

SIEMENS

June 14, 1994

U.S. Nuclear Regulatory Commission
Attn: Document Control Desk
Washington, DC 20555

Subject: Additional information to support the NRC Document No. 99901277

Reference: Document No. 99901277 (NRC inspection conducted May 23 - 27, 1994)

Based upon a recent inspection conducted at Siemens Power Corporation's (SPC), Chattanooga facility, the Vendor Inspection Branch raised several concerns regarding steam generator repair activities performed by Universal Testing Laboratories, Inc. (UTL), a former subsidiary of SPC. One concern related to the disposition of a Non-conformance Report (NCR) in which ASME material was accepted on the basis of Liquid Penetrant (PT) examination only rather than a combination of Ultrasonic (UT) and PT examination as is required by ASME code. The initial information supplied to the inspection team in support of the NCR was incomplete. A Radiographic (RT) examination was performed on the material to supplement the PT examination in order to satisfy the volumetric requirement of ASME, Section III, Division 1, NB-2541(a). This section states in part, "...configurations which do not yield meaningful examination results by ultrasonic methods, shall be examined by radiographic methods..." The other concern related to the potential that S/G plugs from the inadequately tested ASME material were also supplied to the Trojan Nuclear Power Plant. Additional information is provided to confirm that plugs supplied to Trojan were from another material lot (different heat number).

The plugs in question (heat number NX 6441 HK - transfer number 51) were shipped to Florida Power & Light Co. - Turkey Point Nuclear Station, to be used in the repair and replacement of failed Westinghouse steam generator plugs. Prior to installation the plugs were examined by the radiographic method as mentioned above. This RT was performed at the Turkey Point site by another FPL contractor and resulted in "no indications revealed" as indicated on the RT Inspection Reports (Attachment 1 of this letter).

An understanding of SPC's plug serialized numbering system is necessary in order to verify traceability to the required material specification documents. The following brief explanation should provide sufficient information for the purpose of this inspection:

- (a) The first two numbers of the plug serial number are the last two numbers of the drawing - example: drawing 85826 Plug number 26.4.10
- (b) The second number identifies the type of plug from the specified drawing - example: Plug number 26.4.10

Per the drawing is designated a Westinghouse mechanical plug repair type

210065

Siemens Power Corporation

Nuclear Division
Reactor Services & Systems

5959 Shallowford Road, Suite 531
Chattanooga, TN 37421

9406220289 940614
PDR QA799 EMVEXN
99901277 PDR

Tel: (615) 499-0961
Fax: (615) 894-2456

JE09

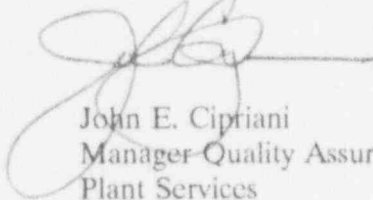
- (c) The last number is the unique identifier for that particular plug -
example: Plug number 26.4.10
- (d) Identified on the plug but not part of the serial number is the heat transfer number.

The seven (7) welded plugs which were installed at Turkey Point Unit 3 were per Siemens AG - KWU Group Drawing U4 441E-33-85826, Revision 0, "7/8 inch Welding Plug", type 4. The plug serial numbers installed were: 26.4.8, 26.4.10, 26.4.17, 26.4.18, 26.4.21, 26.4.27 and 26.4.38.

The question raised concerning the plugs installed at Trojan Nuclear Station can be addressed simply by confirming that the plugs did not come from the heat number NX 6441 HK as is annotated on attachment 2 of this letter. Provided as attachment 2 is a copy of the original shipping notice with the serial numbers, drawing numbers, heat numbers and transfer numbers for the plugs sold to Babcock & Wilcox Nuclear Services (BWNS) for installation at Trojan.

Should there be any further questions regarding this subject matter please contact me at (615) 499-1717.

