

Disposition of NCR 19269 March 3, 2006

All of the indications were reviewed during a conference call on February 27 with EIO, PPPL, and ORNL. This review accepted all “**as is**” with the exception of a few areas for which we requested radiographic examination (reference NCR 19290 and 19291). Following the radiography these also were accepted “**as is**”. Consequently, this NCR can now be considered closed.

Approved by:

Technical representative

Responsible line manager

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
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Telephone: 216-496-2314
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Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116

Revision: 8

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: C3

Reported By: MIKE GRIFFITH

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Problem: 15 areas of cluster indications (shrink, cold shuts, non-metallic inclusions) on finished machined surfaces. linear indications range from .062" to 1.200" in length (actual discontinuity size), many rounded "indications" exceeding the spec. requirements for level 1 surfaces. In addition, approx. 60 random single indications on level I & II surfaces. See field notes and photos for more details.

Proposed Disposition:

SUBMIT TO CUSTOMER CONTINUE PROCESSING.

Number of additional pages: _____

Customer Disposition: Use As Is Rework Repair Scrap Replace

Technical Contact Approval: _____

Title: _____

Date: _____

Buyer Approval: _____

Title: _____

Date: _____

Major Tool Implemented By: _____

Title: _____

Date: _____

C3 Liquid Penetrant Inspection Map of Indications

Area #1

Linear indications (size of discontinuity not bleed-out)
.080" to .500"

14 random rounded indications (size of bleed-out 30min dwell time)
>.125" inspected with pin gage
estimated 50% of rounds would not be rejected based on the size of the discontinuity



C3 Liquid Penetrant Inspection Map of Indications

Area #2

Linear indications (size of discontinuity not bleed-out)
.085" to .200"

15 random rounded indications (size of bleed-out 30 min dwell time)
>.125" inspected with pin gage
estimated 50% of rounds would not be rejected based on the size of the discontinuity



C3 Liquid Penetrant Inspection Map of Indications

Area #3

Linear indications (size of discontinuity not bleed-out)
.200" to .600"

17 random rounded indications (size of bleed-out 30min dwell time)
>.125" inspected with pin gage
estimated 50% of rounds would not be rejected based on the size of the discontinuity



C3 Liquid Penetrant Inspection Map of Indications

Area #4

Linear indications (size of discontinuity not bleed-out)
.100" to .400"

29 random rounded indications (size of bleed-out 30min dwell time)
>.125" inspected with pin gage
estimated 50% of rounds would not be rejected based on the size of the discontinuity



C3 Liquid Penetrant Inspection Map of Indications

Area #5

Linear indications (size of discontinuity not bleed-out)

>3.00" non-metallic inclusion (size of bleed out 30min dwell time)



C3 Liquid Penetrant Inspection Map of Indications

Area #6

Linear indications (size of discontinuity not bleed-out)
.075" to .700"

12 random rounded indications (size of bleed-out 30min dwell time)
>.125" inspected with pin gage
estimated 50% of rounds would not be rejected based on the size of the discontinuity



C3 Liquid Penetrant Inspection Map of Indications

Area #7

Linear indications (size of discontinuity not bleed-out)
.200" to .500"



C3 Liquid Penetrant Inspection Map of Indications

Area #8

Shrink, inclusion pocket, unable to determine individual size
bleed-out ranges from .200" to 1.25"



C3 Liquid Penetrant Inspection Map of Indications

Area #9a

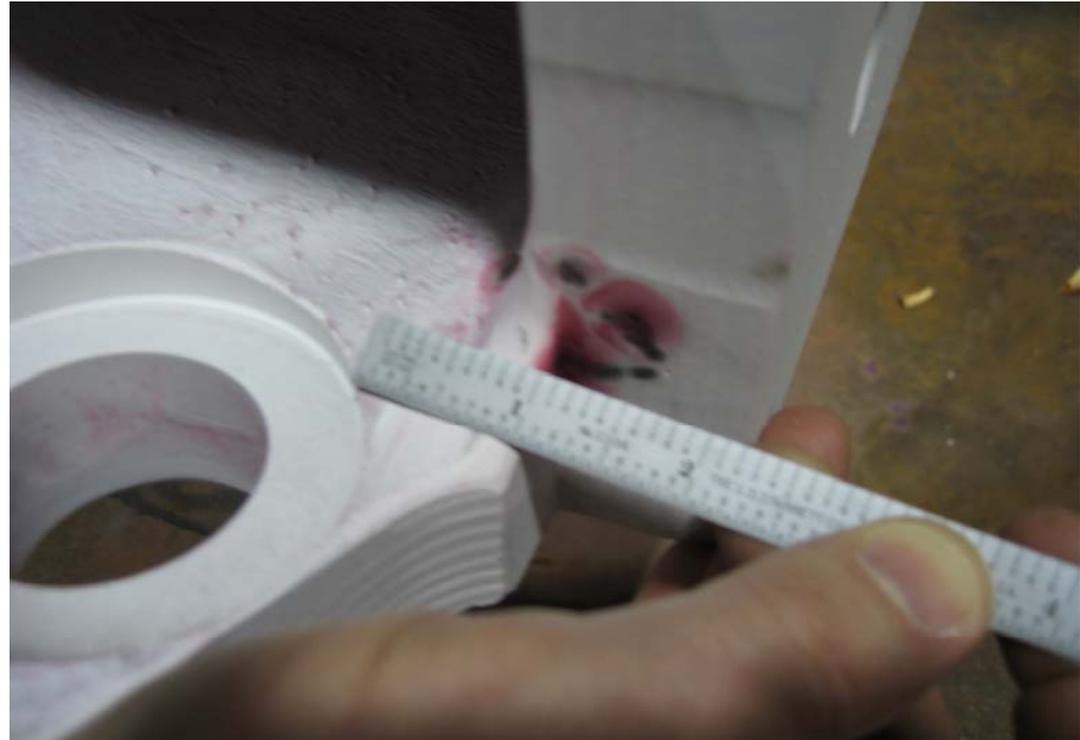
Linear indications (size of discontinuity not bleed-out)
.300" to .450"



