

**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**

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**Customer: ENERGY INDUSTRIES OF OHIO**

Contact: NANCY HORTON  
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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.

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**Proposed Disposition:**

SUBMIT TO CUSTOMER CONTINUE PROCESSING.

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Number of additional pages: \_\_\_\_\_

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**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

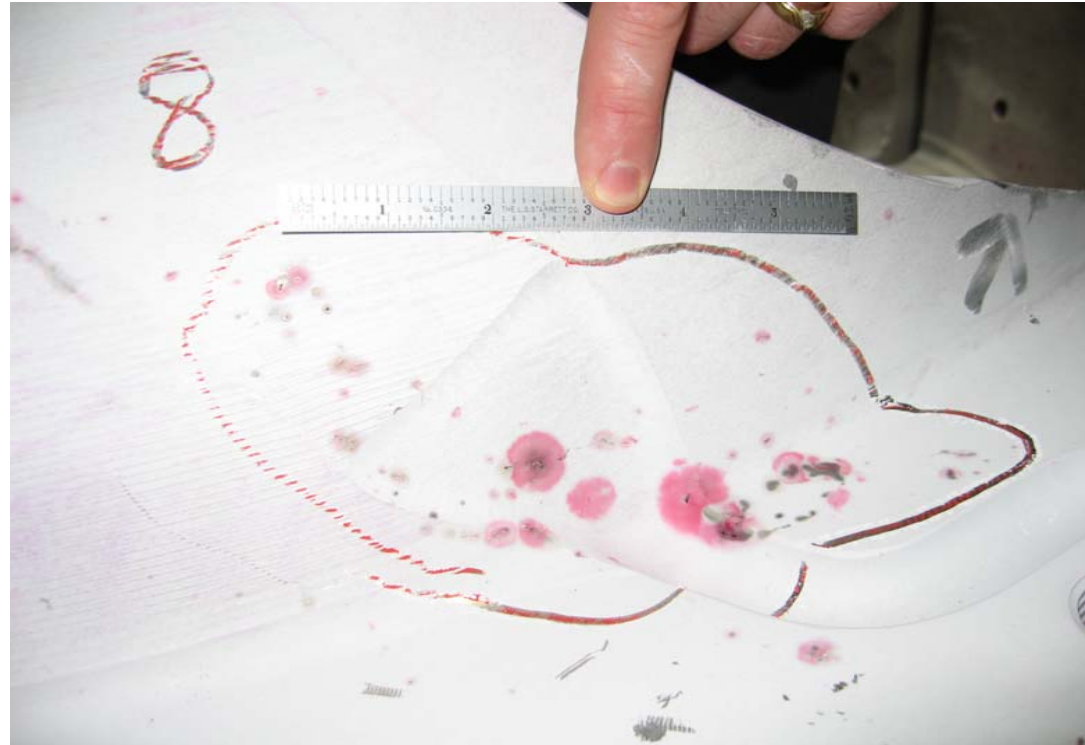
Linear indications (size of discontinuity not bleed-out)  
.200" to .500"



## 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"

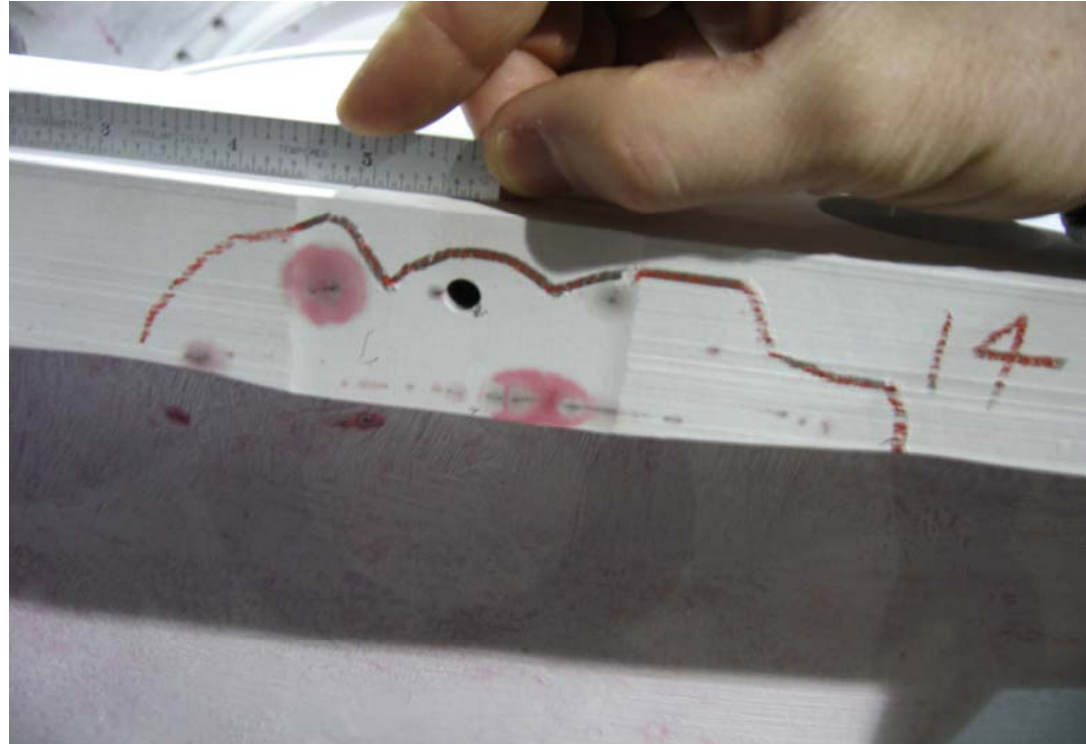




## C3 Liquid Penetrant Inspection Map of Indications

### 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"

