
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116

Revision: 6

Customer P.O.: S005242-F/Ln:2
Serial No./Qty: C2

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Problem: NON-CONFORMANCE 1

PART IS REJECTED PER ASTM A903/A903M Level I. INDICATION IS V-SHAPED AND IS APPROXIMATELY .450" IN LENGTH ON THE LONGEST LEG (SEE PICTURES). INDICATION IS ON THE THIN SECTION OF THE T, LOCATED BETWEEN HOLES 84 AND 85. SEE ACCOMPANYING PHOTOS.

NON-CONFORMANCE 2

PART IS ALSO REJECTED PER ASTM A903/A903M LEVEL II. INDICATIONS ARE JUST OVER THE ACCEPTABLE SIZE RANGE. SEE ACCOMPANYING PHOTOS.

Proposed Disposition:

CUSTOMER TO ADVISE.

Number of additional pages: _____

Customer Disposition: Use As Is Rework Repair Scrap Replace

This NCR refers to MCWF C2. Please see Attachment I for backup data for this disposition.

Tech. Rep. Approval:

RLM Approval:

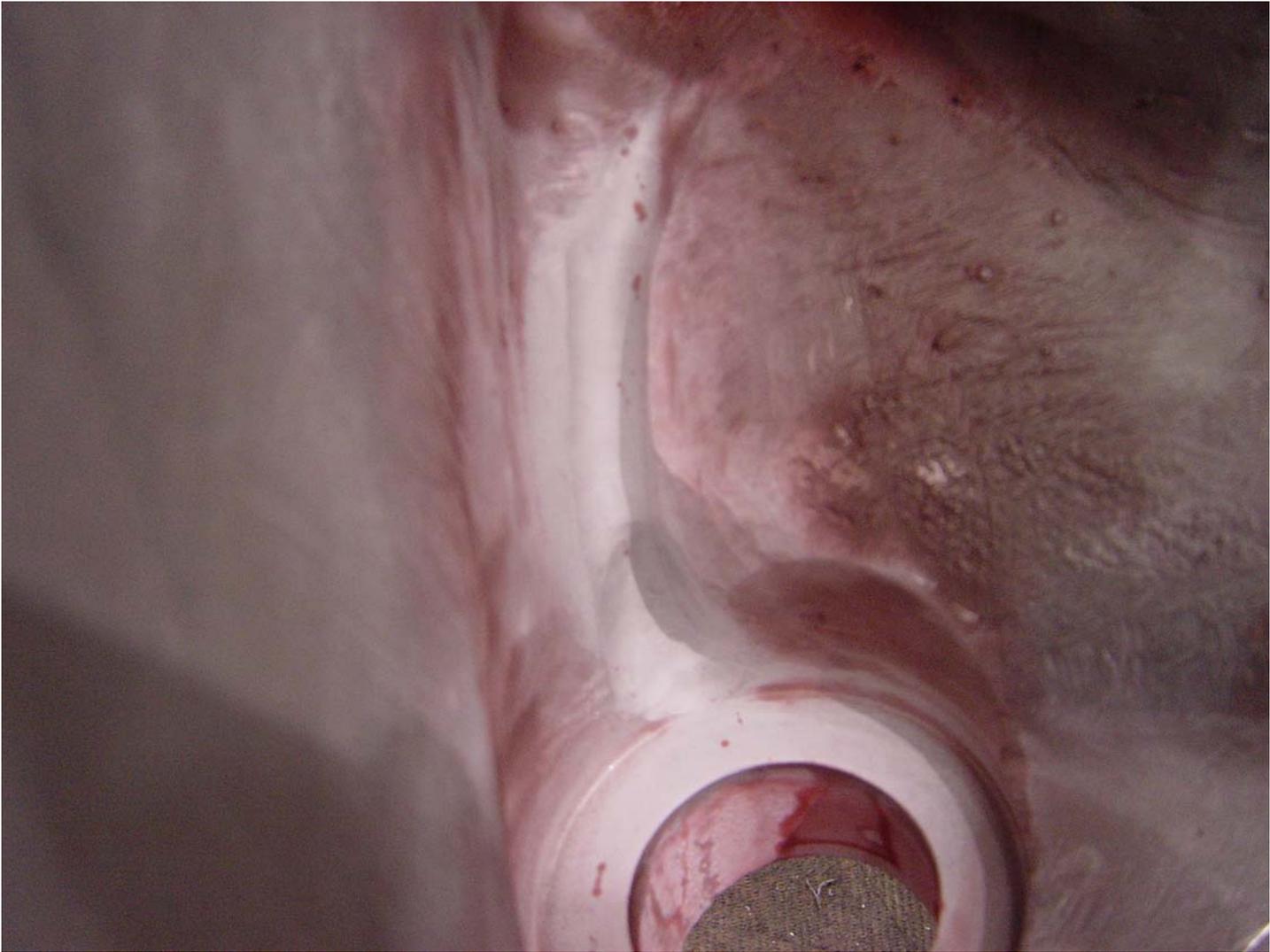
Non-conformance 1

Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

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Non-conformance 2



Attachment I: Disposition of NCR # 18715 for MCWF C-2

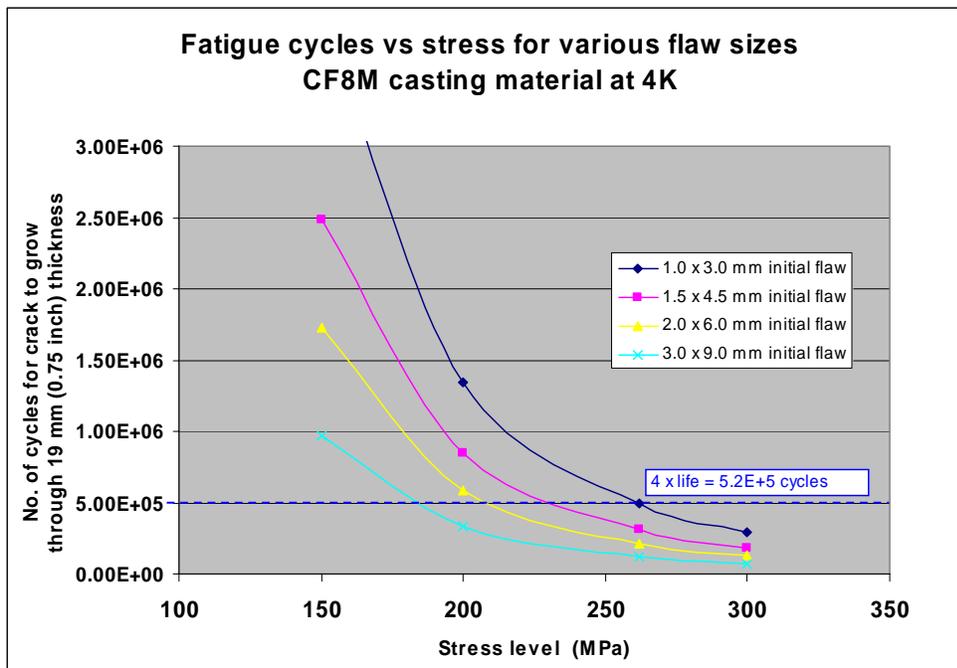
NCR #1: Disposition: Accept AS IS.

As can be seen in the photos below, the non-conforming linear indication

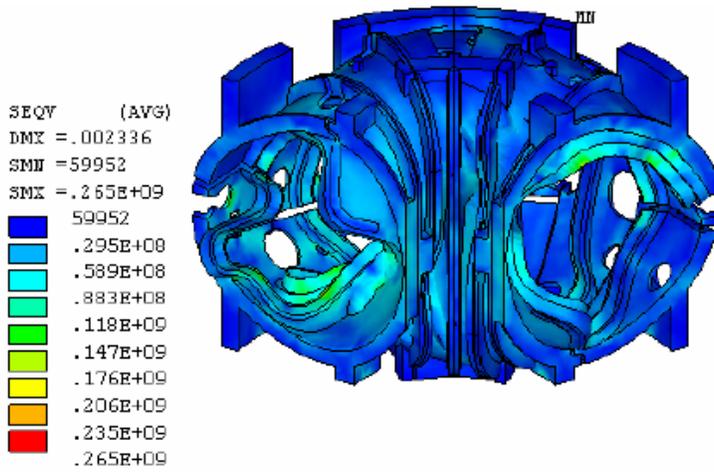
