

AC Inspection as Found Welspun Tubular (11685) 9301 Frazier Pike

Little Rock, AR 72206

FolderID: 104111 FormID: 23312554

AC Inspect	ion - Rev. 2		Hi-Speed Job Number:	104111
Location:	LR MOTOR S	SHOP	Manufacturer:	Siemens
Serial Numb	er: N8/64L4L270		Product Number:	LLAO224-4YA96-Z
Description:	45 KW SIEMANS		Spec/ID #:	IEC 60034-1
			Serial Number:	N8/64L4L270
			HP/kW:	45 (HP)
			RPM:	1776 (RPM)
			Frame:	225M
			Voltage:	460
			Current:	70 (Amps)
			Phase:	Three
			Hz:	60 (Hz)
			Enclosure:	TEFC
			# of Leads:	6
			J-box Included:	Complete
			Coupling/Sheave:	None
			Date Received:	02/06/2025
			Bearing RTDs:	No
			Stator RTDs:	No
			Repair Stage:	Final
			Rewind:	Yes
			Shaft Machined Fit Repairs Required:	Yes
			Bearing Housing Machined Fit Repairs Required:	Yes
			Heaters:	No
			Winding Type :	Random Wound
			Bearing Type:	Rolling Element
Priorities Found	: 🛑 10 - High	🔵 6 - Good		

Overall Condition

Report Date 1.

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2. Nameplate Picture



3. Photos of all six sides of the machine.









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12.	Lead Length	6 Inches	
13.	Does it have Lugs?, If so what is the Stud Size?		
-	Yes		
14.	Lead Numbers	1-6	
) 15.	Frame Condition		
) 16.	Fan Condition	(F) Fail	
	Fan is entirely melted		
• 17.	Does motor have internal fan?	(No) No	
• 18.	Broken or Missing Components	fan	
Initial E	Electrical Inspection		
19.	Insulation Resistance/Megger	Megohms	
20.	Winding Resistance		
	1-2 1-3	2-3	
21.	Perform Surge Test	(NA) Not Applicable	
22.	Number of Stator Slots	48	
) 23.	Stator Condition		
-	Core damage		
24.	Stator Thermistors/Ohms		
25.	Stator Overloads/Ohms		
Mecha	nical Inspection		
26.	Drive End Bearing Brand	SKF	
27.	Drive End Bearing Number-	6313	
28.	Drive End Bearing Qty.	1	
29.	Drive End Bearing Type	(Ball) Ball Bearing	
30.	Drive End Lubrication Type	(Grease) Grease Lubricated	
31.	Drive End Bearing Insulation or Grounding Device?	L 1	
32.	Drive End Wavy Washer/Snap-Ring Other Retention Device?	bearing cap springs	
33.	Drive End Bearing Condition		
34.	Opposite Drive End Bearing Brand	0010	
35.	Opposite Drive End Bearing Number-	6313	
36.	Opposite Drive End Bearing Uty.	(D-II) D-I D- 1	
37.	Opposite Drive End Bearing Type	(Ball) Ball Bearing	
38.	Opposite Drive End Lubrication Type	(Grease) Grease Lubricated	

39. Opposite Drive End Bearing Insulation or Grounding Device?

40.	Opposite Drive End Wavy Washe	er/Snap-Ring Other Retention Device	?	
41.	Opposite Drive End Bearing Cond	dition	cage failed	
42.	Drive End Seal			
43.	Opposite Drive End Seal		65-85-10	
Rotor I	Inspection			
44.	Rotor Type/Material		(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast	
45.	Growler Test		(Pass) Pass	
46.	Number of Rotor Bars		36	
47.	Rotor Condition		pass needs cleaned	
4 8.	List the Parts needed for the Rep	air Below		
	6313x2 Bearing sleeve for end bell Snap ring Lip seal 65-85-10			
L	Mie			
Mecha	nical Fits- Rotor			0
50.	Shaft Runout		0.002 inches	
	After assembling.			
51.	Rotor Runout			
	Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
52.	Coupling Fit Closest to Bearing H	ousing		
	0 Degrees	90 Degrees	120 Degrees	
53.	Coupling Fit Closest to the end of	the Shaft		
	0 Degrees	60 Degrees	120 Degrees	
		-		
54.	Drive End Bearing Shaft Fit			
	0 Degrees	60 Degrees	120 Degrees	
	-	5		
-	5.51275.5124-5.5125			
55.	Drive End Bearing Shaft Fit Cond	lition	(P) Pass	

	56.	Opposite Drive End Bearing Shaf	t Fit		P89
		0 Degrees	60 Degrees	120 Degrees	
	57.	Opposite Drive End Bearing Shaf	t Fit Condition	(F) F	ail P95
	-	Bearing spun on shaft			
	59	Shaft Air Saal Fita			
	58.	Shaft Air Seal Fits	Opposite Drive End Air Seel		
		Drive Eriu Ali Seal	Opposite Drive Ellu All Seal		
Μ	echa	nical Fits- Bearing Housings			0
	59.	Drive End - Endbell Bearing Fit			
		0 Degrees	60 Degrees	120 Degrees	
	-	2.5599-2.5599-2.5599			
	60.	Drive End - Endbell Bearing Fit C	ondition	(P) Pa	SS
	61.	Opposite Drive End - Endbell Bea	ring Fit		
		0 Degrees	60 Degrees	120 Degrees	
		Excessive wear and sleeve is pulle	d out		



