

# Report on examination

Delivered to: University of Tokyo

Product: Xenon recovery tank (TX-2000)

Product ID: #0001, #0002

October 2000

Taiyo Material Inc.



1-18-15 Ohmori-nishi Ohta-ku Tokyo 143-0015 Japan

TEL +81-3-3764-0271/FAX +81-3766-6597

## Result of tightness leak test

No.	---	Product No	---				
Product Name	Xenon recovery tank	Dimension	ID520x1546				2 tanks
Design Pressure	8.0 Mpa	Manufacture No. #4058	Approved by	Mr. Otobe	Operated by	Mr. Kobayashi	

## Test

Product Name		Test Pressure (Mpa)	Duration Temp.	Date	Decision	Examining staff
1	Xenon recovery tank (1)	8.5	10min 22°C	3/Oct/2000	OK	Mr. Kobayashi
2	Xenon recovery tank(2)	8.3	10min 22°C	3/Oct/2000	OK	Mr. Kobayashi
3						
4						
5						
6						

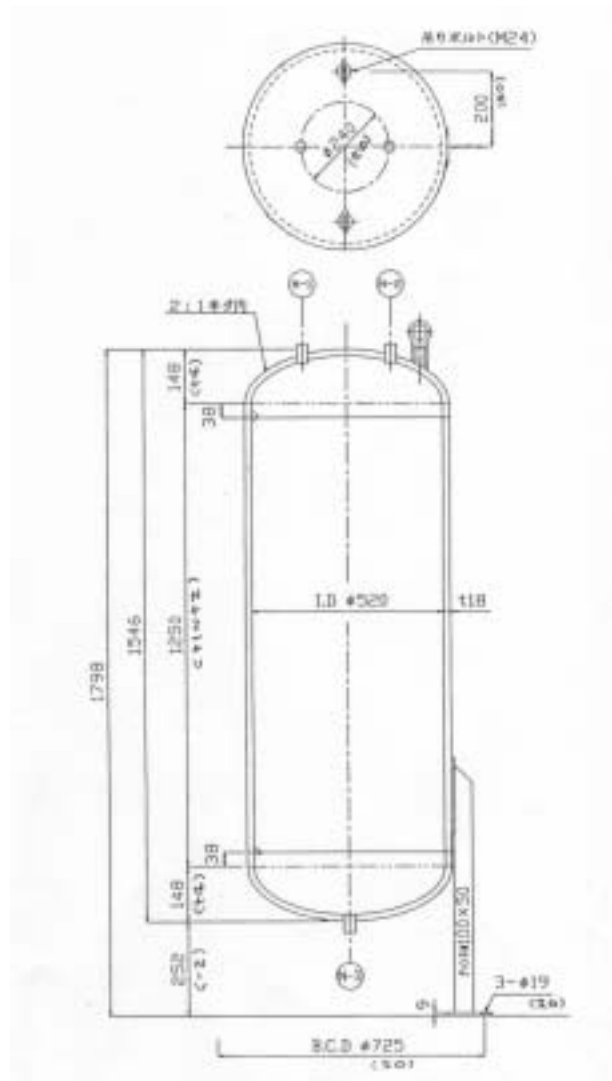
# Dimension

Otobe Tekkousyo Inc.

No.: \_\_\_\_\_

Product Name: xenon recovery tank

Product ID: #0001, #0002



Measured values are shown in ().

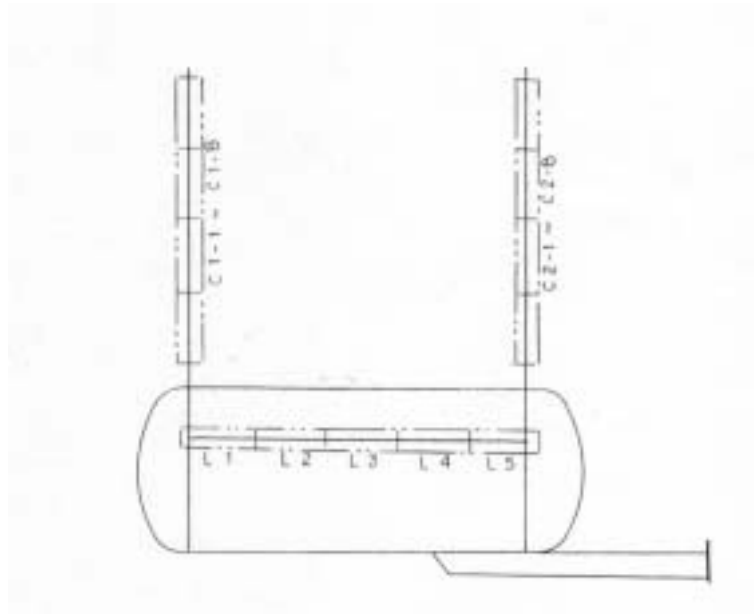
Visual examination OK

## X-ray Photography

Otobe Tekkousyo Inc.

