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

MTM N/C: 21264

Date: 02/28/07
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO
Contact: NANCY HORTON — Telephone: 216-496-2314
E-Mail: NKHFlowen@aol.com — Fax: 216-328-2001

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE — Customer P.O.: S005242-F/Ln:5
Drawing ID: MCWF TYPE-A XRAY MA Revision: 1 — Serial No./Qty: A5
W/O Links: 1-Type:W: 65709/5.0 Sub: 1

Reported By: MIKE GRIFFITH — Telephone: 317-636-6433
E-Mail: mGriffith@MajorTool.com — Fax: 317-634-9420

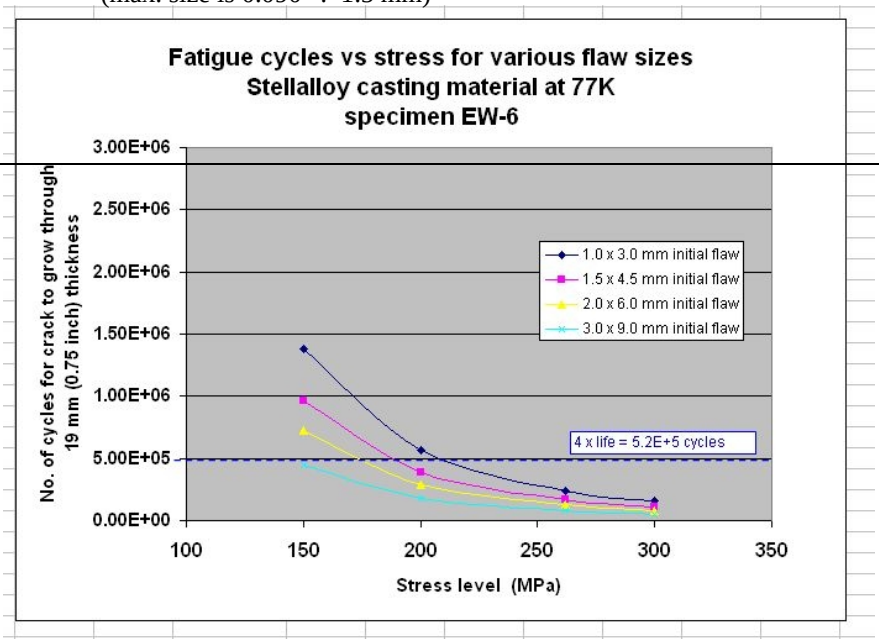
Problem: X RAY FAILURE ON:
"T AREA", VIEW 41-45, POROSITY CLUSTER, LARGEST PORE MEASURES .090", AVERAGE PORE SIZE .060". APPROX. 15 PORES IN A 1 INCH CIRCLE. LOCATED BETWEEN TAPPED HOLE 43 AND 44. STRING OF POROSITY LEADING OFF OF CLUSTER APPROX. 4 INCHES.
(see attachment)

Proposed Disposition:
Submit to Customer for Review.

Number of additional pages: 1 page RT attachment

Customer Disposition: **[X] Use As Is** **[ ] Rework** **[ ] Repair** **[ ] Scrap** **[ ] Replace**

The attached RT indications were reviewed by D. Williamson and discussed during a conference call attended by J. Chrzanowski, L. Sutton, F. Malinowski, L. Dudek, D. Williamson, T. Brown, and P. Heitzenroeder on 2/28/07. Dave notes that the stress in this region varies from 9-20 ksi. (62-138 MPa). As can be seen in the fracture plot, the region will meet the fatigue life criteria with these flaw sizes.(max. size is 0.090" : 1.5 mm)



Approved by:

Phil Heitzenroeder
Digitally signed by Phil Heitzenroeder
DN: cn=Phil Heitzenroeder, c=US, o=PPPL, ou=Mech. Eng. Division
Date: 2007.03.02 12:01:04 -05'00'

Tech. Rep;.

