

**Customer: ENERGY INDUSTRIES OF OHIO**

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**Part: SE141-114 / MODULAR COIL WINDING FORM TYPE**

Drawing ID: SE141-114

Revision: 6

Customer P.O.: S005242-F/Ln:2  
Serial No./Qty: A2

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

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

Problem: PART IS REJECTED PER ASTM A903/A903M LEVEL 1.  
SEE ATTACHMENT FOR SIZES AND LOCATIONS.

**Proposed Disposition:**

PROPOSE TO USE AS IS.

Number of additional pages: 8 page attachment

**Customer Disposition:**     Use As Is     Rework     Repair     Scrap     Replace

The indications were reviewed by David Williamson (see below). Since all but one small cluster was in a low stress area, they are accepted "use as is".  
From: "Williamson, David E." <williamsonde@ornl.gov>  
Date: June 23, 2006 9:57:52 AM EDT  
To: "Frank A. Malinowski" <fmalinow@pppl.gov>, "Nelson, Brad E." <nelsonbe@ornl.gov>, Phil Heitzenroeder <pheitzen@pppl.gov>  
Cc: "Colin F. Phelps" <cphelps@pppl.gov>  
Subject: RE: A2 PT rejections  
Phil, Frank,  
There are four PT indications on the winding surface (#2, 4, 5, 17), but only one small cluster in the high stress region (#4). I would recommend that we accept the part as-is.  
Thanks,  
David

Approved by:

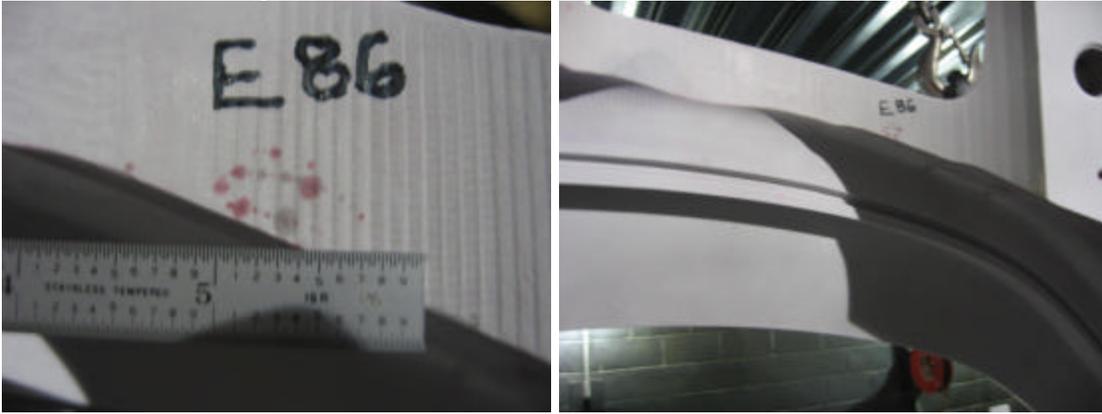
Tech. Rep.

RLM

Major Tool Implemented By: \_\_\_\_\_ Title: \_\_\_\_\_ Date: \_\_\_\_\_

# PT Inspection Results of A2 – NC20044

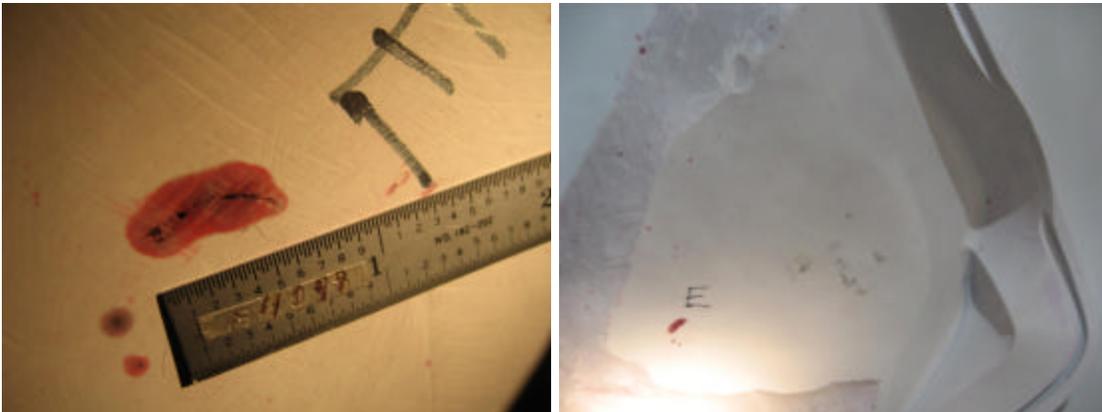
1. Linear cluster, longest is .550". Reference cutout on drawing sheet 5, zone C6.



