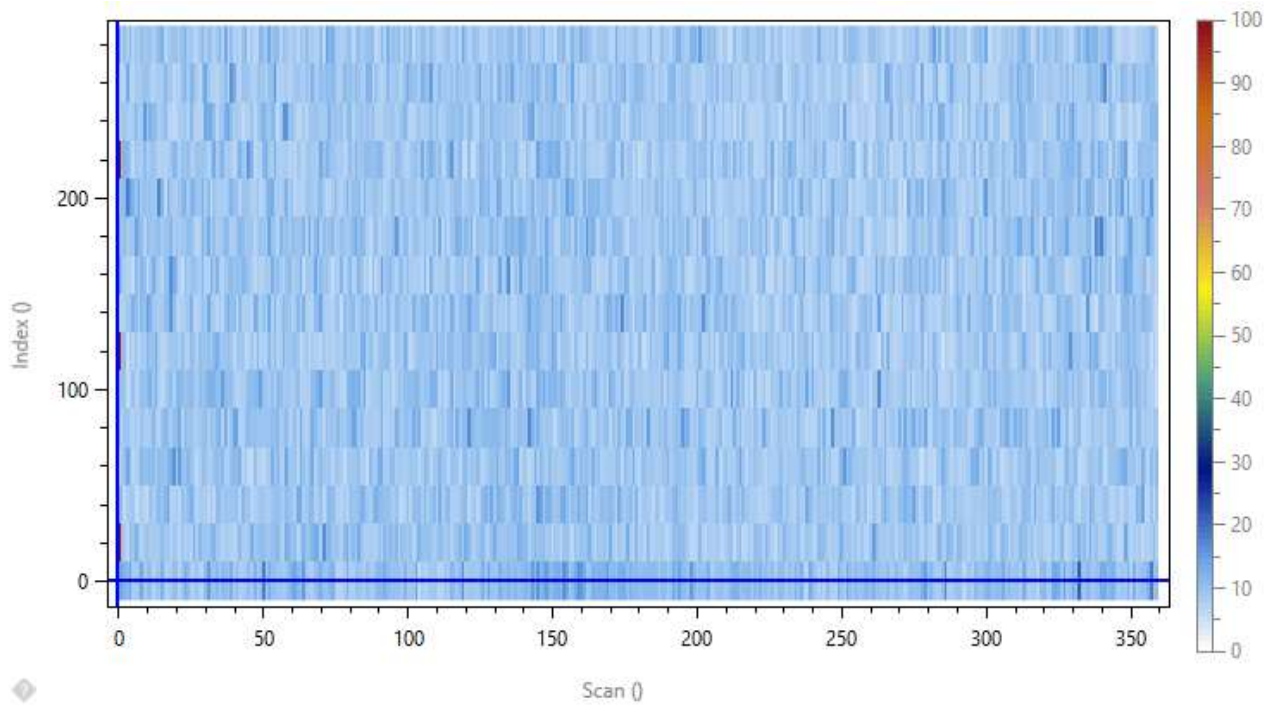
Scan 6

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



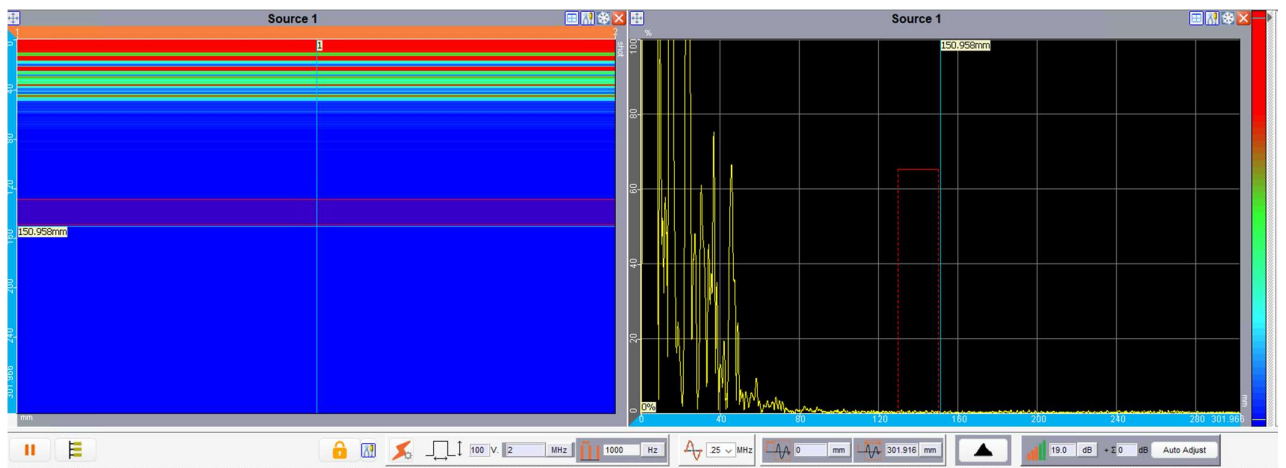
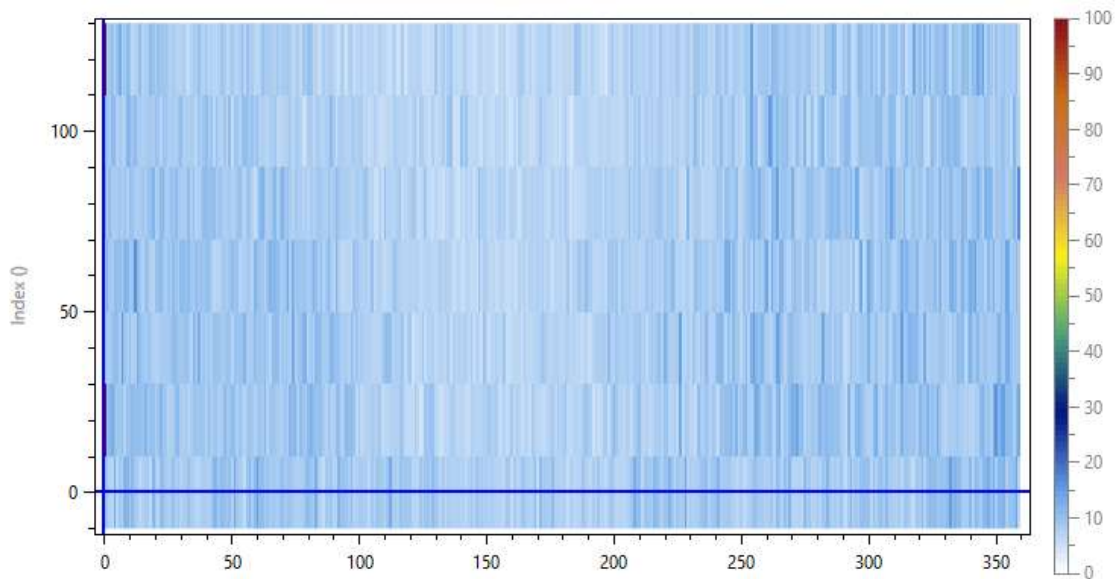
