

**Customer: ENERGY INDUSTRIES OF OHIO**

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 E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314  
 Fax: 216-328-2001

**Part: SE141-103-1 / MOD COIL WINDING FORM ASSEMBLY**

Drawing ID: MCWF TYPE-C XRAY MA Revision:

Customer P.O.: S005242-F/Ln:5  
 Serial No./Qty: C5

Reported By: MIKE GRIFFITH  
 E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433  
 Fax: 317-634-9420

Problem: The radiographic inspection performed on the "T" Section revealed eight (8) entrapped, gas-type discontinuities in film location 0-1.

An "overlay film" was made to represent the location of the indications as they could be found within the casting material.

See attachments:  
 Reader Sheet  
 RT Map  
 Photos of overlay

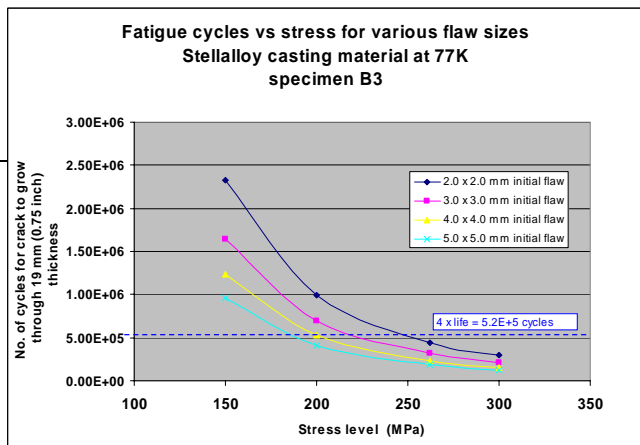
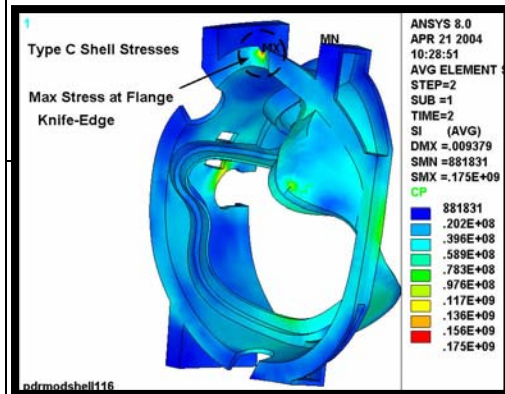
**Proposed Disposition:**

Propose to Use As Is.

Number of additional pages: 5

**Customer Disposition:**     Use As Is     Rework     Repair     Scrap     Replace

The attached Reader Sheet indicates that the (8) rejectable discontinuities are 0.090-0.110" (2.25-2.75 mm) in diameter. They are located roughly between holes 45 and 50. Since the stress in this region is <100 MPa, the discontinuities can be accepted "as is".



Accepted by:

Tech. Rep.

