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LR Motor Shop Repairs

Job Number 104112

Prepared for Welspun Tubular (11685)

9301 Frazier Pike
Little Rock AR 72206

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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: 104112
FormID: 23316575

AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: N8/64L4L265

Description: 45 HP SIEMANS

Hi-Speed Job Number: 104112

Manufacturer: Siemens

Product Number: LLAO224-4YA96

Serial Number: N8/64L4L265

HP/kW: 45 (HP)

RPM: 1770 (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

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: ● 5 - High ● 10 - Good

Overall Condition

1. Report Date

02/07/2025

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1.0

2. Nameplate Picture



3. Photos of all six sides of the machine.







4. Describe the Overall Condition of the Equipment as Received

Dirty

Initial Mechanical/Electrical

5. Does Shaft Turn Freely?	(Y) Yes
6. Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
7. Does Shaft Have Visible Damage?	(No) No
8. Assembled Shaft Runout	Inches
9. Assembled Shaft End Play	inches
10. Air Gap Variation <10%	ok
11. Lead Condition	(P) Pass
12. Lead Length	10 Inches
13. Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
14. Lead Numbers	1-6
15. Frame Condition	good
16. Fan Condition	(F) Fail
17. Does motor have internal fan?	(No) No
18. Broken or Missing Components	fan

Initial Electrical Inspection

19. Insulation Resistance/Megger	0 Megohms
20. Winding Resistance	

1-2

1-3

2-3

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21. Perform Surge Test	(F) Fail
22. Number of Stator Slots	
23. Stator Condition	rewind
24. Stator Thermistors/Ohms	none
25. Stator Overloads/Ohms	none
Mechanical 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?	none
32. Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
33. Drive End Bearing Condition	normal
34. Opposite Drive End Bearing Brand	SKF
35. Opposite Drive End Bearing Number-	6313
36. Opposite Drive End Bearing Qty.	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?	none
40. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	snap ring
41. Opposite Drive End Bearing Condition	normal

42. Drive End Seal

65*85*10



43. Opposite Drive End Seal

65*85*10




Rotor Inspection

44. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast
45. Growler Test	(Pass) Pass
46. Number of Rotor Bars	44
47. Rotor Condition	good
48. List the Parts needed for the Repair Below <i>Rewind, fan, 6313 2Z, 6313 2Z, 65*85*10 seal, 65*85*10 seal</i>	
49. Signature of Technician that Disassembled Motor	David Maclin

Mechanical Fits- Rotor

50. Shaft Runout	0 inches	
51. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
0	0	0

52. Coupling Fit Closest to Bearing Housing		
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
2.5597	2.5597	2.5597
55. Drive End Bearing Shaft Fit Condition		(P) Pass
56. Opposite Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
 Badly damaged		



57. Opposite Drive End Bearing Shaft Fit Condition			(F) Fail
58. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
ok	ok		
Mechanical Fits- Bearing Housings			
59. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5123	5.5123	5.5123	
60. Drive End - Endbell Bearing Fit Condition			(P) Pass
61. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
5.5135	5.5137	5.514	
62. Opposite Drive End - Endbell Bearing Fit Condition			(F) Fail
63. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		
ok	ok		
64. End Bell Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
ok	ok		
65. List Machine Work Needed Below			
<i>Weld and machine ode shaft, sleeve ode end bell.</i>			

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66. Technician

David Maclin


Root Cause of Failure

67. Failure locations

Winding

68. Root cause of failure

*Overload/ excessive heat***Dynamic Balance Report**

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

DM


Rewind

73. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

74. Core Hot Spot Test

Pre-Burnout

Post-Burnout

75. Post Rewind Electrical Test- Insulation Resistance

Megohms


76. Post Rewind Polarization Index

Polarization Index

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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		
Mechanical Fits- Rotor - Post Repair		
81. Shaft Runout Post Repair		inches
82. Rotor Runout Post Repair		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
83. Coupling Fit Closest to Bearing Housing Post Repair		
0 Degrees	90 Degrees	120 Degrees
84. Coupling Fit Closest to the end of the Shaft Post Repair		
0 Degrees	60 Degrees	120 Degrees
85. Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
86. Opposite Drive End Bearing Shaft Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
2.5592	2.5592	2.5592




87. Shaft Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	
88. Shaft Repair Sign-off		RW
		
Mechanical Fits- Bearing Housings - Post Repair		
89. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees

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90. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
5.5123	5.5123	5.5123



91. Bearing Cap Condition Post Repair		
Drive End Bearing Cap		Opposite Drive End Bearing Cap
92. End Bell Air Seal Fits Post Repair		
Drive End Air Seal		Opposite Drive End Air Seal