Scan 7

| | |
|---------------|--|
| 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 |



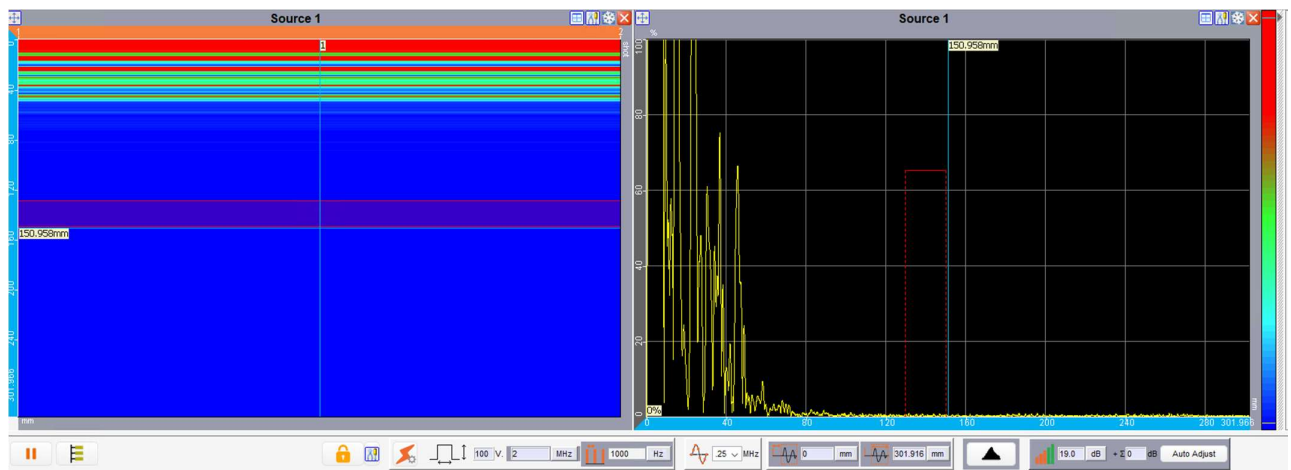
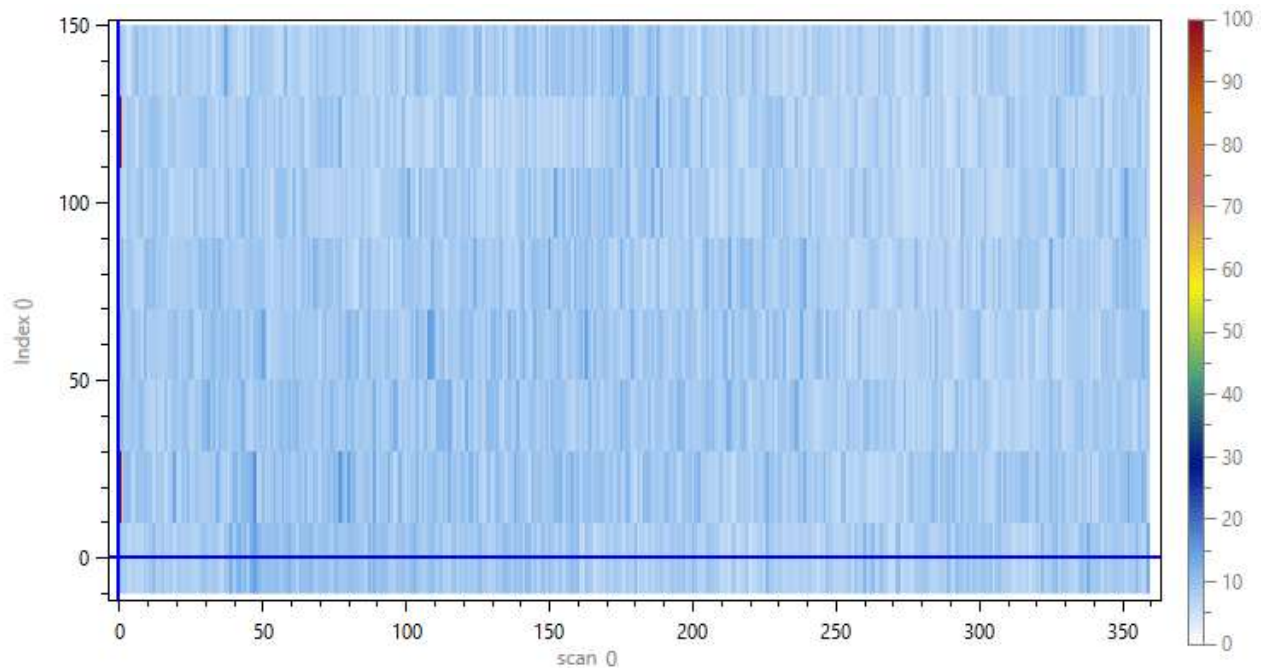
Scan 8