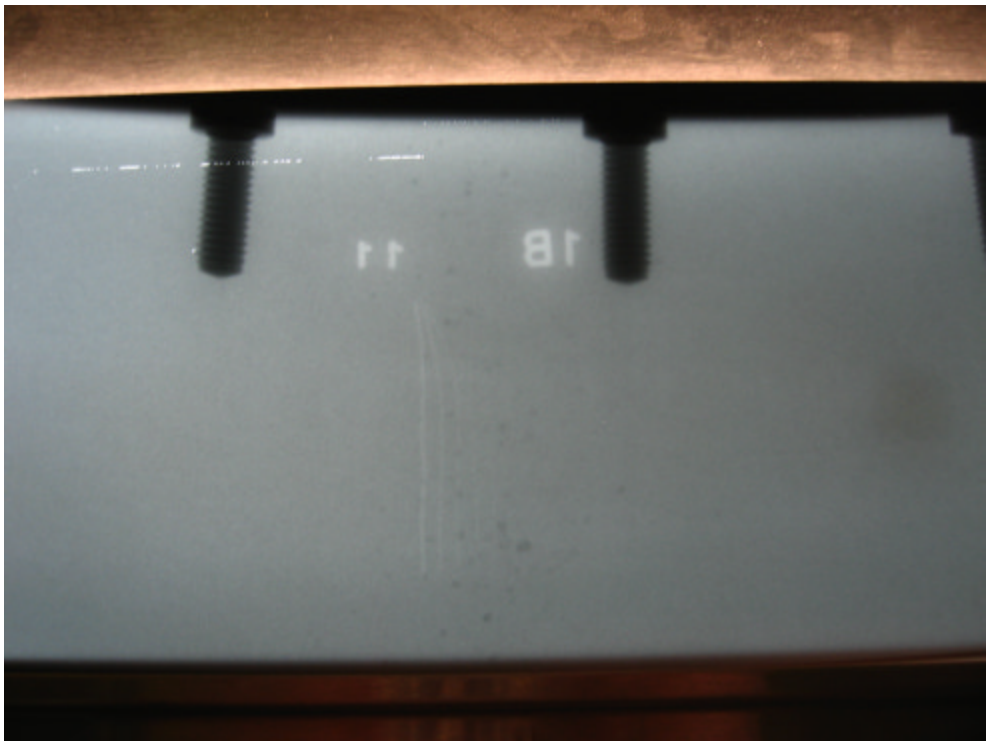
Brad Nelson
Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2007.03.02 12:06:20 -05'00'

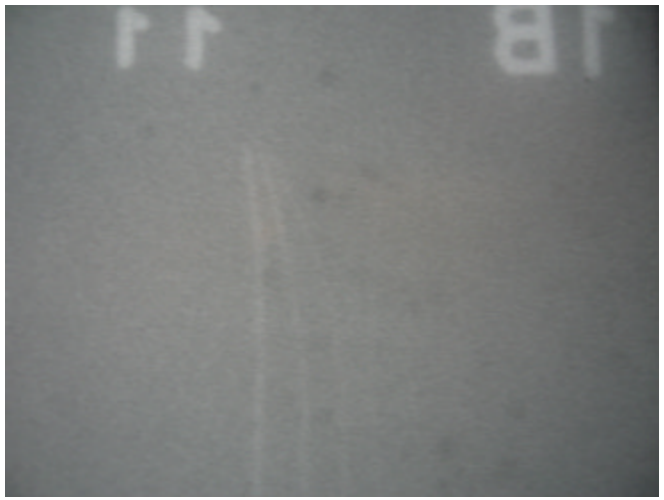
RLM.

