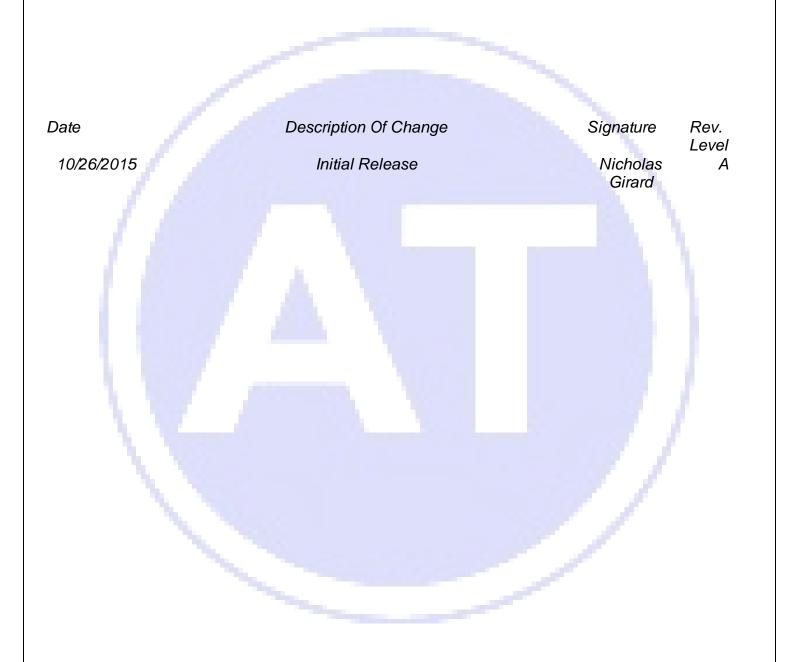
| Ameritube LLC | | | | | | | | | |
|------------------------------------|--|--|--|--|--|--|--|--|--|
| 1000 N. Hwy 77, Hillsboro TX 76645 | | | | | | | | | |

Revision Level: Procedure No.
A SOP 902
Revision Date: 10/26/15 Page No. 1 of 2

Air Underwater Testing

This Document expires one day after printing Last Printed: October 30, 2015



Company Title:

Quality Manager

Date:

10/27/2015

Procedure Approval:

Ameritube LLC 1000 N. Hwy 77, Hillsboro TX 76645

| Revision Level: | Procedure No. |
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| Α | SOP 902 |
| Revision Date: | |
| 10/26/15 | Page No. 2 of 2 |
| | |

Air Underwater Testing

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1.Scope

The scope of this procedure is to provide instructions, and to assign tasks for initiating, requesting, implementing, and checking the effectiveness of holding an internal air pressure with a tube. This procedure applies to the testing of materials for conformance to pneumatic testing stated in ASTM Standards for Metals Test Methods and Analytical Procedures SB-111.

1.1. These test methods cover the tubes capacity to with-stand, at the minimum, an internal air pressure of 60 psig (400 kPa) for 5 seconds.

2. Procedure

- 1. Inspect tube ends at both ends for any possible burrs and remove if necessary.
- 2. Insert the proper couplings for the tube size being tested on both ends of the tube.
- 3. Induce pressure to the specified requirements above.
- 4. Visualy inspect the entire length of the tubes for leaks.

HWO-9

5. If the couplings are leaking, remove coupling and deburr ends and repeat from step 2.

W.O. Date

10/30/2015

3. Work Order

| | | | | | | Customer I | Name | Holtec International | |
|---------------------------|----------------------|------------|-------------|--------------------|---------------|------------|------------|----------------------|-------|
| AIR UNDERWATER WORK ORDER | | | | | | PO# | | 2845-2222 | |
| | | | | | | Issued By: | | | |
| Metal Type | | | | | | Signed: | | | |
| Material | C70600 | | | | | Revision: | | | |
| Standard | SB-111 | | | | | | | | |
| | | | | | | | | | |
| ncoming | OD | Wall | Length | Pressure | Test Time | | | | |
| | 0.998 | 0.047 | 504 | 150 PSIG | 5 sec. | | | | |
| | | | | | | | | | |
| ւ. Inspect tub | e ends at bot | h ends fo | r any possi | ible burrs and rem | ove if necess | ary. | | | |
| 2. Insert the p | proper couplin | ngs for th | e tube size | being tested on l | oth ends of t | he tube. | | | |
| 3. Induce pres | ssure to the s | pecified | requireme | nts above. | | | | | |
| 1. Visualy ins | pect the entir | e length | of the tube | es for leaks. | | | | | |
| 5. If the coup | lings are leaki | ng, remo | ve couplin | g and deburr ends | and repeat fr | om step 2 | 2. | | |
| 6. Reject any | tubes that sho | ow leaks | and genera | ate a non-conform | ance in accor | dance wit | th QMS- | -005. | |
| | | | | | | | | | |
| Date | Operator ID Pressure | TAG# | Alloy | TIM | TIME | | Pcs Passed | Pcs | |
| | Operator 1D | Pressure | TAGE | Alloy | START | FINISH | Tube Size | rus Passeu | rejec |
| | | | | | | | | | |
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