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



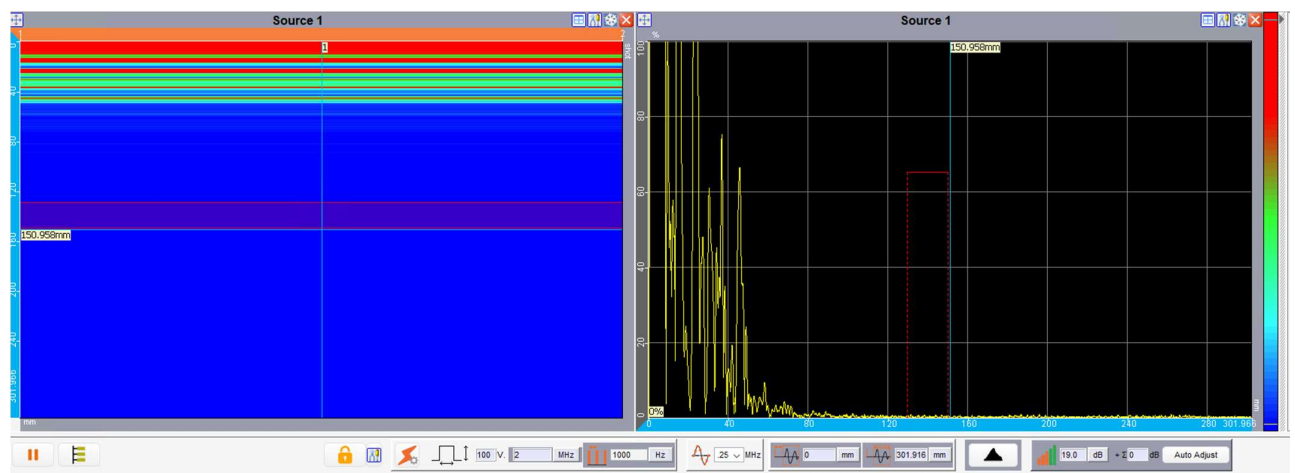
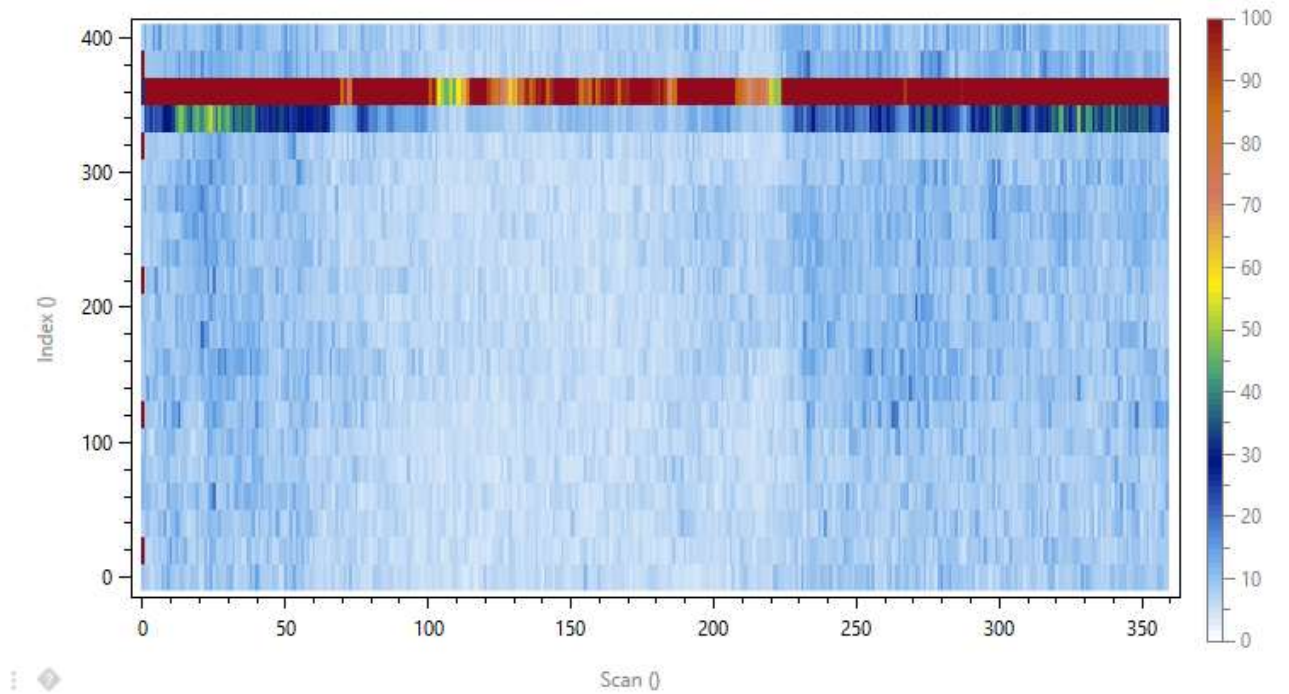
Scan 9