2. Linear indication, .150" long. Located on E side short leg near hole 78.

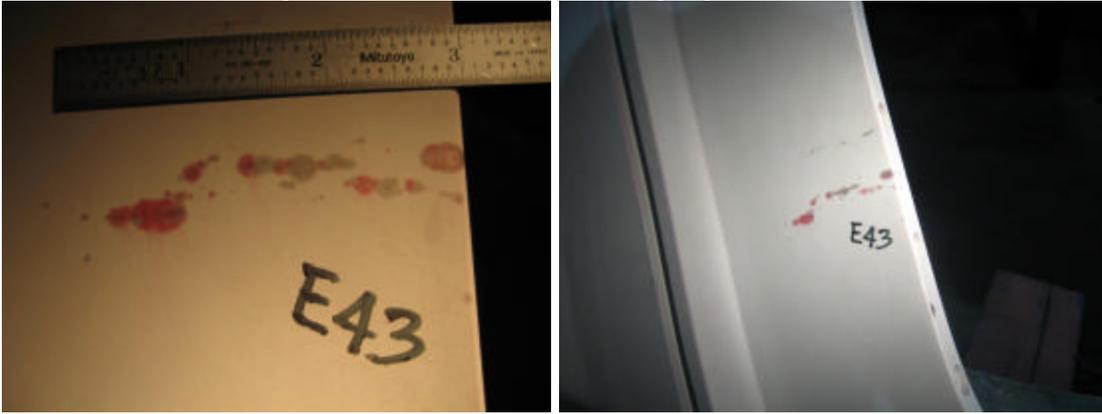


3. .600" long linear located on E side of inner cast wall. This area has been machined due to excess cast stock. Reference sheet 5, zone E5.



## PT Inspection Results of A2 – NC20044

4. Linear cluster, longest is .300". Located on long leg of E side near hole 43.



5. Linear cluster approximately .550" long, located on long leg of E side near hole 28.

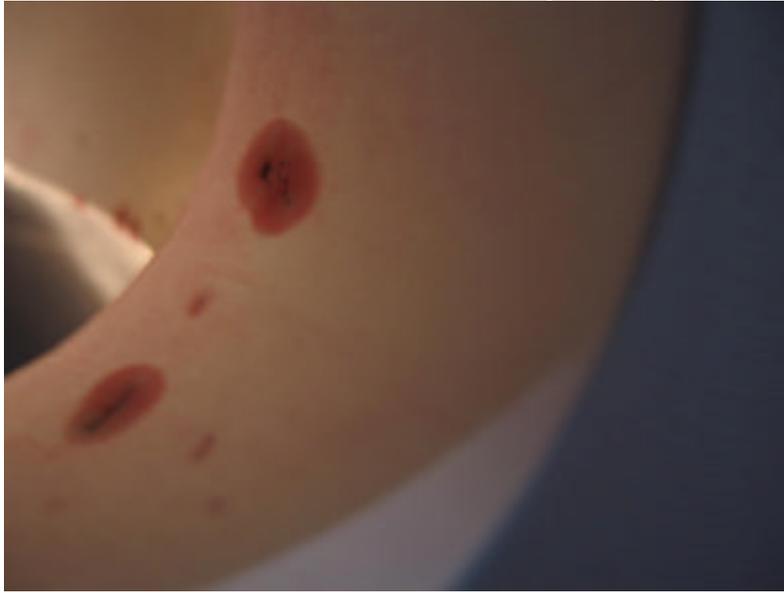


6. .350" linear located in VPI groove near hole 28 on E side.



## PT Inspection Results of A2 – NC20044

7. Linear indications in 1.885 thru hole in datum E flange. Longest is .200”

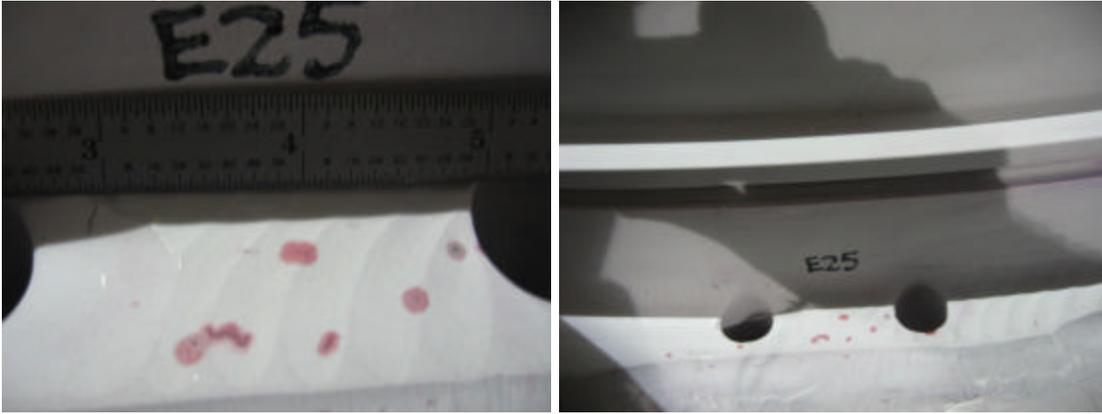


The picture below is a wide view of indications 5, 6 and 7. All of the indications are grouped in the same general area.