No.: 4058-1,2

Product Name: xenon recovery tank



X-ray photography inspection: 100%

Applied law: Japanese regulation for special equipments 51, 52

Inspection method and approval condition: Follow methods described in JIS Z 3106 (regulation for the examination of X-ray photography for stainless welding, and its grade classification)

Approved when the photograph satisfies requirements for the grade 2 or higher in JIS Z 3106.

### Mark, Material, thickness and quantity

Mark	Material	Thickness	Quantity	Mark	Material	Thickness	Quantity
4058-L1~L5	SUS 304	18	5				
4058C1-1~C1-8	SUS 304	18	8				
4058C2-1~C2-8	SUS 304	18	8				

Total 21

Results of X-ray photography									
<div style="text-align: right;"> Unisec Inc.  4-14-9 chuo Tsurumi-ku Yokohama, 230-0051, Japan  +81-45-503-3511 </div>									
30/Sep/2000									
Orderer Otohe Tekkousyo Inc.				Date 22,29/Sep/2002		Inspector Mr. Eiji Yamamura			
Product Name Xenon recovery tank				Applied regulation		Japanese regulation for special equipments 51, 52			
				Decision Criteria		JIS Z3106 above 1-2 2-2			
Equipment for inspection	Producer		Rigaku Denki Inc.		Type		RF300EGS-2		
	Focusing point		2.5x2.5mm	Rated voltage		300kVp	Rated current		5mA
Film	Name and dimension		Fuji 1x100 85x305mm		Metallic foil screen		Silver foil 0.03mm		
Development condition	Developer		Fujifilm Highrendor	Development temperature		23°C	Development duration		5min
Outer dimension (mm)	Plate thickness (mm)		Filming Condition						
			Voltage (KVp)	Current(mA)	Distance (mm)	Duration (min.)	Transmission meter		
520.0	18.0		205	5	600	1.0	S02		
			300	5	700	2.6	S04		
Film mark	Grade	Defection	Film mark	Grade	Defection	Film mark	Grade	Defection	
4058 L-1	1	ND	C2-3	1	BH	C1-5	1	ND	
-2	1	BH	-4	1	BH	-6	1	ND	
-3	1	BH	-5	1	BH	-7	1	ND	
-4	1	BH	-6	1	BH	-8	1	ND	
-5	1	ND	-7	1	ND	C2-1	1	ND	
C1-1	1	ND	-8	1	ND	-2	1	ND	
-2	1	ND	4058-2 L-1	1	BH	-3	1	ND	
-3	1	ND	-2	1	ND	-4	1	ND	
-4	1	ND	-3	1	BH	-5	1	ND	
-5	1	ND	-4	1	ND	-6	1	ND	
-6	1	ND	-5	1	BH	-7	1	ND	
-7	1	ND	C1-1	1	ND	-8	1	ND	
-8	1	ND	-2	1	ND				
C2-1	1	ND	-3	1	ND				
-2	1	ND	-4	1	ND				
Defection category	1	2					3	4	
Defection mark	BH	SI	P	LF	IP	W	ND		
Defection description	Blow hole	Slag entrained	Pipe	Imperfect fusion	In sufficient merge	Tungsten entrained	.....		

鏡板検査成績書  
HEAD PLATE INSPECTION RESULTS

日期: 2000/09/13

注文主: 株式会社 乙部鉄工所 殿  
注文番号: 4058  
Order No.