Best Regards,



John E. Ciptiani
Manager Quality Assurance
Plant Services

JEC:RLS

Attachments

cc: D. Perry - SPC
C. Powers - SPC
M. Tagliamonte - SPC

Chief Vendor Inspection Branch
Division of Reactor Inspection & Licensee Performance
Office of Nuclear Reactor Regulation
U.S. Nuclear Regulatory Commission
Washington, DC 20555



RADIOGRAPHIC INSPECTION REPORT
 (AS 9.3)

IR NUMBER: 11-70-0552
 SHEET: 2 OF 3
 PROJ: 87-580
 PS: N/A
 EXPOSURE SHEET NUMBER: 7

UNIT: Project Turkey Point # 3 DRAWING NO.: 85826
 SYSTEM: S/G tube plugs WELD NO.: SEE STATIONS
 SI: 1 KEY TECH. CAT. ASME III
 JOINT: OPEN ROOT INSEAT BACKING N/A
 MFG. STD: PARTIAL FINAL BEFORE AFTER
 EXCAVATED AREA OTHER
 PENETRANT: TY SE-42 N/A OTHER
 PEN. SIZE: 10 MATERIAL: _____
 PEN. PLACING: SOURCE SIDE FILM SIDE
 SOURCE: 18 KV X-RAY CO-60
 SR. NO.: 8951 SOURCE SHOT SIZE: .59
 CUSEC. VALVIN: SPD 20"
 ADMIN. # 660
 FILM TYPE: 203ART SPEED: D-2 LOAD: 2-100
 SHIMI MATERIAL: S/S THICKNESS: .03/.25 in
 SCREENS: PB OTHER
 SCREEN THICKNESS: FRONT .010 BACK .010
 SURFACE CONDITION: AS WELDED FLAT TOPPED N/A GROUND SMOOTH
 LOCATION MARKER: SOURCE SIDE FILM SIDE
 AT 7/16" SPACING & NO. AT 7/16" INCHES INTERVALS
 RADIOGRAPHER: Don Hottel II 3/13/90 DWH
 REQUIRED SENSITIVITY: 2T 4T
 VIEWING TECHNIQUE: SINGLE FILM COMPOSITE FILM
 EXAMINATION: SINGLE WALL DOUBLE WALL

STATIONS	PROBES	SLIP	CRACK	LACK OF FUSION	INDIGIBLE OR REGENERATION	CRATER	ARTIFACT	UNDERCUT	WORN THRU	UNFUSED INSERT	TURBULENCE	SURFACE INDICATION	MISC.	FILM ARTIFACT	FILM DENSITY	FILM DENSITY	SENSITIVITY	ACCEPT	REJECT	REMARKS
8/4																				
9																				
9																				
10																				
11																				
12																				
17																				

NOTE: Additional 10 INDICATIONS were detected

ASTE NO.: 101-PTP-4302 D-4 7340
 101-PIP-8227 D-4 4830
 EVALUATED BY: J. J. ... LEVEL: ... DATE: ... INITIAL: ...
 THIS REPORT IS FOR: TRAVELER C
 NO. 90 4054
 DISCREPANCIES: 0/1
 APPROVED BY: Don Hottel II 3/13/90 DWH
 TITLE: RDCS SIGNATURE: [Signature] DATE: 3/13/90



RADIOGRAPHIC INSPECTION REPORT
(TS 9.3)

NCR 80-NG054
Page 25 of 224

IR NUMBER
19-70-0552

PROJECT
774 #3 R-2 93

97-200 100-200

PROJECT Project Turkey Point #3	DRAWING NO. 8584	PS	REV.	ITEM #
SYSTEM 5/8 Tube Plus	WELD NO. 250 Station	N/A	N/A	N/A