## PT Inspection Results of A2 – NC20044

8. .200 long linear indication on E side near hole 25 and between the two 1" holes.



9. .500" long linear indication in the 2.0" diameter hole on D flange near hole 80.



10. .200" long linear on D flange face near hole 80. This picture shows a wide view of indications 9, 10 & 11.



## PT Inspection Results of A2 – NC20044

11. Cluster of indications below VPI groove on D side of casting. Cluster is in area near hole 80. The largest indication is approximately .800" long.



12. The following photos show indications on the outer edge of the D flange (labeled D1 thru D3).

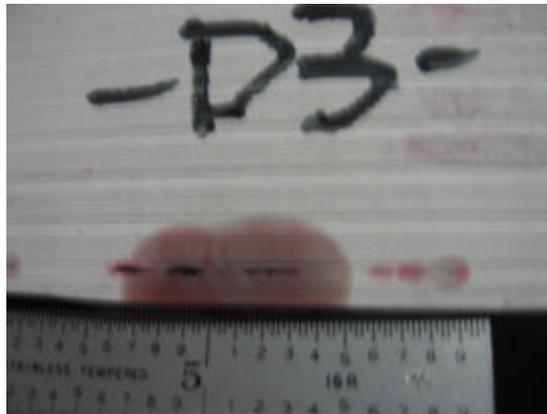
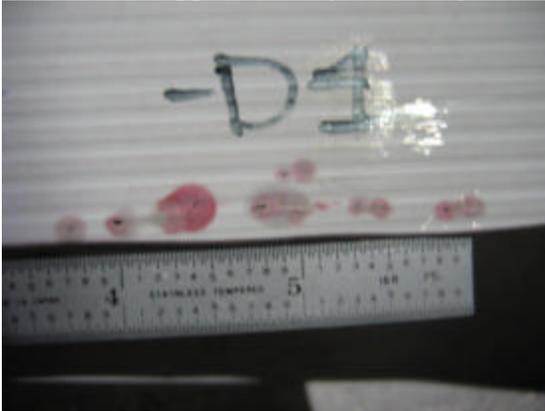


## PT Inspection Results of A2 – NC20044

D1 = linear cluster, longest is .800”.

D2 = rounded indication, .100”.

D3 = linear, approximately 1.3” long.



13. Rounded indication, approximately .150” located in large cut out of D flange near hole 5.

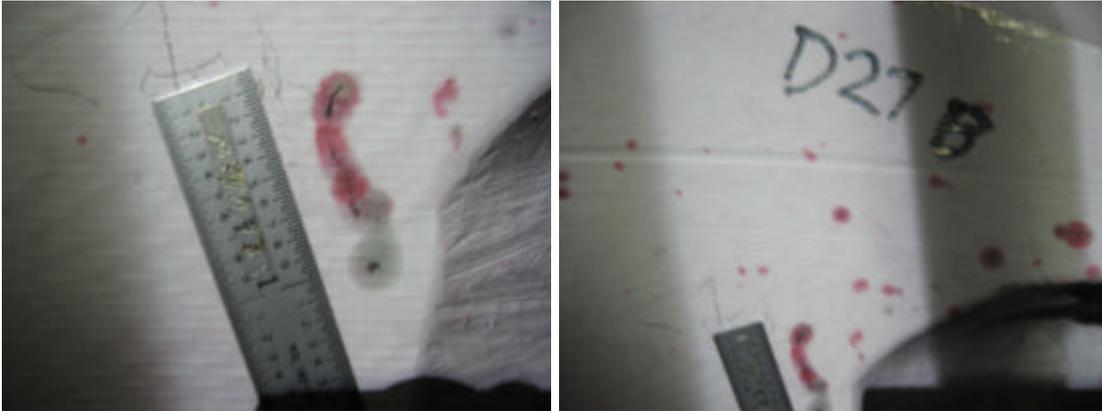


## PT Inspection Results of A2 – NC20044

14. Rounded indication, approximately .125" located in large cut out of D flange near hole 15.



15. Cluster of linear indications in large cut out. Largest is a .600". Reference sheet 4, zone G6.



16. Cluster of linear indications near 2" diameter bore on D flange near hole 27. Picture at the bottom right shows indications for both 15 and 16.



## PT Inspection Results of A2 – NC20044

17. Linear indication approximately .140" long on long leg of T near hole 28 on D side.



A2 PT INDICATIONS