型	式 :	ED	n =	38.0
	Time		n =	168.0

第12章 函数与方程	520.0
内 容	520.0

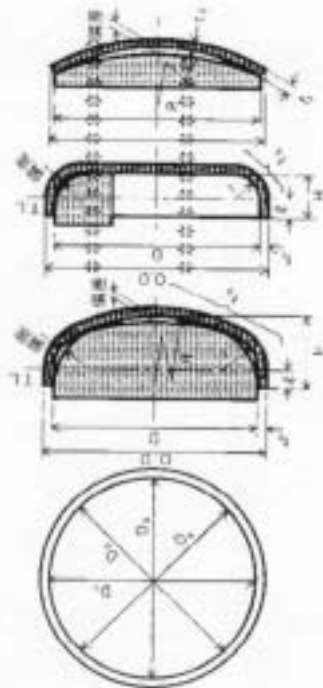
材 質 :	SUS304
板 厚 :	18.0
	Thickness

材料メーカー ; 新日本製鉄株式会社  
Steel Maker

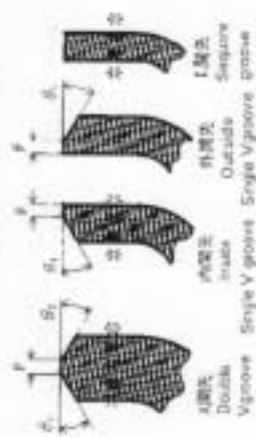
越工方法：  
Farming Method

製造番号 : Product No	000829-004-0	数量 : Quantity	1
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鏡板略図  
Sketch of head plate



開先詳細図  
Detail of tower



Unit : mm

[illegible]

材料免注册号  
Material Order No.

御 題

開先及び、外觀検査合格

上に読版は規定の検査を行ない、これに合格したことを証明する。  
We hereby certify that this head plate is satisfied with

J I S B 8 2 4 7

Authorised Instructor



新日本製鐵株式會社

NIPPON STEEL CORPORATION  
鋼材検査証明書  
INSPECTION CERTIFICATE

社：〒100-8071 東京都千代田区大手町二丁目6番3号  
HEAD OFFICE 2-6-3 OTEMACHI, CHYODOKU, 100-8071 JAPAN  
八幡製鐵所：〒804-0001 北九州市戸畑区飛崎町1番1号  
YAWATA WORKS 1-1, TOBEHATCHO, TOBATA-KU, KITAYUKU, 804-0001 JAPAN

注文書  
SHIPPER : NITTETSU SHOJI  
注文書照合番号  
REFERENCE No. : 153 10F34015  
契約番号  
CONTRACT No. : 0-123-YH-1-4-R950  
品名  
COMMODITY : STAINLESS STEEL PLATE  
規格  
SPECIFICATION : JIS G4304-1999 SUS304  
文書番号  
DOCUMENT No. :  
需要家  
CUSTOMER : OOTANI KAKO

証明書番号 : 8374  
CERTIFICATE No.  
発行年月日 : 2000-05-06  
DATE OF ISSUE  
頁 : 1  
PAGE

需要家管理番号 : E05 2  
CUSTOMER'S CONTROL No.  
111 # 00

寸法 DIMENSION MM	数量 QUANTITY	質量 MASS KG	製鋼番号 CAST No. 試験番号 TEST No.	製品番号 PLATE No.	引張試験 TENSILE TEST			衝撃試験 IMPACT TEST			化学成分 CHEMICAL COMPOSITION %										
					引張 T.S.	引張 Y.S.	伸長 E.L.	断面収縮 R.	平均 AVG	個々 EACH	C	Si	Mn	P	S	CU	Ni	Cr	Mo	Nb	V
18X2500X6100	02	2176	E81703 43577	227409-01TCA	253	614	69		187		8100	200	45	30			800	1800			
(3585050130)	SUB TOTAL	2176							146		6	41	88	27	1		829	1828			
TOTAL	1	2176																			

