

PPPL NONCONFORMANCE REPORT NO: 3754 Open Date 03/31/08

Status 2 --Disposition Needed 9-Closed Trend 07-Out Of Tolerance
Department NCSX Division Construction
Source/Org Fab, Ops and Maint
Item Dwg/Part# SE140-046 Procurement # D-NCSX-FPA-002
Cost Center WBS/Other WBS 185
RAP# 3317 Job Doc # D-NCSX-FPA-002 Vendor _____
RAP Title Field Period Assembly Station Two
☐ HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

The welds for the 1/4" support rod to A1-B1 joint shims listed below have magnetic permeability $>1.3 <1.4\mu$. Dwg #SE140-046, Note 4, requires permeability not exceeding 1.02 μ . There are two welds per shim, flare bevel groove welds 1/8" x 1/4" long. Shim Nos. E4, E4-1, E4-2, E14, E14-1, E15, E16, E16-1, E17, E18, E18-1, E19, E24, E-24-1, E24-2, and E25.

Lot Size Recd 0 Sample Size Insp 0 ☐ Lot Rejected # Rejected 0
Reported By Boscoe J Validated By Malsbury J Validated Date 04/01/08

DistributionCog M. ViolaInsp J. Boscoe

Proj. Doc Control (when closed)

QC Files

Malsbury J

Boscoe J

J. Edwards L. Dudek Ellis R Brooks A Williams M Chrzanowski J

Heitzenroeder P Tyrrell M Simmons R

Disposition: Rework___ Repair___ Use As Is X Return to Vendor___ Scrap___

Per A. Brooks 4/2 email to M. Viola, "This sounds like the issue we spoke about. This is acceptable as is based on similar arguments made for NCR 3753 (see below)."

A. Brooks email to M. Viola dated 3/28/08, "Based on some earlier investigations anticipating the weld permeability may be high (see email to Phil appended), the NCR 3753 is acceptable as-is. We found we could tolerate permeability throughout the weld as high as 1.2 without exceeding our single incidence goal to limit field errors to 0.1 G at the plasma. For isolated regions (<10% of volume) we could tolerate permeability as high as 2.0 while meeting that goal."

For rework or repair of vendor supplied equipment, fill in information below:

Hours _____ \$ Est Labor _____ \$ G&A _____
 \$ Material _____ \$ Burden _____ \$ Total _____

Disposition by

Mike Viola 4/3/08

Supervisor's Concurrence

[Signature] 4/3/08

Eng. Dept. Head Concurrence

[Signature] 4/3/08

Other (i.e., WCO/FPE) Concurrence

N/A

PQA/QC Mgr Disposition Concurrence

John E. Boscoe 4-4-08

QA Field Verification by

N/A (LY 4/4/08)