| | |
|---------------|--|
| 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 |



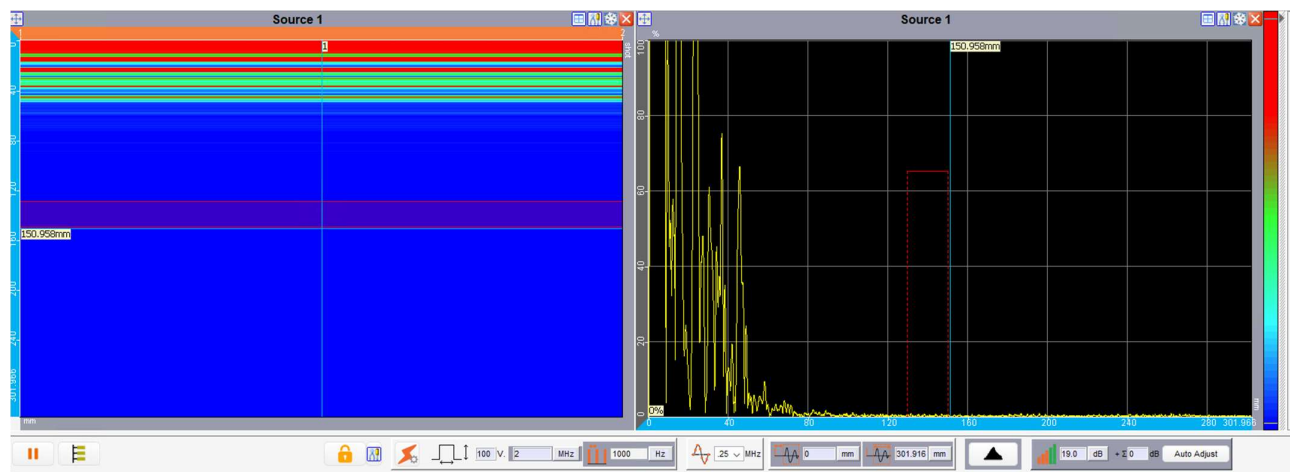
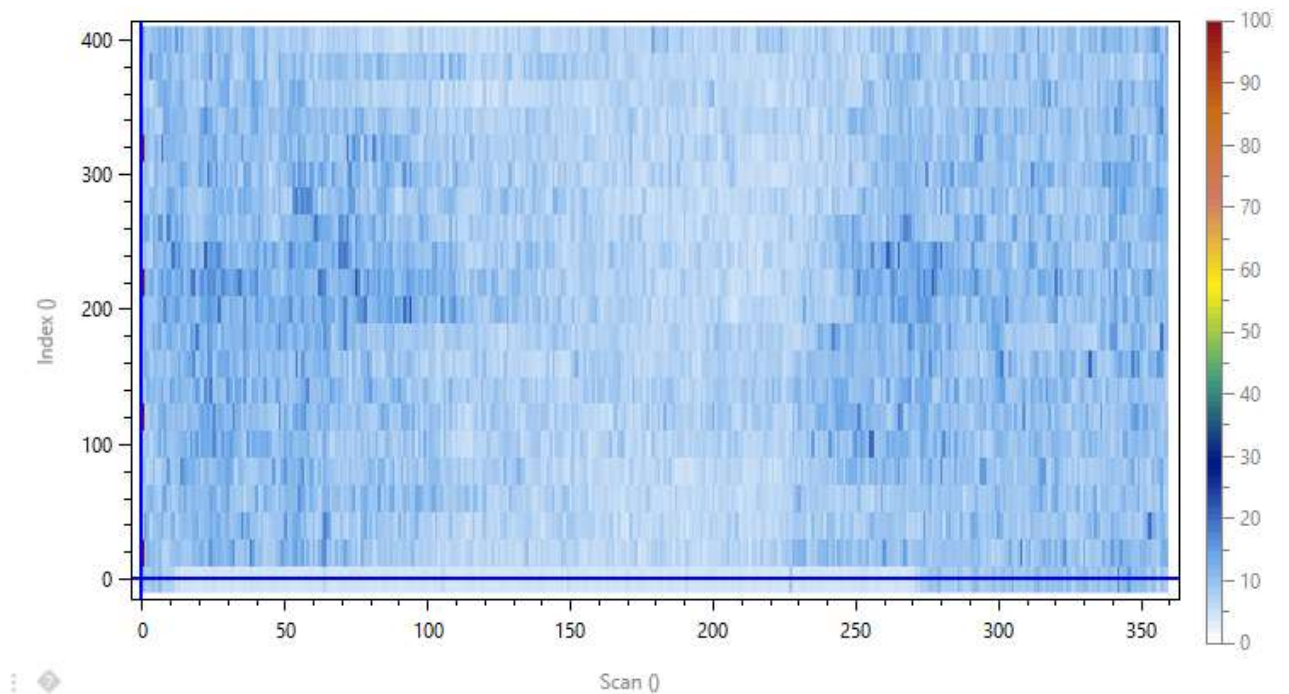
Scan 10