注釈 NOTES ①位置・方向 T: 頭部 Top, B: 底部 Bottom, L: 任意方向 Longitudinal, C: 垂直方向 Transverse, Z: 軸方向 Through Thickness, R: 45° 方向 45Deg. to the Longitudinal Axis  
②寸法公差 ③試験片形状 A: 50mm 矩形試験片 Rectangular, B: 50mm 矩形試験片 Rectangular, C: 70mm 矩形試験片 Rectangular, D: 70mm 矩形試験片 Rectangular, E: 80mm 矩形試験片 Rectangular, F: 80mm 矩形試験片 Rectangular, G: 200mm 矩形試験片 Rectangular, H: 200mm 矩形試験片 Rectangular, I: 200mm 矩形試験片 Rectangular, J: 200mm 矩形試験片 Rectangular, K: 200mm 矩形試験片 Rectangular, L: 200mm 矩形試験片 Rectangular, M: 200mm 矩形試験片 Rectangular, N: 200mm 矩形試験片 Rectangular, O: 200mm 矩形試験片 Rectangular, P: 200mm 矩形試験片 Rectangular, Q: 200mm 矩形試験片 Rectangular, R: 200mm 矩形試験片 Rectangular, S: 200mm 矩形試験片 Rectangular, T: 200mm 矩形試験片 Rectangular, U: 200mm 矩形試験片 Rectangular, V: 200mm 矩形試験片 Rectangular, W: 200mm 矩形試験片 Rectangular, X: 200mm 矩形試験片 Rectangular, Y: 200mm 矩形試験片 Rectangular, Z: 200mm 矩形試験片 Rectangular  
④A: 鍛り Reduction of Area, Y.R: 降伏比 Yield Ratio ⑤A: 合格 Acceptable ⑥2: 2.5mm, 3: 3.3mm, 4: 3.3mm, 5: 3.3mm, 6: 3.3mm, 7: 3.3mm, 8: 3.3mm, 9: 3.3mm, 10: 3.3mm, 11: 3.3mm, 12: 3.3mm, 13: 3.3mm, 14: 3.3mm, 15: 3.3mm, 16: 3.3mm, 17: 3.3mm, 18: 3.3mm, 19: 3.3mm, 20: 3.3mm, 21: 3.3mm, 22: 3.3mm, 23: 3.3mm, 24: 3.3mm, 25: 3.3mm, 26: 3.3mm, 27: 3.3mm, 28: 3.3mm, 29: 3.3mm, 30: 3.3mm, 31: 3.3mm, 32: 3.3mm, 33: 3.3mm, 34: 3.3mm, 35: 3.3mm, 36: 3.3mm, 37: 3.3mm, 38: 3.3mm, 39: 3.3mm, 40: 3.3mm, 41: 3.3mm, 42: 3.3mm, 43: 3.3mm, 44: 3.3mm, 45: 3.3mm, 46: 3.3mm, 47: 3.3mm, 48: 3.3mm, 49: 3.3mm, 50: 3.3mm, 51: 3.3mm, 52: 3.3mm, 53: 3.3mm, 54: 3.3mm, 55: 3.3mm, 56: 3.3mm, 57: 3.3mm, 58: 3.3mm, 59: 3.3mm, 60: 3.3mm, 61: 3.3mm, 62: 3.3mm, 63: 3.3mm, 64: 3.3mm, 65: 3.3mm, 66: 3.3mm, 67: 3.3mm, 68: 3.3mm, 69: 3.3mm, 70: 3.3mm, 71: 3.3mm, 72: 3.3mm, 73: 3.3mm, 74: 3.3mm, 75: 3.3mm, 76: 3.3mm, 77: 3.3mm, 78: 3.3mm, 79: 3.3mm, 80: 3.3mm, 81: 3.3mm, 82: 3.3mm, 83: 3.3mm, 84: 3.3mm, 85: 3.3mm, 86: 3.3mm, 87: 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ク NO 50034 10 INSPECTION CERTIFICATE 検査証明書

KK ウェルクス チョウタツ		Purchaser KK ウェルクス		備考							
Chemical Composition 化学成分											
Elements	C	Si	Mn	P	S	Cu	Ni	Cr	Mo		
%	MAX 100	MAX 100	MAX 100	MAX 1000	MAX 1000	N	MAX 100	MAX 100			
Specification	MAX 8	MAX 100	MAX 200	MAX 45	MAX 30		800	1800			
Results	6	29	171	35	28		816	1859			
Mechanical properties 機械的性質											
Items	Tension Test 引張試験				Impact Test 衝撃試験		Bending Test 曲げ試験		Heat Treatment 熱処理		
	Type of Specimen 試験片	Yield Strength 降伏点	Tensile Strength 引張強さ	Elongation 伸び	Reduction of Area 断面収縮率	Hardness 硬度	Type of Specimen 試験片				
Specification	N/MM	N/MM	N/MM	%	%	HB					
	MIN 205	MIN 520	MIN 674	MIN 40	MIN 60	MAX 187					
Results	JIS10	291	674	60	72	167					
Items	Grain Size 結晶粒径	Decarburization 脱炭素化	Streak Flow 線状流動	Body Hardness 製品硬度		Non Metallic Inclusion 非金属夹杂物					
Results											
Items	Hardenability 硬化性										
Results											
Hardenability (End Quenching Method) 硬化性 (一頭入法)											
Results											

Date 1-05-24 Certificate No. 4J4997 (5BK052) JISG4303-98-SUS304 50 D ST, PM Heat No. 3393D

「ココウカシヨリ, PM:ハ-ター-カコウ(スム-スハク)」 is hereby certified that the above results are true and correct in every details. 上記の成績は要求事項を満足していることを証明します。

Chief of Quality Assurance Section J. H. Hino

Quality Assurance Section, Kawasaki Plant

★ Daido Steel Co. Ltd. 大同特殊鋼株式会社 川崎工場 品質保証室 〒210 0863 神奈川県川崎市幸区日通1-1 TEL 044-256-1163 (大代表)

