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— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 103634**

Prepared for Welspun Tubular (11685)

9301 Frazier Pike  
Little Rock AR 72206

# Table of Contents

AC Inspection as Found - *LR MOTORSHOP*

AC Inspection - Rev. 2: *CAT: H0150V2SLG*

**1.0**

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Hi-Speed Industrial Service  
7030 Ryburn Dr  
Millington, Tn 38053  
901-873-5300

## AC Inspection as Found

Welspun Tubular (11685)

9301 Frazier Pike  
Little Rock, AR 72206

FolderID: 103634  
FormID: 21947538

### AC Inspection - Rev. 2

Location: LR MOTORSHOP  
Serial Number: CAT: H0150V2SLG  
Description: 150HP US MOTORS 1780RPM

Hi-Speed Job Number:	103634
Manufacturer:	US Motors/Nidec
Product Number:	M: DN11
Spec/ID #:	A047712362-009 R 0004
Serial Number:	CAT: H0150V2SLG
HP/kW:	150 (HP)
RPM:	1780 (RPM)
Frame:	H444TP
Voltage:	460
Current:	164 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
Enclosure:	WPI
# of Leads:	6
J-box Included:	None
Coupling/Sheave:	None
Bearing RTDs:	No
Stator RTDs:	No
Repair Stage:	Final
Rewind:	No
Shaft Machined Fit Repairs Required:	Yes
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	Yes
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 3 - High ● 7 - Good

### Overall Condition

1. Report Date	10/21/2024
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## 2. Nameplate Picture



## 3. Photos of all six sides of the machine.



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1.3



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1.4





Heater ohms



4.	Describe the Overall Condition of the Equipment as Received	
	Serviceable	
5.	Report Date [COPY]	
<b>Initial Mechanical/Electrical</b>		
6.	Does Shaft Turn Freely?	(Y) Yes
7.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
8.	Does Shaft Have Visible Damage?	(No) No


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9.	Assembled Shaft Runout	Inches
	Na	
10.	Assembled Shaft End Play	inches
11.	Air Gap Variation <10%	
	12. Lead Condition	(P) Pass
	13. Lead Length	22 Inches
	14. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes

15. Lead Numbers	1,2,3-7,8,9
16. Frame Condition	pass
17. Fan Condition	
18. Heater Quantity, Ratings	
Quantity	Volts/Watts Pass/Fail
1	115/192



19. Broken or Missing Components  
 *No connection box.*

**Initial Electrical Inspection**



21. Winding Resistance

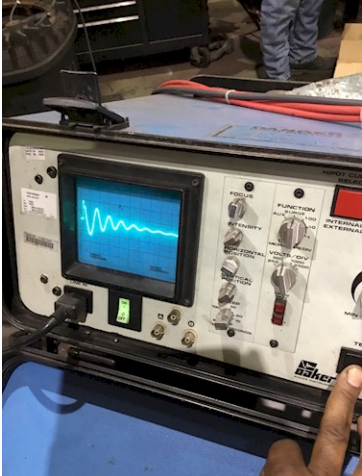
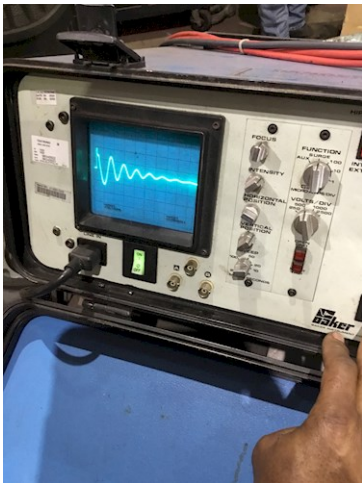
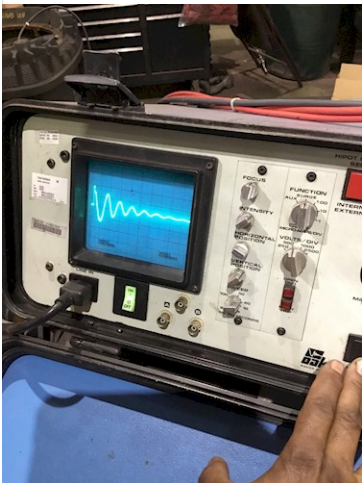
1-2

1-3

2-3

22. Perform Surge Test

(P) Pass



23. Number of Stator Slots

72

24. Stator Condition

rusty but passed surge & Meg

25. Stator Thermistors/Ohms

26. Stator Overloads/Ohms

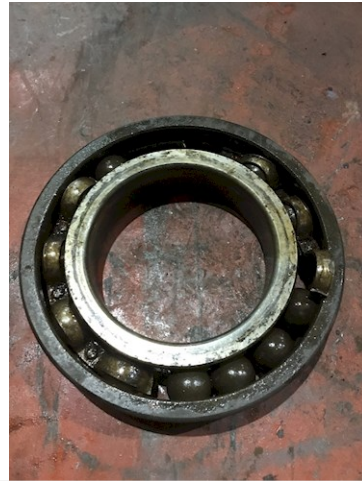
.1

Mechanical Inspection

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27. Drive End Bearing Brand	FAG
28. Drive End Bearing Number-	7322-B-XL-MP
	
29. Drive End Bearing Qty.	1
30. Drive End Bearing Type	(Thrust) Thrust
 	
31. Drive End Lubrication Type	(Oil) Oil Lubricated
32. Drive End Bearing Insulation or Grounding Device?	none
33. Drive End Wavy Washer/Snap-Ring Other Retention Device?	none
34. Drive End Bearing Condition	replace
35. Opposite Drive End Bearing Brand	in- readable
36. Opposite Drive End Bearing Number-	6215 J
37. Opposite Drive End Bearing Qty.	1
38. Opposite Drive End Bearing Type	(Ball) Ball Bearing
39. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
40. Opposite Drive End Bearing Insulation or Grounding Device?	
	
41. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap-ring
42. Opposite Drive End Bearing Condition	rusted and worn with cage failure





43. Drive End Seal

44. Opposite Drive End Seal

dust seal

### Rotor Inspection

45. Rotor Type/Material

(Squirrel Aluminum) Squirrel  
Cage Aluminum Die Cast

 *Hollow shafted.*

46. Growler Test

(Pass) Pass

47. Number of Rotor Bars

57

48. Rotor Condition

pass

49. List the Parts needed for the Repair Below

*Sleeve ODE housing fit.*

50. Signature of Technician that Disassembled Motor

Terrence Holland



### Mechanical Fits- Rotor

51. Shaft Runout

52. Rotor Runout

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

53. Coupling Fit Closest to Bearing Housing

0 Degrees

90 Degrees

120 Degrees

54. Coupling Fit Closest to the end of the Shaft

0 Degrees

60 Degrees

120 Degrees

55. Drive End Bearing Shaft Fit

0 Degrees


60 Degrees

120 Degrees

4.3302

4.3301

4.3301

 56. Drive End Bearing Shaft Fit Condition

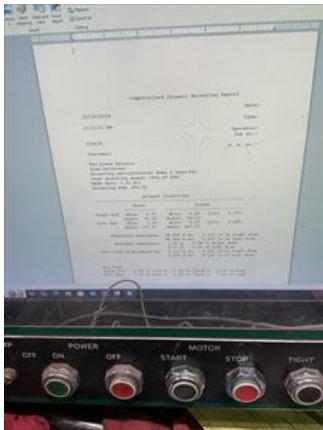
(F) Fail

57. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
2.9522	2.9523	2.9523	
<div> <div></div> Minimum allowed </div>			
58. Opposite Drive End Bearing Shaft Fit Condition			(F) Fail
59. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
Mechanical Fits- Bearing Housings			
60. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
61. Drive End - Endbell Bearing Fit Condition			(P) Pass
62. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
<div> <div></div> Has lip worn in. </div>			
63. Opposite Drive End - Endbell Bearing Fit Condition			(F) Fail
64. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
65. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
66. List Machine Work Needed Below	Sleeve lower end bell housing, and repair upper and lower bearing shaft fits. Replace worn shaft grounding ring.		
67. Technician	Terrence Holland		
			
Root Cause of Failure			
68. Failure locations	Lower bear was rusted and grease was contaminated. Lower bearing housing has lip worn in and upper bearing shaft fit measures too small.		
69. Root cause of failure	Water contaminated grease in lower bearing.		
Dynamic Balance Report			

## 70. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade



## 71. Initial Balance Readings

Drive End

Opposite Drive End

**.37****1.26**

## 72. Final Balance Readings

Drive End

Opposite Drive End

**.05****.07**

## 73. Technician

**RW**
**Mechanical Fits- Rotor - Post Repair**

## 74. Shaft Runout Post Repair

**0.001 inches**

## 75. Rotor Runout Post Repair

Drive End Bearing Fit

Rotor Body

Opposite Drive End Bearing

**0.002****0.002****0.002**

## 76. Coupling Fit Closest to Bearing Housing Post Repair

0 Degrees

90 Degrees

120 Degrees

## 77. Coupling Fit Closest to the end of the Shaft Post Repair

0 Degrees

60 Degrees

120 Degrees

## 78. Drive End Bearing Shaft Fit Post Repair

0 Degrees

60 Degrees

120 Degrees

**D.W.**



79. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.9534	2.9534	2.9534



80. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	

81. Shaft Repair Sign-off	Gary
.	

Mechanical Fits- Bearing Housings - Post Repair		
82. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
83. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
5.1187	5.1188	5.1188



84. Bearing Cap Condition Post Repair

Drive End Bearing Cap

Opposite Drive End Bearing Cap

*Installed AGIS ring on O.D.E. bearing cap.*



85. End Bell Air Seal Fits Post Repair

Drive End Air Seal

Opposite Drive End Air Seal

86. End Bell Repair Sign-off

Gary

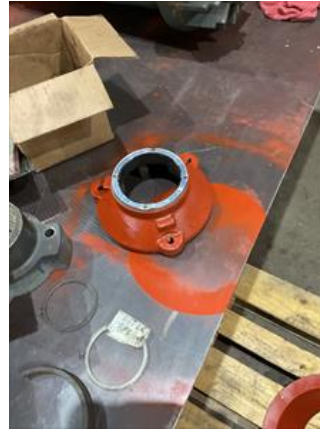
Assembly

87. QC Check All Parts for Cleanliness Prior to Assembly

88. Photograph All Major Components prior to assembly

(Complete) Complete





89. Final Insulation Resistance Test

Passed the High Pot

Megohms





90. Assembled Shaft Endplay	inches		
Na			
91. Assembled Shaft Runout	inches		
Na			
92. Test Run Voltage			
Volts	Volts	Volts	
457	457	459	



93. Test Run Amperage

Amps

41.2

Amps

40.1

Amps

40.7



TRH

94. Drive End Vibration Readings - Inches Per Second

Horizontal

0.03

Vertical

0.03

Axial

0.04

95. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

Na

96. Ambient Temperature - Fahrenheit

Na

97. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

98. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

Na

99. Document Final Condition with Pictures after paint



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100. Final Pics and QC Review

RW

Handwritten signature: *RL*



Co sign TRH





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