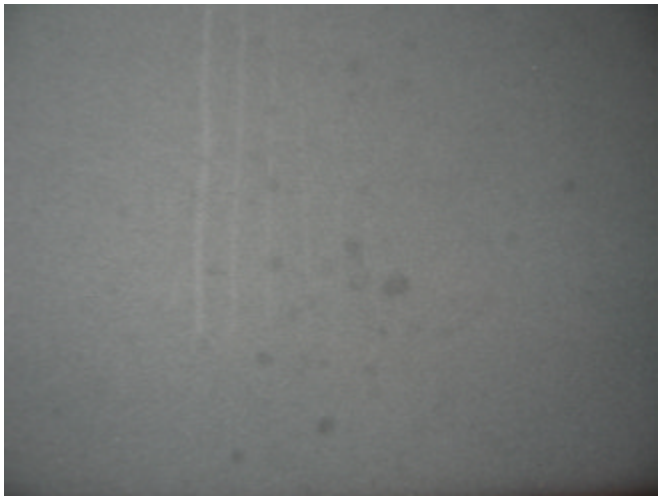
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

n:\mtmapps\Mtnonc14.qrp

NC21264 – RT Rejections







View above is of a cluster of porosity between holes 43 and 44. The largest was sized at approximately .090".

From: Williamson, David E. [williamsonde@ornl.gov]
Sent: Tuesday, February 27, 2007 1:24 PM
To: Phil Heitzenroeder
Subject: RE: A5 PT Rejections - tentative A5 close-out telecon at 2:30 tomorrow

Phil,
My comments are:
Indication #1 - Datum-E, edge of flange, near tee hole #90, very low stress, acceptable
#2 - Datum-E, edge of flange, near tee hole #26, ~4-ksi, acceptable
#3 - Winding side-B, tee hole #80-81, stress=~3-ksi, acceptable
#4 - Winding side-A, base at tee hole #76, stress = ~3-ksi, acceptable
None of the indications occur in the high stress regions, tee hole #41-48, #61-65.
-David

From: Phil Heitzenroeder [mailto:pheitzen@pppl.gov]
Sent: Tuesday, February 27, 2007 10:11 AM
To: Williamson, David E.; Thomas G. Brown
Cc: Lawrence E. Dudek; jchrzanowski@pppl.gov; Larry L. Sutton; fmalinowski@pppl.gov; Nelson, Brad E.; hneilson@pppl.gov
Subject: FW: A5 PT Rejections - tentative A5 close-out telecon at 2:30 tomorrow

David,
Would you please review and comment? MTM expects to submit the A5 inspection data today and is asking If we can have the "close out" telcon at 2:30 tomorrow. Thanks
Phil

Is 2:30 tomorrow OK for everyone?

From: Griffith, Mike [mailto:MGriffith@majortool.com]
Sent: Monday, February 26, 2007 4:04 PM
To: NKHFlowen@aol.com; royjratc-aol-com-offsite; pdjord@sbcglobal.net
Cc: bob.skelly@dcma.mil
Subject: A5 PT Rejections

A5 inspection revealed very few rejectable indications. See attached.

