

Customer: ENERGY INDUSTRIES OF OHIO

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Part: /
Drawing ID: SE141-116

Revision: 6

Customer P.O.: S005242-F/Ln:3
Serial No./Qty:

Reported By: KEVIN BOWLING
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Problem: Casting defect uncovered during machining (see attached pictures).

The defect was detected visually during machining and confirmed using Liquid Penetrant Inspection. The size of the indication is about 1.5" long by approximately .5" wide from the base of the T in both directions (defect is on the corner). It appears that it will be in the area where we will be cutting the VPI groove. Reference sheet 4 of SE141-116 for specific location on the casting. The indication is directly below the hole located at 20.52 and 86.10 (zone F5).

After complete excavation of the defect the affected area is now approximately 1.600" long by .500" across the face of the base section and .200" in depth along the edge. (see pictures). Confirmation of defect removal was accomplished using Liquid Penetrant Inspection.

Recommend weld repair of defective area and LPI after repair rather than LPI and radiographic inspection.

Proposed Disposition:

Number of additional pages: 3

Customer Disposition: Use As Is Rework Repair Scrap Replace

Agree with recommended disposition to weld repair and LPI after repair in lieu of LPI and RPI since this is not a high stress region.

Technical Contact Approval: Phil
Heitzenroeder

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US,
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Eng. Mgr. Approval: Brad
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Major Tool Implemented By: Mike
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defined by the placement of my
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Date: 2006.03.29 13:34:02 -05'00'