

Status	9 - Closed NCR		Trend		
Department	NCSX		Division	WBS 121	
Source/Org	FABRICATION, OPERATIONS & MAINTENANCE				
Item Dwg/Part#	SE121-009 R0	Procurement #	D-NCSX-FPA-001	Cost Center	
RAP#	3268	Job Doc #	D-NCSX-FPA-001	Vendor	
RAP Title	Field Period Assembly Station One				
<input type="checkbox"/> HoldTag Applied					

Nonconforming Condition (include requirement(s) violated):

VVSA #1 - the following welds exceed allowable magnetic permeability of 1.02 mu per C-SPEC 185-01-00, Sect. 3.2.1.4.6. These welds are where the Cooling Manifold Inner and Outer Headers join the Cryostat Interface Flange Bellows (Sect. B-B on drawing) Part Nos. 3, 4, 5, and 6. Magnetic permeability ranges from 1.08 to isolated spots 1.2 mu. Welds are 1/16" fillet by 1.66" O.D. It is expected welds for VVSA #2 and 3 will be in the same range. When dispositioning thisN CR, please consider applying to all three vessel segments.

Lot Size Recd	0	Sample Size Insp	0	<input type="checkbox"/> Lot Rejected	# Rejected	0
Reported By	Boscoe J	Validated By	Phelps C	Validated Date	12/22/06	

Disposition: Rework*__ Repair*__ Use As Is*__ Return To Vendor*__ Scrap*__ Use As Is

From: Arthur W. Brooks
 Sent: Wednesday, January 03, 2007 9:03 AM
 To: Michael E. Viola
 Subject: RE: New NCR 3691

Mike,
 The welds are acceptable. They are located near the port 12 flange which we have already accepted at 1.2 and the amount of material involved is orders of magnitude less.
 Art

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

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

Disposition By	Viola M	Date	01/05/07
Supervisor's Concur	Dudek L	Date	01/09/07
Eng. Dept. Head Concur	Williams M	Date	01/09/07
WCO/Other	N/A	Date	_____
PQA/QC Mgr Dispos Concur	Boscoe J	Date	01/11/07
QC Field Verification By	N/A	Date	_____

- Distribution**
- Cog** M. Viola
 - Insp** Boscoe/Phelps
 - Proj. Doc Control (when closed)
 - QC Files
 - Malsbury J
 - Boscoe J
 - J. Edwards
 - L. Dudek
 - Reiersen W
 - Williams M
 - Tyrrell M
 - Phelps C
 - Malinowski F
 - Malsbury J