

Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 19321

Page: 1
Date: 03/03/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116 Revision: 8

Customer P.O.: S005242-F/Ln:4
Serial No./Qty: C4

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

Problem: There is a tool gouge in the T-section of the Datum E side. The gouge is along the short leg of the L in the location where the .5" VPI bleed hole intersects the T-section (zone F3 on sheet 9 of the drawing). The gouge is approximately 12" in length and approximately .05" in depth. The width and location of the gouge varies along the surface. See attached pictures for further details.

Proposed Disposition:

Major Tool Proposes to weld the defective area after the completion of all machining operations. Indicators would be placed on and around the T section to monitor any movement that may occur during welding. If required, welds will be performed on the opposite side of the T to counteract any movement that occurs. The welded areas will be blended to the adjacent machined surfaces to maintain the correct profile. Both a PT inspection and permeability check will be performed on any welded areas. Major Tool also proposes a waiver of RT for this repair. Due to the thickness of the casting in this area, it is highly unlikely that an x-ray would produce any evidence of a defect introduced by the welding process.

Number of additional pages: 4

Customer Disposition: Use As Is Rework Repair Scrap Replace

- This tool gouge is located on the base of the "T" between bolt locations 25 and 30. Please see the attached photos also.
- The size and location of this gouge requires this defect to be weld repaired.
- Major Tool's proposal to waive the RT for this repair and perform PT and permeability checks is accepted

EIO verification of completion: Nancy Horton Title: EIO Program Mgr for NCSY Date: 3/24/06

Digitally signed by Mike Griffith
DN: CN = Mike Griffith, C = US, O = Major Tool and Machine, OU = CFT White
Date: 2006.03.24 17:26:45 -0500

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

Approved by:

Phil Heitzenroeder
Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US, O = PPPL, OU = Mech. Eng. Division
Reason: I agree to 'specified' portions of this document
Date: 2006.03.22 09:48:12 -0500

Brad Nelson

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2006.03.21 21:08:57 -0500

Tech. Rep.

RLM

n:\mmaps\lmonc14.qrp



Nondestructive Test Certification for Liquid Penetrant Examination

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

Date of Inspection: 03/24/2006

Type of Material: CAST STAINLESS

NDT#: 16147

Inspection Requirements:

100 % of all accessible surfaces Joint Preps Root Pass Back Gouge Cover Pass Other

Inspector: 674-S.WILLIAMS

Date: 03/24/2006

Sylvester Williams Level II MTM
P-1

NDT001

n:\mtmapps\MTNDTLPI.QRP

Page: 1

/NDT:All /Dat:All /WO:65707 /Lot:4 /Spl:0 /Sub:12 /Op:30
 User ID: GRIFFIT# Date: 03/24/06



INSPECTION DATA CHECKLIST

Workorder: 65707/4-0 Sub:12 Op:40

Revision: 03/06/06 7:42

Part: REWORK - REWORK / REPAIR PER N/C - N/C # _____

Drawing ID: SE141-116 Rev: 8		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
(10)		N C 19321 RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO 03-24-06			A

Employees: 503-B.Houk

* To Far Right Indicates Data Package Requirement

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.