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



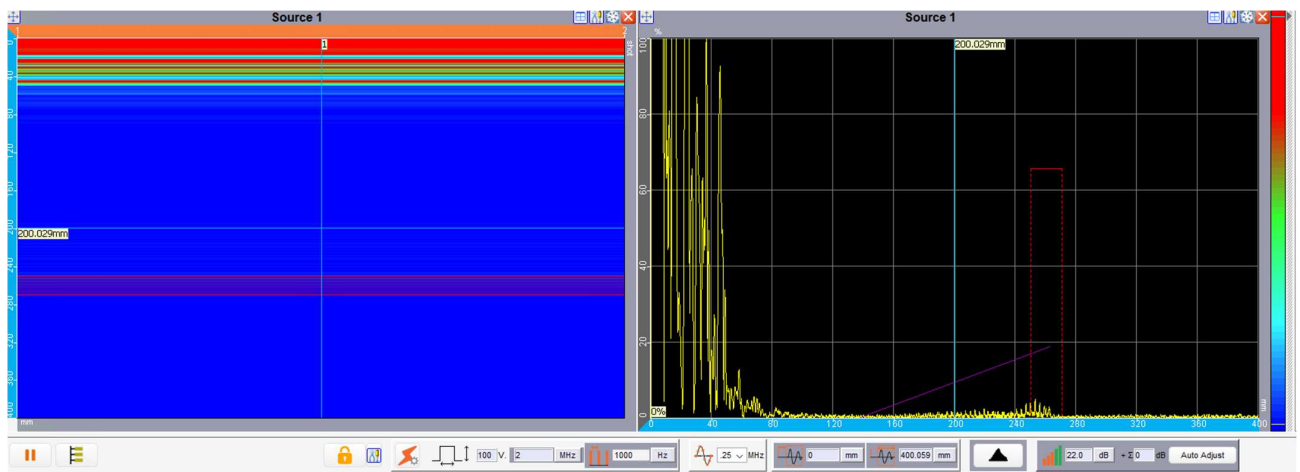
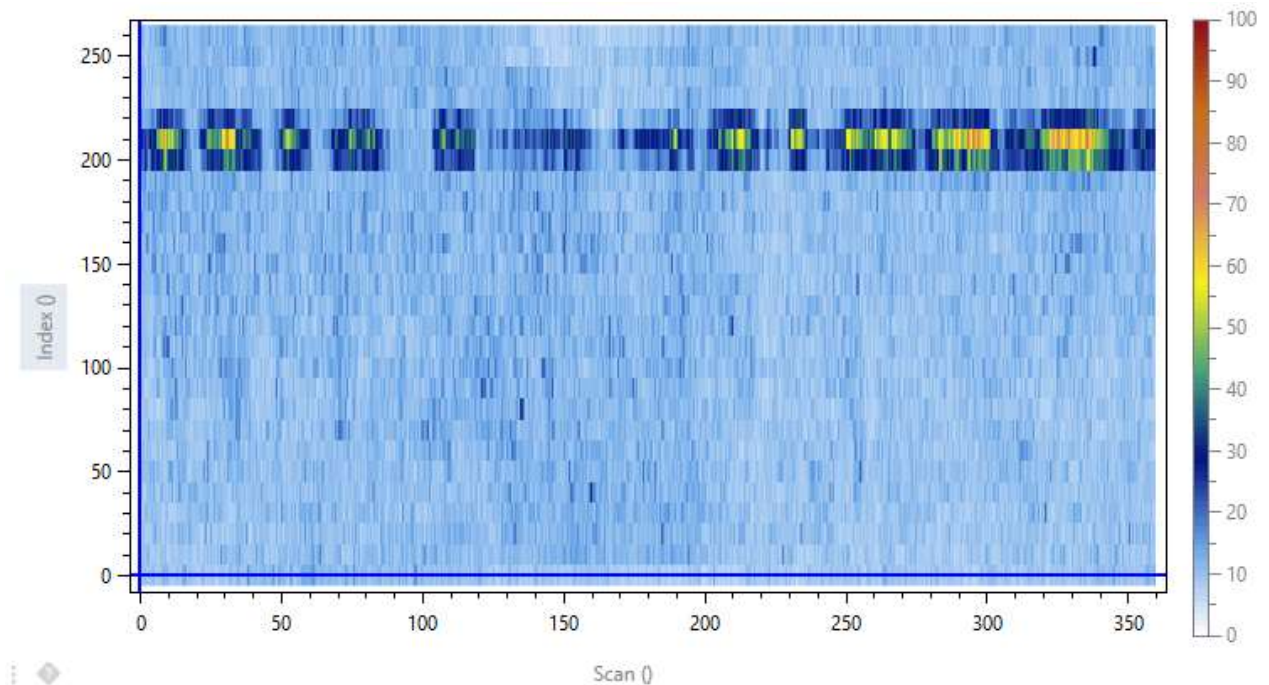
Scan 11