	69.	Rotor Weight and Balance Grade			
		Rotor Weight	Balance Grade		
	70.	Initial Balance Readings			
		Drive End	Opposite Drive End		
	71.	Final Balance Readings			
		Drive End	Opposite Drive End		
	72.	Technician			
R	ewind	k			
	73.	Core Test Results - Watts loss pe	r Pound		
		Pre-Burnout	Post Burnout		
	74.	Core Hot Spot Test			
		Pre-Burnout	Post-Burnout		
	75.	Post Rewind Electrical Test- Insul	ation Resistance	Megohms	
	76.	Post Rewind Polarization Index		Polarization Index	
	77.	Post Rewind Winding Resistance			
		1-2	1-3	2-3	
	78.	Post Rewind Surge Test			
	79.	Post Rewind Hi-Pot		micro-amps	
	80.	Technician			_
M	echai	nical Fits- Rotor - Post Repair			0
	81.	Shaft Runout Post Repair		inches	
	-	NA			
	82.	Rotor Runout Post Repair	Defee De d		
		Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing	
	_	814			
	02	Coupling Eit Closest to Rearing H	auging Doct Donoir		
	03.			120 Dogrado	
		0 Degrees	90 Degrees	120 Degrees	
	-	NA			
	84	Coupling Fit Closest to the end of	the Shaft Post Penair		
	04.	0 Degrees	60 Degrees	120 Degrees	
		0 Degrees	ou Degrees	120 Degrees	
	-	NΔ			
	85	Drive End Bearing Shaft Fit Post	Repair		
	00.		60 Degrees	120 Degrees	
		U Degrees	00 Degrees	120 Degrees	
		Pass			

86.	Opposite Drive End Bearing Shafe	t Fit Post Repair		P500
	0 Degrees	60 Degrees	120 Degrees	
	2.5597	2.5597	2.5597	
87.	Shaft Air Seal Fits Post Repair			
	Drive End Air Seal	Opposite Drive End Air Seal		
	_			
88	Pass Shaft Repair Sign-off		RW	
1	7//			
Mechai	nical Fits- Bearing Housings -	- Post Repair		ia.
Mechai 89.	nical Fits- Bearing Housings - Drive End - Endbell Bearing Fit Po	- Post Repair ost Repair		Ō
Mechar 89.	nical Fits- Bearing Housings - Drive End - Endbell Bearing Fit Po 0 Degrees	- Post Repair ost Repair 60 Degrees	120 Degrees	
Mechar 89.	nical Fits- Bearing Housings - Drive End - Endbell Bearing Fit Po 0 Degrees	• Post Repair ost Repair 60 Degrees	120 Degrees	
Mechan 89.	nical Fits- Bearing Housings - Drive End - Endbell Bearing Fit Po 0 Degrees Opposite Drive End - Endbell Bea	• Post Repair ost Repair 60 Degrees ring Fit Post Repair	120 Degrees	D P19
Mechan 89.	nical Fits- Bearing Housings - Drive End - Endbell Bearing Fit Po 0 Degrees Opposite Drive End - Endbell Bea 0 Degrees	• Post Repair ost Repair 60 Degrees ring Fit Post Repair 60 Degrees	120 Degrees 120 Degrees	D P19
90.	nical Fits- Bearing Housings - Drive End - Endbell Bearing Fit Po 0 Degrees Opposite Drive End - Endbell Bear 0 Degrees 5.5123	• Post Repair ost Repair 60 Degrees ring Fit Post Repair 60 Degrees 5.5123	120 Degrees 120 Degrees 5.5123	P19
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P31 Final Insulation Resistance Test Megohms 96. 97. Assembled Shaft Endplay 0 inches 0.002 inches Assembled Shaft Runout 98. 99. Test Run Voltage P55 Volts Volts Volts 461 458 461 46 / 0458 046 I 02 IA 02 IA . P65 100. Test Run Amperage Amps Amps Amps 22.8 21.8 21.6

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101.	Drive End Vibration Readings - In	ches Per Second	
	Horizontal	Vertical	Axial
102.	Opposite Drive End Vibration Rea	dings - Inches Per Second	
	Horizontal	Vertical	Axial
103.	Ambient Temperature - Fahrenhe	it	
104.	Drive End Bearing Temps - Fahre	nheit	
	5 Minutes	10 Minutes	15 Minutes
105.	Opposite Drive End Bearing Temp	os - Fahrenheit	
	5 Minutes	10 Minutes	15 Minutes
106.	Document Final Condition with Pic	ctures after paint	
	See below		



Co sign: RRW