(in the ground depression) is ~11 mm long. It is located between bolt holes 84 and 85. The stress in this region is ~60 MPa, but it is adjacent to an area where the stress is ~120 MPa.



The recommendation to accept “AS IS” is based on the adequacy of the fracture lifetime with an 11 mm initial flaw in the T with a stress of 60 MPa. The plot below is from an internal NCSX Project Power Point slide set entitled “fracture story-3”. The plot shows that an initial flaw size 3 x 9 mm would meet 4 x life to crack through the T for a stress level of ~180 MPa. The 60 MPa – the stress in the area of this flaw- is well off to the left of the vertical axis of the graph. Based on this, we feel it is reasonable and in the best interest of the project to accept this flaw “as is”.



NCR#2: Disposition: Accept AS IS. This indication is in a region where the stress is low – in the range of 60 MPa (see the figure below – virtually all of the leg region is ~60 MPa). The fatigue curve shown for NCR 1 is for a pre-existing crack to grow through a 3/4” thickness and, as in NCR1, the 60 MPa stress is far to the left of the vertical axis. It is in a heavy overcast area near the region where the leg, shell, and flange all come together; consequently, this indication can be accepted as is. The thickness that the flaw would have to “grow” through is significantly bigger for this flaw: the leg is ~1 3/8” thick; the shell is ~1 3/8” thick; the flange is 1 1/4”



Unit of stress in pascal