Q1 TECH. CAT.	APPENDIX/ACCEPT. STD.	JOINT: OPEN ROOT <input type="checkbox"/> INSERT <input type="checkbox"/> SACKING <input type="checkbox"/> N/A
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Q2 MATERIAL TYPE INCON 690	THICKNESS RANGE OR NOM. LENGTH 1/2" - 1 1/2"	WFG STD. PARTIAL <input type="checkbox"/> FINAL <input type="checkbox"/> SECTION <input type="checkbox"/> AFTER <input type="checkbox"/>
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NO. OF EXPOSURES 1	NO. FILM/IMG. 4	NO. NCL 90-NG054	EXCAVATED AREA <input type="checkbox"/> OTHER <input type="checkbox"/>
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SOURCE: IS <input checked="" type="checkbox"/> CO-60 <input type="checkbox"/> X-RAY <input type="checkbox"/> K	SOURCE SPOT SIZE 159	PEN. PLACING: SOURCE SIDE <input checked="" type="checkbox"/> FILM SIDE <input type="checkbox"/>
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SR. NO. 951	WAVEL. N/A	SPD. 20'	SWIM. MATERIAL 5/8 TUBES 100% 93M
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CLOSED <input type="checkbox"/> OPEN <input checked="" type="checkbox"/>	SURFACE CONDITION AS WELDED <input type="checkbox"/> FLAT TOPPED <input type="checkbox"/> GROUND SMOOTH <input type="checkbox"/>	SCREENS: P2 <input checked="" type="checkbox"/> OTHER <input type="checkbox"/>	SCREEN THICKNESS: FRONT 0.015 BACK 0.010
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FILM TYPE KODAK	SPEED 16	LOAD Quad	LOCATION MARKER: SOURCE SIDE <input type="checkbox"/> FILM SIDE <input type="checkbox"/>
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RADIOGRAPHER J.R. Lambson II	CERT LEVEL II	DATE 3-4-91	INITIAL JRL
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REQUIRED SENSITIVITY RT <input type="checkbox"/> AT <input checked="" type="checkbox"/>	VIEWING TECHNIQUE: SINGLE FILM <input checked="" type="checkbox"/> COMPOSITE FILM <input type="checkbox"/>	EXAMINATION: SINGLE WALL <input type="checkbox"/> DOUBLE WALL <input type="checkbox"/>
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AT 7/16" SPACING & NO. AT 7/16" INCHES INTERVALS
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STATIONS	IRREGULARITY	SLAG	CRACK	LACK OF FUSION	UNDERFILL	SPATTER	ROOT BEAD	BURN THROUGH	UNFUSED INSERT	TURBULENCE	AIR TRAP	INDICATION	ARTIFACT	FILM ARTIFACT	FILM DENSITY	FILM DENSITY	IRREGULARITY	RECORD	REWORK	REMARKS
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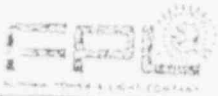
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NCR 90-N6054

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RADIOGRAPHIC INSPECTION REPORT (TS 9.3)

IR NUMBER
17-90-0553

PROJECT
PTN - 3

POK
89-580

PS
PIV.

EXPOSURE SETUP NUMBER
7

DRAWING NO.
85826

ITEM
PTN-3

WELD NO.
SEE STATIONS

REV. TECH. CAT. APPENDIX/ACCEPT. STD.

1 T.S.-9.3 I ASME III

MATERIAL TYPE
WCCMR 690

THICKNESS RANGE
.125

DIA OR LENGTH
1 1/2"

NO. OF EXPOSURES
1

NO. FILM/JOINTS
4

REMARKS

JOINT: OPEN ROOT INSERT BACKING W/P

MFG. STG: PARTIAL FINAL BEFORE AFTER

EXCAVATED AREA OTHER

PENETRATOR: TY SE 142 N/A OTHER

PEN SIZE: 10

PEN. PLACING: SOURCE SIDE FILM SIDE

SOURCE: 18192 CO-60 X-RAY

SR NO: 8951

SOURCE SPOT SIZE: .159

MIN. 880

MAXIM. N/A

SFO: 20"

SHIML MATERIAL: S/S THICKNESS: .0325"

SCREENS: PD OTHER

SCREEN THICKNESS: FRONT .010 BACK .010

ALPHA BEAM TYPE DEVIANT SPEED D-7 LOAD QUAD

SURFACE CONDITION

AS WELDED FLAT TOPPED N/A

GROUND SMOOTH

LOCATION MARKER: SOURCE SIDE FILM SIDE

AT 3/16" SPACING & NO. AT 3/16" INCHES INTERVALS

REQUIRED SENSITIVITY: 2T 4T

RADIOGRAPHER: 4 total II 3/13/90 DTH

VISUING TECHNIQUE: SINGLE FILM COMPOSITE FILM

EXAMINATION: SINGLE WALL DOUBLE WALL

STATIONS	POSSIBLY	SLAG	CRACK	LACK OF FUSION	INCOMPLETE PENETRATION	CRATER	PIT/CRACK	UNDERCUT	BURN THRU	UNPUSHED INSERT	TURBIDITY	SURFACE INDICATION	ANISC.	FILM ARTIFACT	FILM DENSITY	FILM DENSITY	SENSITIVITY	ACCEPT	REJECT	REMARKS
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PTP-4302 DATE 7-31-90