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



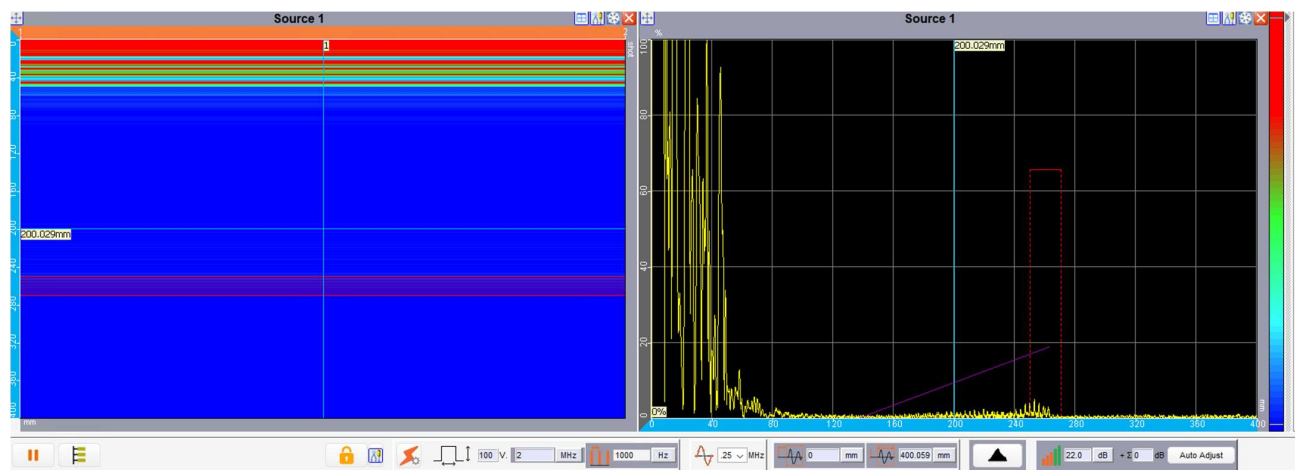
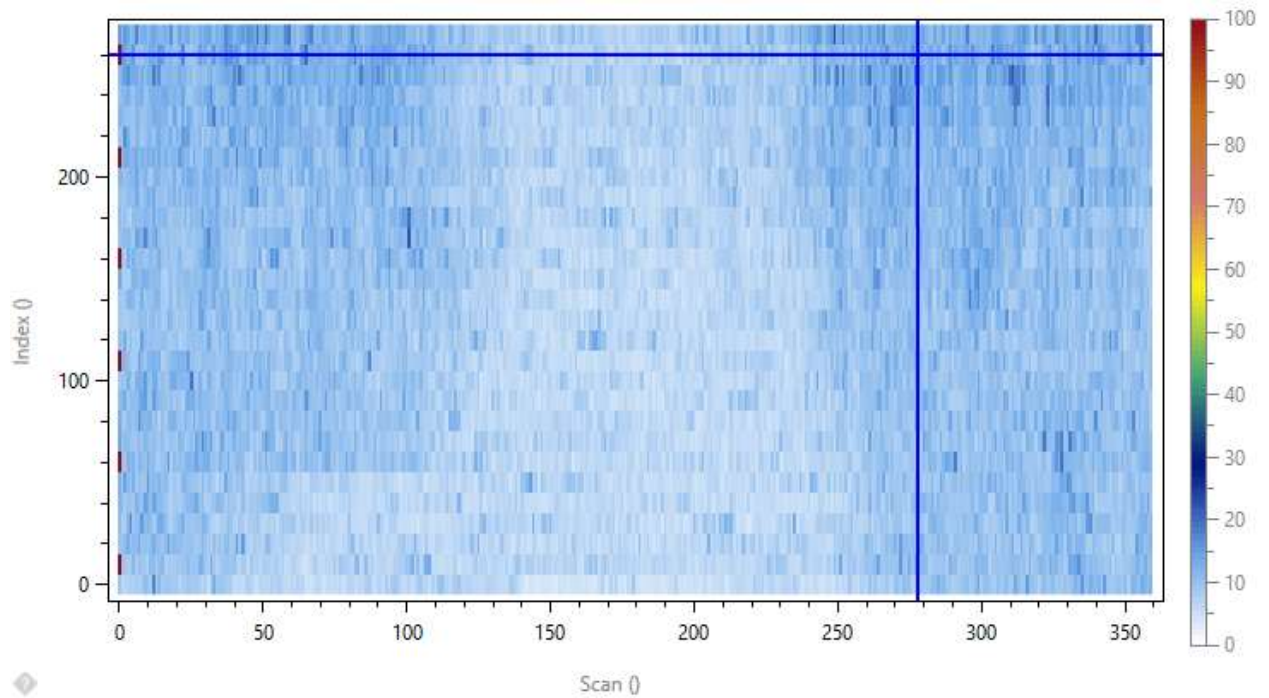
Scan 12

