



Corrective Action 1379
Carondelet Division - CA / PA / RGA Database
Corrective Action Type NCR
Date 8/31/2005
CA Originator C. Ruud
Applies to: Weld Material Lincoln 3018926-78309

A1 coil

Description of Defect / Non-Conformance

Material failed elongation and one of three charpy impact tests at -320 F. The average of the specimens exceeds the minimum. See S8 of ASTM A 703/A 703M.

Root Cause

The sample of the weld contained defects not detected.

Corrective Action

Retest material already at Lab.

If needed, make a new weld plate after reviewing process with welder and weld another sample.

Verification of Corrective Action

Retest results. If new plates are needed, the new plate will be x-rayed prior to testing.

Estimated Completion Date

9-2-05

Actual Completion Date TBD

Signed: C. Ruud

A handwritten signature in black ink, appearing to be "C. Ruud".

CC: R. Suria, Barry Craig, Joe Edwards, E.J. Kubick

Frank A. Malinowski

From: Charles.Ruud@MetalTekInt.Com
Sent: Thursday, September 15, 2005 12:51 PM
To: djord@earthlink.net
Cc: royjratc-aol-com-offsite; NKHFlowen@aol.com; Joe.Edwards@metaltekint.com; Rick.Suria@metaltekint.com
Subject: Weld Material Test Report
Attachments: Lincoln 3018926-78309 cryo results.pdf

Attached is the report from Westmoreland on the Lincoln material lot 3018926-78309.

It has passed all tests.

Please call if there are any questions.

Chuck Ruud

Quality Manager

MetalTek International

Carondelet Division

cruud@metaltekint.com

636-475-2199

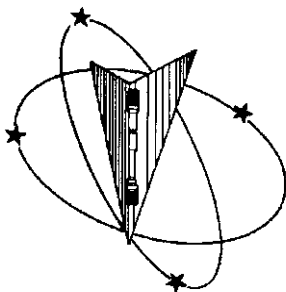
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No virus found in this outgoing message.

Checked by AVG Anti-Virus.

Version: 7.0.344 / Virus Database: 267.11.0/103 - Release Date: 9/15/2005

9/29/2005



September 13, 2005

MetaTek International
The Carondelet Division
8600 Commercial Blvd.
I-55 Industrial Park
Pevely, MO 63070-1528

Attention: Jim Galaske

Subject: All processes, performed upon the material as received, were conducted at WMT&R, Inc. in accordance with the WMT&R Quality Assurance Manual, Rev. 9, dated 4/1/2000.
The following tests were performed on this order: IMPACT and TENSILE

IMPACT RESULTS: ASTM E23-02

REQUIREMENTS: Energy (Min 35Max ---)

MATERIAL: Lincoln LNM4455

SAMPLE TYPE: Charpy V-Notch

Reference	Lot No. Batch No. Specimen ID	Test Log Number	Sample Size	Temp. °F	Energy ft-lbs	Mils Lat Exp	% Shear Fracture	AIUR
Lincoln LNM4455	3018926 78309 Cvn-1	C43939	Standard	-320	56	18	40	Acceptable
Lincoln LNM4455	3018926 78309 Cvn-2	C43940	Standard	-320	52	18	40	Acceptable
Lincoln LNM4455	3018926 78309 Cvn-3	C43941	Standard	-320	53	12	40	Acceptable

DISPOSITION: Acceptable

Requirements supplied by MetaTek International.

Westmoreland Mechanical Testing & Research, Inc.

P.O. Box 388

Westmoreland Drive

Youngstown, Pa. 15696-0388 U.S.A.

Telephone: 724-537-3131

Fax: 724-537-3151

Website: www.wmtr.com

WMT&R is a technical leader in the material testing industry.

CERTIFICATION

621-01 & 621-02



Accredited
Matcap
Materials Testing Laboratory

WMT&R Report No. 5-34328
P.O. No. 19386 Rel No.18
Requisition No. 4934

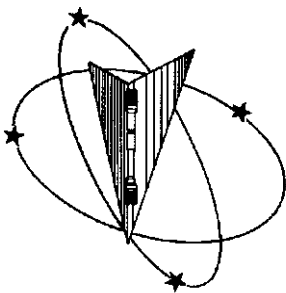
KNOWINGLY OR WILLFULLY FALSIFYING OR CONCEALING A MATERIAL FACT ON THIS FORM
OR MAKING FALSE, FICTITIOUS OR FALSOUS STATEMENTS OR REPRESENTATIONS
HEREIN COULD CONSTITUTE A FELONY PUNISHABLE UNDER FEDERAL
STATUTES. THIS CERTIFICATE OR REPORT SHALL NOT BE REPRODUCED
EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF WMT&R, INC.

Matthew Wojcik
Roy E. Stark
Technical Services Manager

September 13, 2005

9-13-05

Testing Specialists for Aerospace, Automotive, and Material Testing Fields
Locations in Youngstown, PA U.S.A. ~ Tel. (724) 537-3131 and
Banbury U.K. ~ Tel. +44 (0) 1295 261211



Westmoreland Mechanical Testing & Research, Inc.
P.O. Box 388
Westmoreland Drive
Youngstown, Pa. 15696-0388 U.S.A.

Telephone: 724-537-3131 Fax: 724-537-3151
Website: www.wmtr.com

WMTR is a technical leader in the material testing industry.

September 13, 2005

CERTIFICATION

MetaTek International
The Carondelet Division
8600 Commercial Blvd.
1-55 Industrial Park
Pevely, MO 63070-1528

Attention: Jim Galaske

Subject: All processes, performed upon the material as received, were conducted at WMTR, Inc. in accordance with the WMTR Quality Assurance Manual, Rev. 9, dated 4/1/2000.
The following tests were performed on this order: IMPACT and TENSILE

TENSILE RESULTS: ASTM E21-03a

Requirements: UTS ksi (Min 95Max ---) 0.2% YS ksi (Min 72Max ---) 4D Elong. % (Min 32Max ---) Modulus Msi (Min 21Max ---)

SOAK TIME: 5 Minutes

SPEED OF TESTING: 0.0030 in./in./min., 0.0500 in./min./in.

MATERIAL: 316 S/S

DISPOSITION: Acceptable

Reference	Lot No. Batch	Test Log No. Specimen ID	Temp. °F	UTS ksi	0.2% YS ksi	Elong %	RA %	Modulus Msi	Ult. Load lbf	0.2% YLD. lbf
Lincoln LNM4455	3018926 78309 Tensile	C43938	-320	182.1	128.2	34	24	27.0	17560	12360

AUUR: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

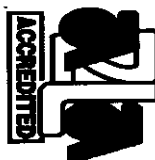
DISPOSITION: Acceptable

Reference	Lot No. Batch	Test Log No. Specimen ID	Orig. Dia. (in.)	Final Dia. (in.)	4D Orig GL (in.)	4D Final GL (in.)	Orig. Area (sq. in.)	Machine Number	AUUR
Lincoln LNM4455	3018926 78309 Tensile	C43938	0.3504	0.3048	1.40	1.87	0.09643131	M9	A

AUUR: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

Requirements supplied by MetaTek International.

621-01 & 621-02



WMTR Report No. 5-34328
P.O. No. 19386 Rel No. 18
Requisition No. 4934

Robert E. Starman
Robert E. Starman
Technical Services Manager

9-13-05
September 13, 2005

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