PTP-5229 DATE 4-12-90

TRAVELER

90-N6054

ACC

3/13/90

EVALUATED BY: LEVEL: DATE: INITIAL:

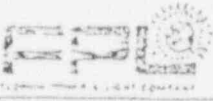
3/13/90

RADIOGRAPHER(S) LEVEL DATE

3/13/90

3/13/90

NCR 90 N0054
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RADIOGRAPHIC INSPECTION REPORT
(IS 9.3)

IR NUMBER
17-70-0553

PROJECT
PTN 3

PCN
87-580

PS REV.
N/A

EXPOSURE SHEET NUMBER
7

DRAWING NO.
85826

WELD NO.
SIZ STATIONS

PTN-3

SIG TUBE PLUGS

TECH. CAT. APPENDIX/ACCP. STD.
T.S.-9.3 I ASME III

MATERIAL TYPE THICKNESS RANGE DIA OR LENGTH
1/2" - 2 1/2" .125 12"

NO. OF EXPOSURES. NO. FILM JOINTS. REF AIR #
1 4 90-00054

SOURCE: CO-60 X-RAY OR Y
SOURCE SPOT SIZE: .159

CLUST. DMT. 160 MAIN: SPD: 20"

JOINT: OPEN ROOT INSERT SACKING N/A

WFO. STD. PARTIAL FINAL BEFORE AFTER

EXCAVATED AREA OTHER

PENETRANT: TV SE-1425 N/A INK OTHER

PEN. SIZE: 10 MATERIAL:

PEN. PLACING: SOURCE SIDE FILM SIDE

SHIM: MATERIAL S/S THICKNESS .0325 IN.

SCREENS: #8 OTHER FRONT .010 ACR .010

SCREEN THICKNESS: FRONT .010 ACR .010

FILM SPEED: 02 LOAD: QUAD

SURFACE CONDITION: N/A

AS FLAT TOPPED GROUND SMOOTH

LOCATION MARKER: SOURCE SIDE FILM SIDE

AT 7/16" SPACING & MO. AT 7/16" INCHES INTERVALS

RADIOGRAPHER: CERT. LEVEL DATE INITIAL
D. J. H. II 3/13/90 DJH

REQUIRED SENSITIVITY: 2T 4T

VIEWING TECHNIQUE: SINGLE FILM COMPOSITE FILM

EXAMINATION: SINGLE WALL DOUBLE WALL

STATION	PROPERTY	SLAG	CRACK	LACK OF FUSION	INCOMPLETE PENETRATION	CRATER	PIPE CRACK	UNDER CUT	BURR	THRU	UNWELDED	INHERENT	POOR JOINT	SLIP	MISC.	FILM ARTIFACT	PENE DENSITY	FILM DENSITY	SENSITIVITY	ACCEPT	REJECT	REMARKS
18																						
21																						
27																						
36																						
37																						
38																						
NOTE: Radiographically no indications were detected																						

DATE: 17-4302 DUE 7/23/90
17-5228 DUE 4/12/90

EVALUATED BY: LEVEL: DATE: INITIAL:
D. J. H. II 3/13/90 DJH

TRAVELER

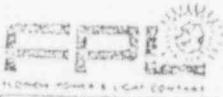
REMARKS APPROVED BY: H. O. C.

TITLE: SIGNATURE: DATE: 3/13/90

REMARKS APPROVED BY: H. O. C.