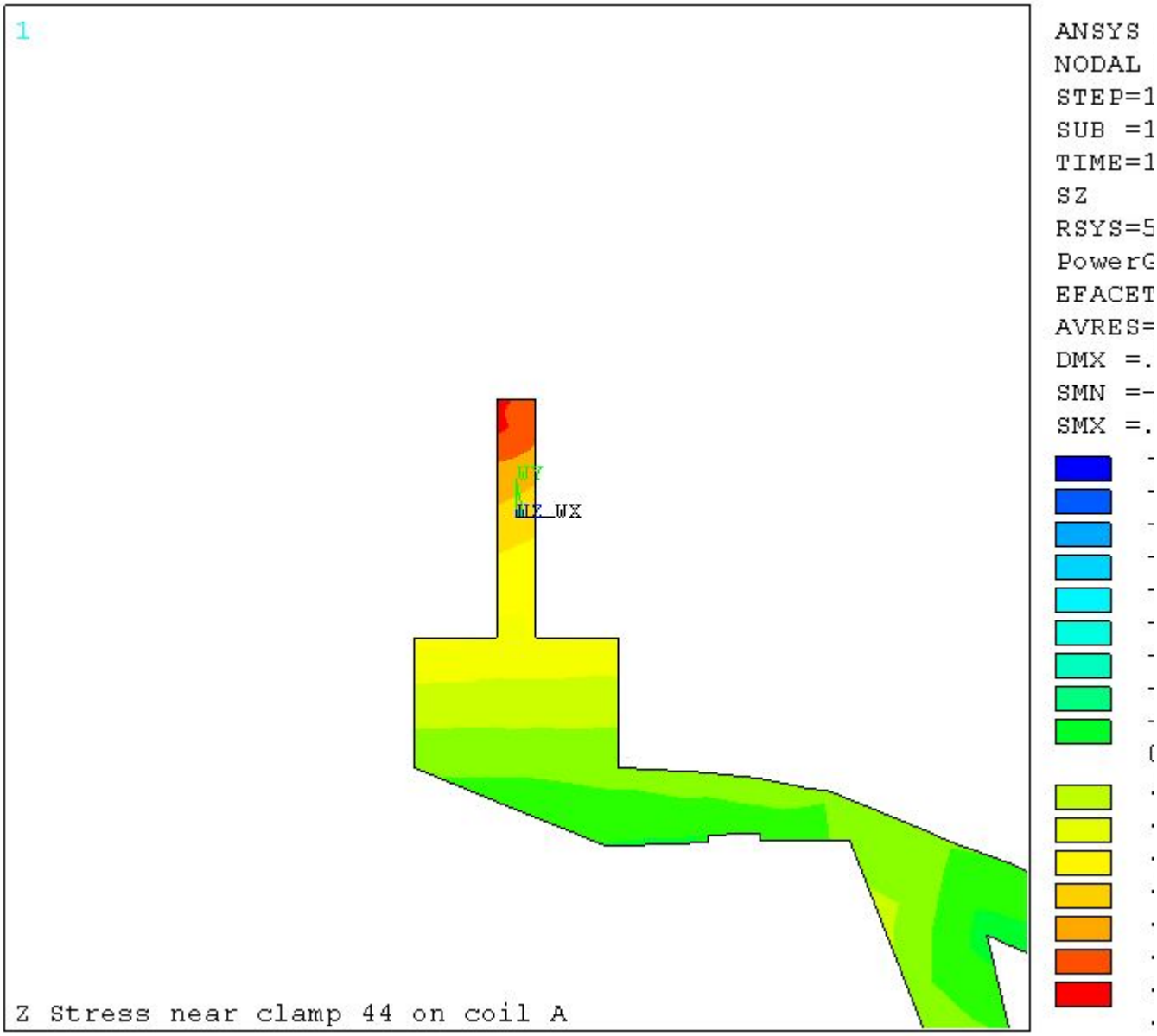
Mike Griffith

Major Tool and Machine, Inc
Quality Control Manager
Tel: (317) 917-2612
Email: mgriffith@majortool.com

Phil Heitzenroeder

From: Williamson, David E. [williamsonde@ornl.gov]
Sent: Wednesday, February 28, 2007 1:23 PM
To: Phil Heitzenroeder; Frank A. Malinowski
Subject: RE: RT failure on A5

Phil, Frank,
The stress in the web varies from 9-20 ksi through the septum at hole #44.



From: Griffith, Mike [mailto:MGriffith@majortool.com]
Sent: Wednesday, February 28, 2007 12:12 PM
To: NKHFlowen@aol.com; RoyJRATC@aol.com; pdjord@sbcglobal.net
Cc: Phil Heitzenroeder; lsutton@pppl.gov; Larry Dudek; Williamson, David E.
Subject: RT failure on A5

Mike Griffith
Major Tool and Machine, Inc
Quality Control Manager
Tel: (317) 917-2612
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