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



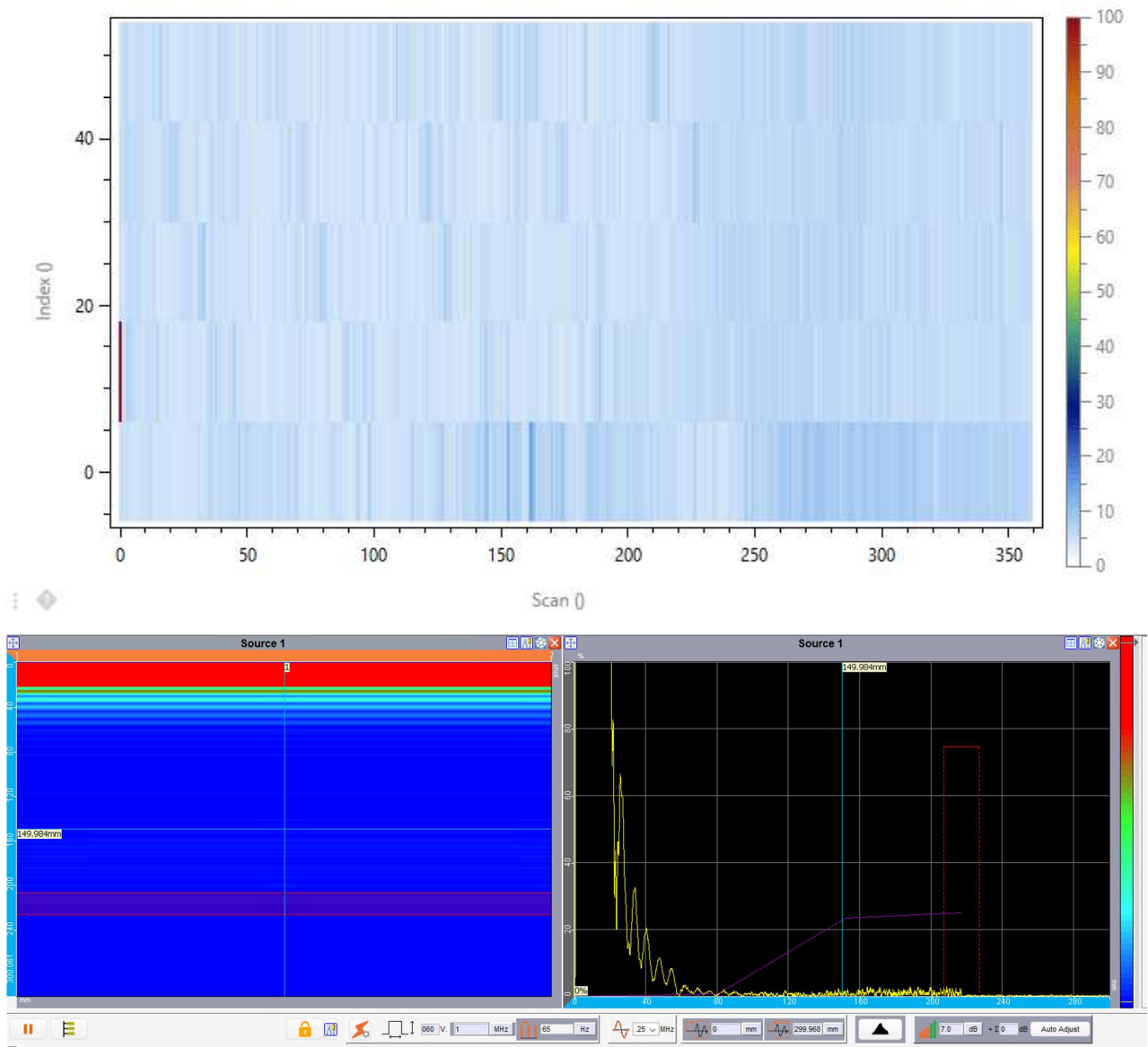
Scan 13


| | |
|---------------|----------------------------------|
| 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

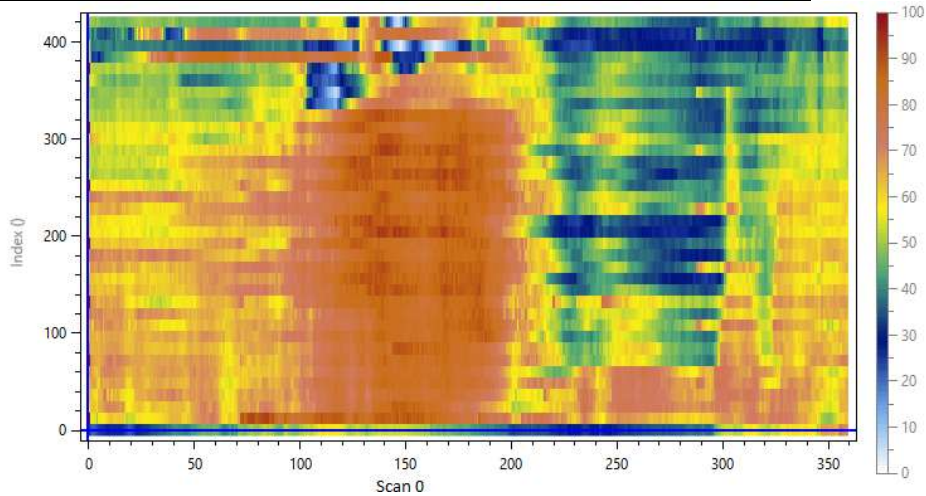
| | |
|---------------|-----------------------|