TITLE: SIGNATURE: DATE: 3/13/90

NCR 90-ND454
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RADIOGRAPHIC INSPECTION REPORT
(IS 9.3)

IR NUMBER: 17-90-0553
 PROJECT: 3 202 003
 PCN: 89-580
 PS: N/A
 EXPOSURE SET # NUMBER: 7

UNIT: Project Turkey Point # 3
 DRAWING NO.: 85826
 SYSTEM: 5/16 TUBE PLUGS
 WELD NO.: SEE STATIONS

DI: 1 T.S.-9.3 I ASME
 MATERIAL TYPE: INCONEL
 THICKNESS RANGE: .125
 DIA OR LENGTH: 1 1/2"
 NO. OF EXPOSURES: 1
 NO. FILM/JOINT: 4
 REF MKR #: 90ND054

SOURCE: 12192
 SR. NO.: 8951
 CO. 80 X-RAY
 SOURCE SPOT SIZE: 154
 CUMIN: 880
 WAXIN: SFO 20"

FILM TYPE: KODAK
 SPEED: D-2
 LOAD: QAD
 SURFACE CONDITION: AS WELDED
 FLAT TOPPED: N/A
 GROUND SMOOTH:

RADIOGRAPHER: CERT LEVEL: DATE: 3/10/90 INITIAL: DKL

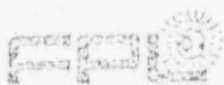
JOINT: OPEN ROOT INSERT BACKING N/A
 MFG. STD: PARTIAL FINAL BEFORE AFTER
 EXCAVATED AREA OTHER
 PENETRATOR: TY SE 142 N/A DATE:
 PEN. PLACING: SOURCE SIDE FILM SIDE
 SHIM: MATERIAL: S/S THICKNESS: .0325/50 in
 SCREENS: PD OTHER
 SCREEN THICKNESS: FRONT: 20 BACK: 010
 LOCATION MARKER: SOURCE SIDE FILM SIDE
 AT 3/16" SPACING & NO. AT 3/16" INCHES INTERVALS
 REQUIRED SENSITIVITY: 2T 4T
 VIEWING TECHNIQUE: SINGLE FILM COMPOSITE FILM
 EXAMINATION: SINGLE WALL DOUBLE WALL

STATIONS	POROSITY	SLAG	CRACK	LACK OF FUSION	INCOMPLETE PENETRATION	CRATER	PIT/CRACK	UNDER ROOT	BURN THRU	UNFUSED INSERT	TUFTS/TEN	SURFACE IRREGULARITY	DISC.	FILM ARTIFACT	PIPE DENSITY	FILM DENSITY	SENSITIVITY	ACCEPT	REJECT	REMARKS
5/1																				
0°																				
18																				
21																				
27																				
36																				
37																				
38																				

NOTE: Additional work no indications were revealed

MTE NO. FR-P+P-4302 DMC 7-31-90
 FOL-PTP-8228 DMC 4-11-90
 THIS REPORT IS FOR: TRAVELER
 WER NO. NCR 90-ND454
 OTHER:
 DISCREPANCIES:
 NCR
 WER
 OTHER

EVALUATED BY: J.R. [Signature]
 LEVEL: [Blank] DATE: 3/10/90 INITIAL: DKL
 APPROVED BY: [Signature]
 TITLE: [Blank] SIGNATURE: [Blank]



RADIOGRAPHIC INSPECTION REPORT (IS 9.3)

NCR 90-10054
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PROJECT: PTP 3 - 10-03
 FOR: 89-530 313
 PS: REV. 1/A
 EXPOSURE SHEET NUMBER: 7

UNIT: Project Turkey Point # 3 DRAWING NO.: 85826

SYSTEM: S/G-TUBE PLUGS WELD NO.: SEE STATIONS

Q1 REV. TECH. CAT. AMEND/ACCEPT STD. JOINT: OPEN ROOT INSERT FACING VIA
 Q2 1 T.S.-9.3 I ASME III WIG. STD. PARTIAL FINAL EVIDENCE POINT WATER POINT

MATERIAL TYPE: INCONEL 690 THICKNESS RANGE: DIA OR LENGTH: 1 1/2"
 NO. OF EXPOSURES: 1 NO. FILM JOINTS: 4 REF. NCR # 90-10054
 PENETRANT: 10 WATER: ALL
 PEN PLACING: SOURCE SIDE FILM SIDE

