



**KEEPING YOUR FACILITY UP TO SPEED**  
— EVERY DAY SINCE 1946 —

LR Motor Shop Repairs

**Job Number 104556**

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: 104556  
FormID: 24332439

### AC Inspection - Rev. 2

Location: LR MOTOR SHOP

Serial Number: UD1206/1456097-001-1

Description: 18.6 KW NEMA

Hi-Speed Job Number:	104556
Manufacturer:	Siemens
Product Number:	1LE15231EB290JZ4
Serial Number:	UD1206/1456097-001-1
HP/kW:	18.6 (kW)
RPM:	1775 (RPM)
Frame:	60034
Voltage:	480
Current:	29.5 (Amps)
Phase:	Three
Hz:	60 (Hz)
Service Factor:	1.15
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:	No
Bearing Housing Machined Fit Repairs Required:	Yes
Heaters:	No
Winding Type :	Random Wound
Bearing Type:	Rolling Element

Priorities Found: ● 2 - High ● 15 - Good

### Overall Condition

1. Report Date

05/14/2025

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## 2. Nameplate Picture



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







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4.	Describe the Overall Condition of the Equipment as Received	
	<i>Serviceable</i>	
5.	Is this a UL Listed Motor	(No) No
6.	Is the motor water cooled or can be pressure checked before teardown	(No) No
<b>Initial Mechanical/Electrical</b>		
7.	Does Shaft Turn Freely?	(Y) Yes
8.	Does the shaft require T.I.R in Lathe to identify additional repairs?	(No) No
9.	Does Shaft Have Visible Damage?	(No) No
10.	Assembled Shaft Runout	0.001 Inches
11.	Assembled Shaft End Play	inches
12.	Air Gap Variation <10%	
13.	Lead Condition	(P) Pass



14.	Lead Length	8 Inches
15.	Does it have Lugs?, If so what is the Stud Size?	(Yes) Yes
	Connection block installed.	

## 16. Lead Numbers

1-6

U1-V1-W1  
U2-V2-W2



17. Are the Leads insulated with Chico or other material	(No) No
18. Frame Condition	pass
19. Fan Condition	(P) Pass



20. Does motor have internal fan?	(No) No
21. Broken or Missing Components	DE snap ring
<b>Initial Electrical Inspection</b>	
22. Insulation Resistance/Megger	Megohms

## 23. Winding Resistance

1-2

1-3

2-3

Motor windings blown in slot.



## 24. Perform Surge Test

(NA) Not Applicable



25. Number of Stator Slots

36

26. Stator Condition

pass

27. Stator Thermistors/Ohms

28. Stator Overloads/Ohms

.3

**Mechanical Inspection**

29. Drive End Bearing Brand

ORS

30. Drive End Bearing Number-

6210 C3

31. Drive End Bearing Qty.

1

32. Drive End Bearing Type

(Ball) Ball Bearing



33. Drive End Lubrication Type

(Grease) Grease Lubricated

34. Drive End Bearing Insulation or Grounding Device?

none

35. Drive End Wavy Washer/Snap-Ring Other Retention Device?

wavy washer

Wavy washer broken



36. Drive End Bearing Condition

worn

37. Opposite Drive End Bearing Brand

ORS

38. Opposite Drive End Bearing Number-

6210 C3

39. Opposite Drive End Bearing Qty.

1

40. Opposite Drive End Bearing Type

(Ball) Ball Bearing



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41. Opposite Drive End Lubrication Type	(Grease) Grease Lubricated
42. Opposite Drive End Bearing Insulation or Grounding Device?	none
43. Opposite Drive End Wavy Washer/Snap-Ring Other Retention Device?	two snap rings
44. Opposite Drive End Bearing Condition	worn
45. Drive End Seal	dust seal
46. Opposite Drive End Seal	dust seal
<b>Rotor Inspection</b>	
47. Rotor Type/Material	(Squirrel Aluminum) Squirrel Cage Aluminum Die Cast



48. Growler Test	(Pass) Pass
49. Number of Rotor Bars	28
50. Rotor Condition	pass
51. List the Parts needed for the Repair Below 2) 6210 C3 bearings	
52. Signature of Technician that Disassembled Motor	Terrence Holland