| Scan type | J Direction 0°, face1 |
| Scan length | 360 degree |
| Index length | 60 mm |
| Probe | Normal, 1 MHz |
| No of Element | 1 |



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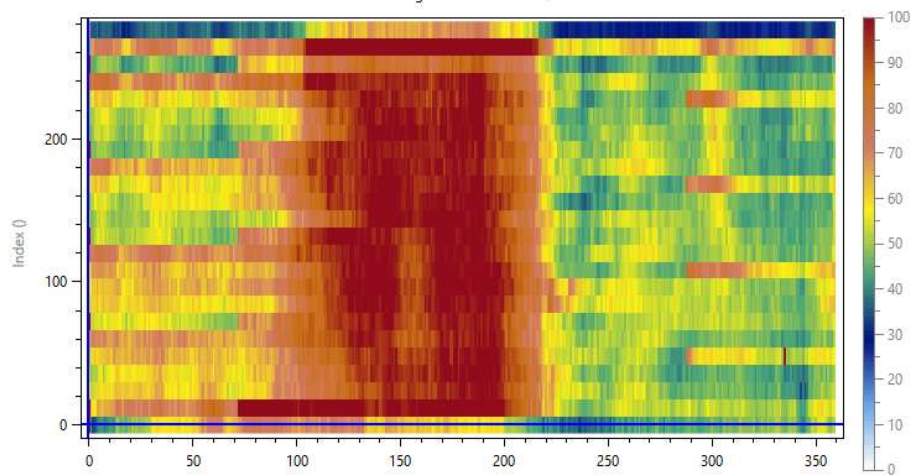
Scan 15


| | |
|---------------|-----------------|
| 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.