

**Status** ~~2~~ Disposition Needed **Trend** 07-Out Of Tolerance  
**Department** NCSX **Division** WBS 121  
**Source/Org** FABRICATION, OPERATIONS & MAINTENANCE  
**Item Dwg/Part#** SE121-009 r0 w/ ECN 5152 **Procurement #** D-NCSX-FPA-001 **Cost Center** \_\_\_\_\_  
**RAP#** 3268 **Job Doc #** D-NCSX-FPA-001 **Vendor** \_\_\_\_\_  
**RAP Title** Field Period Assembly Station One

HoldTag Applied

**Nonconforming Condition (include requirement(s) violated):**

VVSA-1, 2, 3 - The vacuum vessel heating /cooling supply line to coolant tube welds (orbital GTAW welds) exhibit a magnetic permeability range of greater than 1.03 Mu to less than 1.10 Mu which is above the maximum of 1.02 Mu allowed by paragraph 3.2.1.4.6 of NCSX-CSPEC-185-01-00. At the time of this writing VVSA-3 has not been welded yet but is anticipated to be similar to that of VVSA-1 & 2. When dispositioning this NCR consider this condition to affect all three VVSA sections.

Each weld is 1 in. long by 3/16 in. wide by 0.035 in. thick and there are 128 welds per vessel segment. The welds are located approximately 1 ft. away from where port 12 interfaces the vessel.

**Lot Size Recd** 0 **Sample Size Insp** 0  Lot Rejected **# Rejected** 0  
**Reported By** Phelps C **Validated By** Boscoe J **Validated Date** 06/19/07

~~Disposition: Rework\* \_\_\_ Repair\* \_\_\_ Use As Is\* \_\_\_ Return To Vendor\* \_\_\_ Scrap\* \_\_\_~~

*Please use p. 2 for disposition and approvals .*

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

<del>#Hours</del> _____	<del>\$Est Labor</del> _____	<del>\$G&amp;A</del> _____	
<del>\$Material</del> _____	<del>\$Burden</del> _____	<del>\$Total</del> _____	

<del>Disposition By</del> _____	<del>Date</del> _____
<del>Supervisor's Concur</del> _____	<del>Date</del> _____
<del>Eng. Dept. Head Concur</del> _____	<del>Date</del> _____
<del>WCO/Other</del> _____	<del>Date</del> _____
<del>PQA/QC Mgr Dispos Concur</del> _____	<del>Date</del> _____
<del>QC Field Verification By</del> _____	<del>Date</del> _____

**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

Disposition: Rework\_\_\_ Repair \_\_\_ Use As Is\_\_\_ Return to Vendor\_\_\_ Scrap\_\_\_

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

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

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Disposition by \_\_\_\_\_

~~Supervisor's Concurrence~~ \_\_\_\_\_

Eng. Dept. Head Concurrence \_\_\_\_\_

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

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PQA/QC Mgr Disposition Concurrence \_\_\_\_\_

QA Field Verification by \_\_\_\_\_