#### Mechanical Fits- Rotor

53. Shaft Runout	0.001 inches	
54. Rotor Runout		
Drive End Bearing Fit	Rotor Body	Opposite Drive End Bearing
55. Coupling Fit Closest to Bearing Housing		
0 Degrees	90 Degrees	120 Degrees
56. Coupling Fit Closest to the end of the Shaft		
0 Degrees	60 Degrees	120 Degrees
57. Drive End Bearing Shaft Fit		
0 Degrees	60 Degrees	120 Degrees
1.9691	1.969	1.969
58. Drive End Bearing Shaft Fit Condition	(P) Pass	

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59. Opposite Drive End Bearing Shaft Fit			
0 Degrees	60 Degrees	120 Degrees	
1.969	1.969	1.969	
60. Opposite Drive End Bearing Shaft Fit Condition			(P) Pass
61. Shaft Air Seal Fits			
Drive End Air Seal	Opposite Drive End Air Seal		
<b>Mechanical Fits- Bearing Housings</b>			
62. Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	



63. Drive End - Endbell Bearing Fit Condition	(F) Fail
<div></div> Lip worn in.	



64. Opposite Drive End - Endbell Bearing Fit			
0 Degrees	60 Degrees	120 Degrees	
3.5448	3.5446	3.5447	
<div></div> Max allowed is 3.5442			
65. Opposite Drive End - Endbell Bearing Fit Condition			(F) Fail
<div></div> See above			
66. Bearing Cap Condition			
Drive End Bearing Cap	Opposite Drive End Bearing Cap		

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67. End Bell Air Seal Fits

Drive End Air Seal

Opposite Drive End Air Seal

68. List Machine Work Needed Below

*Sleeve both end bell housing fits.*

69. Technician

Terrence Holland



Co sign: RRW

### Root Cause of Failure

70. Failure locations

*Both housing fits bad. Rewind stator. Windings blown in slot*



71. Root cause of failure

*D.E. Housing fit has lip worn in allowing the rotor to impact the stator iron causing a electrical grounding to the iron.  
Contaminated grease I both bearings was a contributing factor to premature bearing failure.*

### Dynamic Balance Report

72. Rotor Weight and Balance Grade

Rotor Weight

Balance Grade

## 73. Initial Balance Readings

Drive End

Opposite Drive End

NEMA Spec: 1.30 Mil  
Balancing RPM: 400.69

Balance Condi

Start

	Mils:	Angle:
Right End	0.87	197.52
Left End	2.77	355.08

Beginning unbalance: 14.141 g  
Residual unbalance: 2.00 g  
This item is balanced to: 8.496 g

Key Data:  
Drive End: 0.00 in wide x 0.00 in  
Head End: 0.00 in wide x 0.00 in

## 74. Final Balance Readings

Drive End

Opposite Drive End

Balance Conditions

Finish

	Mils:	Angle:
Right End	0.40	54.38
Left End	0.28	263.99

Beginning unbalance: 14.141 g-in, 0.499 oz-in Right Side  
Residual unbalance: 183.805 g-in, 6.494 oz-in Left Side  
This item is balanced to: 2.00 g, 0.07 oz Right Side  
8.496 g-in, 0.229 oz-in Right Side  
18.585 g-in, 0.654 oz-in Left Side

in wide x 0.00 in thick x 0.00 in long  
in wide x 0.00 in thick x 0.00 in long

## 75. Technician

Cw



## Rewind

## 76. Core Test Results - Watts loss per Pound

Pre-Burnout

Post Burnout

## 77. Core Hot Spot Test

Pre-Burnout

Post-Burnout

## 78. Post Rewind Electrical Test- Insulation Resistance

Megohms

## 79. Post Rewind Polarization Index

Polarization Index

80. Post Rewind Winding Resistance		
1-2	1-3	2-3
81. Post Rewind Surge Test		
82. Post Rewind Hi-Pot		micro-amps
83. Technician		
<b>Mechanical Fits- Bearing Housings - Post Repair</b>		
84. Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.5435	3.5435	3.5434



85. Opposite Drive End - Endbell Bearing Fit Post Repair		
0 Degrees	60 Degrees	120 Degrees
3.5437	3.5437	3.5436



86. Bearing Cap Condition Post Repair		
Drive End Bearing Cap	Opposite Drive End Bearing Cap	
87. End Bell Air Seal Fits Post Repair		
Drive End Air Seal	Opposite Drive End Air Seal	