93. End Bell Repair Sign-off		RW
		

Assembly

94. QC Check All Parts for Cleanliness Prior to Assembly		David Mackin
		

95. Photograph All Major Components prior to assembly		(Complete) Complete
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96. Final Insulation Resistance Test

11,770 Megohms

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97. Assembled Shaft Endplay	0 inches	
98. Assembled Shaft Runout	0.0002 inches	
99. Test Run Voltage		
Volts	Volts	Volts



100. Test Run Amperage		
Amps	Amps	Amps



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101. Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
102. Opposite Drive End Vibration Readings - Inches Per Second		
Horizontal	Vertical	Axial
103. Ambient Temperature - Fahrenheit		
104. Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
105. Opposite Drive End Bearing Temps - Fahrenheit		
5 Minutes	10 Minutes	15 Minutes
106. Document Final Condition with Pictures after paint		





107. Final Pics and QC Review

RW

A handwritten signature in black ink, consisting of several loops and a long horizontal stroke, is written across the signature line.



Co sign TRH



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

AC Random Coil Rewind Report

FolderID: 104112
FormID: 23503845

Welspun Tubular (11685)

9301 Frazier Pike
Little Rock, AR 72206

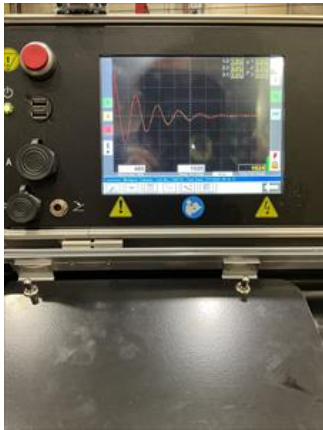
LR MOTOR SHOP

Priorities Found: ● 5 - Good

General	
1. Job Number	104112
2. Report Date	02/24/2025
3. Customer	Welspun
Stator Winding	
4. Core Length	10.375 "
5. Core ID	9.25 "
6. Back Iron Depth	1.25 "
7. Slot Depth	0.875 "
8. Tooth Width	0.375 "
9. Number of Vents	
10. Vent Width	
● 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	
14. Watts loss per lb. before burnout	1.08 W/lbs.
● 15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	
18. Watts loss per lb After Burnout	0.97 W/lbs.
● 19. Core Iron Condition	(P) Pass
20. RTD's	
21. RTD's Reading	
22. Motor Heaters	
23. Heater Qty.	
24. Heater Voltage	
25. Heater Wattage	
26. Thermistors	
27. Number of Poles	4
28. Slots	48
29. Number of Coils	24
30. Coil Weight	
31. Lead Markings	1-2-3-4-5-6
32. Grouping	12 Of 2
● 33. Multiple Wires	(Y) Yes

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34. Wire Size	
14 #17 awg	
35. Turns per coil	10
36. Pitch 1 to:	
10-12	
37. Connection	
1 WYE -1 DELTA	
38. Lead Length	12 "
39. Lead Size	4
40. Number of Leads	6
41. Megger Reading After Rewind	13659 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.04 Ua
46. Surge Pattern After Rewind	(P) Pass



47. Service Technician

Dr End 3.
ODE 2 .75
60 lbs copper wire total
30lbs #18 copper wire
15lbs #17 copper wire
15lbs #16 copper wire
12' #8 exar 600v lead wire





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11. **GOVERNING LAW AND JURISDICTION.** Any controversy arising out of any quotation, the purchase order, the goods sold or delivered, repair or replacement thereof, or any services provided pursuant to any quotation or any purchase order, or these Standard Terms and Conditions shall be governed by the laws of the state of Tennessee without regard to any choice of law provisions and any cause of action related in any manner thereto shall be brought only in the state or federal courts of Shelby County, Tennessee.
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13. **FORCE MAJEURE.** Neither party shall be responsible for any delay or failure in performance of any party of the quotation, purchase order or these Standard Terms and Conditions to the extent that such delays or failures are caused by fire, flood, earthquake, explosion, war, embargo, government requirement, civil or military authority, acts of God, or any other circumstances beyond its reasonable control and not involving any fault or negligence on the party affected ("Condition"). If any such Condition occurs, the party delayed or unable to perform shall promptly give written notice to the other party and, if such Condition remains at the end of thirty (30) days, the party affected by the other party's delay and inability to perform may elect to (i) terminate such order or part thereof, or (ii) suspend the order for the duration of the Condition, if the Buyer is the suspending party, buy elsewhere comparable material to be sold under the order and apply to any commitment the purchase price of such purchase, and resume performance of the order once the Condition ceases, with an option in the affected party to extend the period of this order up to the length of the time the Condition endures.
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