C3 Liquid Penetrant Inspection Map of Indications

Area #9b

Large defect passes through from machined surface to non-machined surface



C3 Liquid Penetrant Inspection Map of Indications

Area #10

Shrink pocket .600" x .700"



C3 Liquid Penetrant Inspection Map of Indications

Area #11

Linear indications (size of discontinuity not bleed-out)
.400" to 1.200"



C3 Liquid Penetrant Inspection Map of Indications

Area #12

Linear indications (size of discontinuity not bleed-out)
.100" to .800"



C3 Liquid Penetrant Inspection Map of Indications

Area #13

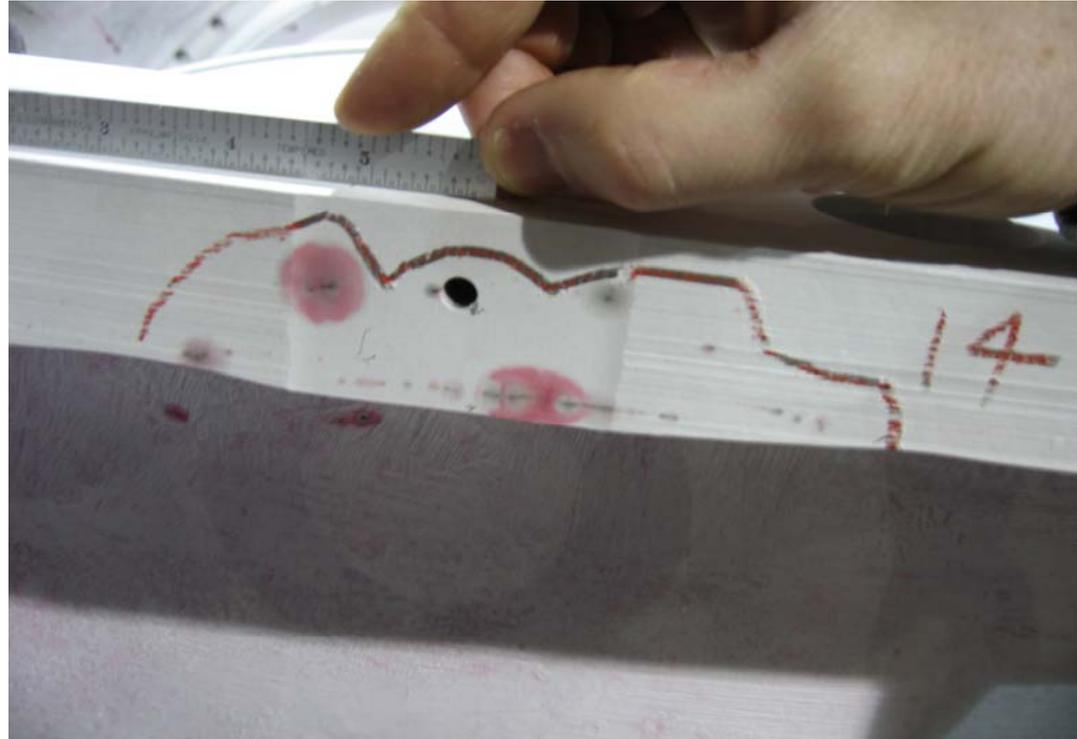
Linear indications (size of discontinuity not bleed-out)
.200" to .350"



C3 Liquid Penetrant Inspection Map of Indications

Area #14

Linear indications (size of discontinuity not bleed-out)
.100" to 1.250"



C3 Liquid Penetrant Inspection Map of Indications

Area #15

Linear indications (size of discontinuity not bleed-out)
.100" to .300"



C3 Liquid Penetrant Inspection Map of Indications

Area #16

Linear indications (size of discontinuity not bleed-out)
.100" to .250"