SOURCE: IR 192 CO: 50 X-RAY SHIM MATERIAL: S/S THICKNESS: 0.150 in
 SR. NO.: 8951 SOURCE SPOT SIZE: 137 SCREENS: PD OTHER
 CLSEC. CLMIN. 820 MAGNIF.: SFO: 20" SCREEN THICKNESS: FRONT 0.0 BACK 0.0

FILM TYPE: AGFA SPEED: D-2 LOAD: QUAD LOCATION MARKER: SOURCE SIDE FILM SIDE
 SURFACE CONDITION: AS WELDED FLAT TOPPED NA GROUND SMOOTH AT 7/16" SPACING & W. AT 7/16" INCHES INTER-ALL
 RADIOGRAPHER: Dave Hottel II 3/13/90 DATE: 3/13/90 REQUIRED SENSITIVITY: 2T 4T

VIEWING TECHNIQUE: SINGLE FILM COMPOSITE FILM EXAMINATION: SINGLE WALL DOUBLE WALL

STATIONS	POSITION	SLAG	CRACK	LACK OF FUSION	UNDESIRABLE WELD METALLURGY	CRATER	PIT/CRACK	UNDERCUT	WORM EATING	UNFINISHED WELD	TURBULENCE	SURFACE IMPURITIES	ANODE	FILM ARTIFACT	DUNE DENSITY	FILM DENSITY	SENSITIVITY	ACCEPT	REJECT	REMARKS
<u>5/1</u>																				
<u>90</u>																				
<u>18</u>																				
<u>21</u>																				
<u>27</u>																				
<u>36</u>																				
<u>37</u>																				
<u>38</u>																				
<u>NOTE: Radiography ^{NO} indications were revealed 3/13/90</u>																				

NOTE NO. FPL-PTP-4302 DUC 7 31 90
FPL-PTP-5322 DUC 4 17 90

EVALUATED BY: J.R. [Signature] LEVEL: 3/13/90 DATE: 3/13/90 INITIAL: JH

THIS REPORT IS FOR: TRAVELER
WORK 90-10054

OTHER: SCREENING

REMARKS APPROVED BY: [Signature] DATE: 3/13/90

SHIPPING NOTICE

JOB NO. _____

SN NO. CT0391

DATE May 14 1991

CONSIGNEE TO Chuck Harden Red Lion Inn Room 116

ADDRESS 570 Liso Dr Kelso WA 98626

ROUTING _____

COLLECT PREPAID

SHIP VIA	AIR EXPRESS	<input checked="" type="checkbox"/>	PURCHASE ORDER NO.	O S & D NO.	ORIGINAL MRR NO.
	EXPRESS	<input type="checkbox"/>	MATERIAL ORIGINALLY PURCHASED ON P.O. NO.	SUPPLIER	
	RAIL FREIGHT	<input type="checkbox"/>	REASON FOR SHIPMENT:		
	MOTOR FREIGHT	<input type="checkbox"/>	<u>Joyan a, B+W</u>		
	PARCEL POST	<input type="checkbox"/>	SHIPMENT AUTHORIZED	BILL OF LADING ATTACHED	
	BEARER	<input type="checkbox"/>	<u>Dennis Green</u>	<u>FGS EX</u> <u>982146725</u>	

ITEM NO.	QUANTITY	UNIT	COMPLETE DESCRIPTION
1	14		Plugs 85825.1, 1, 3, 5, 6, 7
			88512 4, 5, 6, 7
			85825.4. 9, 10, 14, 17

Explanation of plug 4/10/94
 Serial numbers listed
 NOTE: above per our own records.

DRAWING 85825.4
 TRANSFER # 0039
 HEAT # 5207

DRAWING 85825. BH 1
 TRANSFER # 0039
 HEAT # NX5207

DRAWING 88512
 TRANSFER # 0053
 HEAT # 764484

RETURN AUTHORIZED BY: _____

COMPANY _____

SHIPPER
Universal Testing Labs, Inc.
 5959 SHALLOWFORD RD.
 SUITE 531
 CHATTANOOGA, TN. 37421

ADDRESS _____

PER _____

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