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88. End Bell Repair Sign-off

Gary

### Assembly

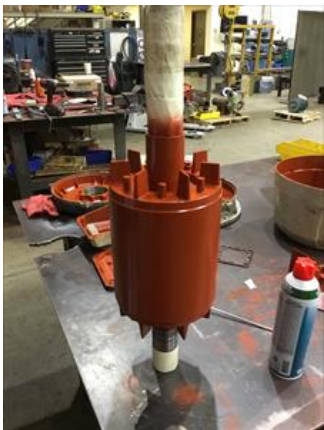
89. QC Check All Parts for Cleanliness Prior to Assembly

Cw



90. Photograph All Major Components prior to assembly

(Complete) Complete



91. Final Insulation Resistance Test	Megohms
92. Assembled Shaft Endplay	inches
93. Assembled Shaft Runout	0.001 inches

94. Test Run Voltage

Volts

Volts

Volts



95. Test Run Amperage

Amps

Amps

Amps



96. Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

97. Opposite Drive End Vibration Readings - Inches Per Second

Horizontal

Vertical

Axial

98. Ambient Temperature - Fahrenheit

99. Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

100. Opposite Drive End Bearing Temps - Fahrenheit

5 Minutes

10 Minutes

15 Minutes

101. Document Final Condition with Pictures after paint

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102. Final Pics and QC Review

Cw



Co sign: RRW



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

## AC Random Coil Rewind Report

FolderID: 104556  
FormID: 24511462

### Welspun Tubular (11685)

9301 Frazier Pike  
Little Rock, AR 72206

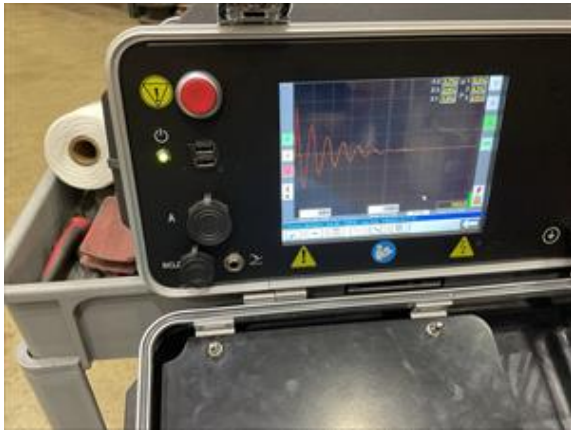
LR MOTOR SHOP

Priorities Found: ● 5 - Good

General	
1. Job Number	104556
2. Report Date	05/20/2025
3. Customer	Welspun
Stator Winding	
4. Core Length	7.75 "
5. Core ID	7 "
6. Back Iron Depth	1.125 "
7. Slot Depth	1.125 "
8. Tooth Width	0.25 "
9. Number of Vents	
10. Vent Width	
<span style="color: green;">●</span> 11. Before Burnout Core loss	(P) Pass
12. Flux Before Burnout	
13. Watts before burnout	Watts
14. Watts loss per lb. before burnout	1.848 W/lbs.
<span style="color: green;">●</span> 15. After Burnout Core Loss	(P) Pass
16. Flux After burnout	
17. Watts After Burnout	
<span style="color: green;">●</span> 18. Watts loss per lb After Burnout	0.0543 W/lbs.
19. Core Iron Condition	
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	36
29. Number of Coils	36
30. Coil Weight	
31. Lead Markings	
U1 V1 W1	
U2 V2 W2	
32. Grouping	
6of1	
6of2	

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33. Multiple Wires	(Y) Yes
34. Wire Size 7#19 1#20	
35. Turns per coil	22
36. Pitch 1 to: 8. 8-10	
37. Connection Wye-Delta	
38. Lead Length 6"	"
39. Lead Size	8'#8 EXAR
40. Number of Leads	6
41. Megger Reading After Rewind	3000 Mohms
42. Coil Machine Slot	
43. Coil Machine Tip	
44. Coil Machine Pitch	
45. Hi Pot Reading After Rewind	0.23892 Ua
46. Surge Pattern After Rewind	(P) Pass



#### 47. Service Technician

LE 3". 1-2-0.261500  
OE 3". 2-3-0.261700  
3-1-0.261700





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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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