RLM

Major Tool Implemented By: \_\_\_\_\_

Title: \_\_\_\_\_

Date: \_\_\_\_\_

4959

10520 Chester Road  
Woodlawn, Ohio 45215

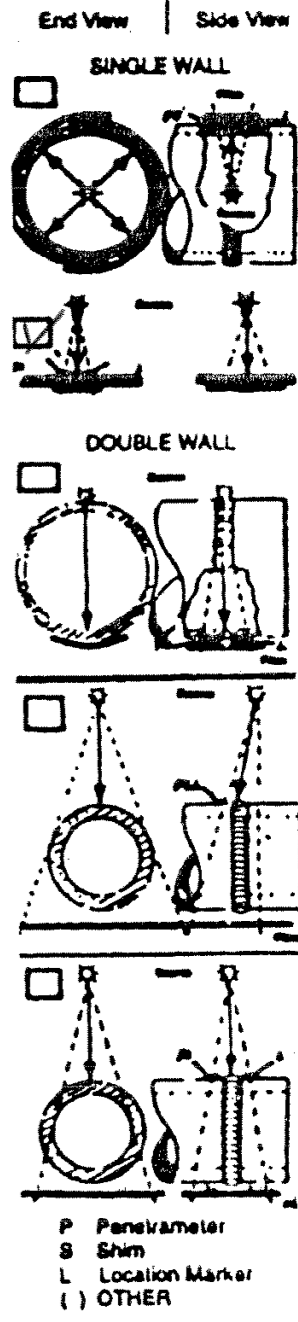


CLIENT Major Tool + Machine			INTERPRETER/LEVEL Robert Weaver II			RADIOGRAPHER Robert Weaver		JOB NO 13860001		P.O. NO N/A		DATE 4/13/06	
ISOTOPE/X-RAY IR192	DIA. X LEN/KV .118"x.089"	CURIES/MA 45	FOCAL SPOT SIZE .148"	SFD 18"	SOD 17.25"	TIME	FILM PROCESSING Auto	FILM TYPE Kodak AA	FILM TECHNIQUE Double	PB SCREENS .010"			
WELD PROCESS N/A		MATERIAL SPEC. 316 SST		MATERIAL DIAMETER N/A	MATERIAL THICKNESS .75"	PENETRATOR ASTM IB	SHIM N/A	ACCEPTANCE STANDARD No indications >.080"					

DESCRIPTION  
65707/5.0/1/110/818  
SE141-116 rev.8  
page 1 of 2

REMARKS  
Densitometer - 12105  
cal due - 5/2/06  
8 spots .090"-.110" diameter / MTM ref. #19607 NCR

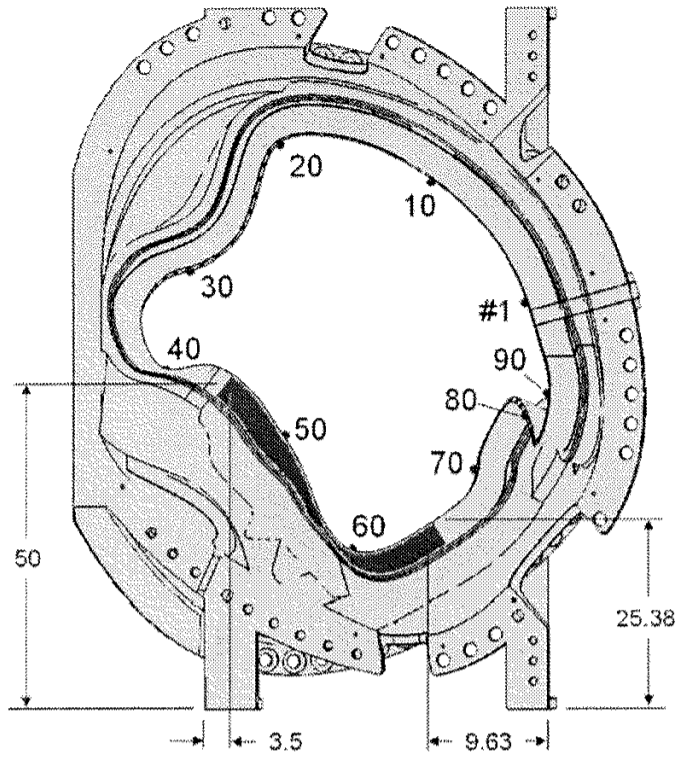
FITTING, SEAM OR FITTING	FILM INTERVAL NUMBER	WELDER IDENTIFICATION	PENETRATOR		SLAG	POROSITY	POROSITY WITH TAIL	CRACK	LACK OF PEN	LACK FUSION	INTERNAL CONVEXITY	INTERNAL CONCAVITY	TUNGSTEN	MELT-THROUGH	BURN-THROUGH	CRATER-PIT	OXIDATION	INTERNAL UNDERCUT	EXTERNAL UNDERCUT	ALIGNED INDICATIONS	WELD CONTOUR	MIS-MATCH	FILM ARTIFACT	VISUAL CONCERNS	FILM DENSITY	SEE REMARKS	ACCEPT	REJECT
			SIZE	QUALITY LEVEL																								
T-area	0-1	N/A	IB	.016"		✓																				✓	X	
	1-2					✓																				✓		
	2-3																									✓		
	3-4																									✓		



Robert Weaver 655514/II  
Cooperheat-MQS Signature

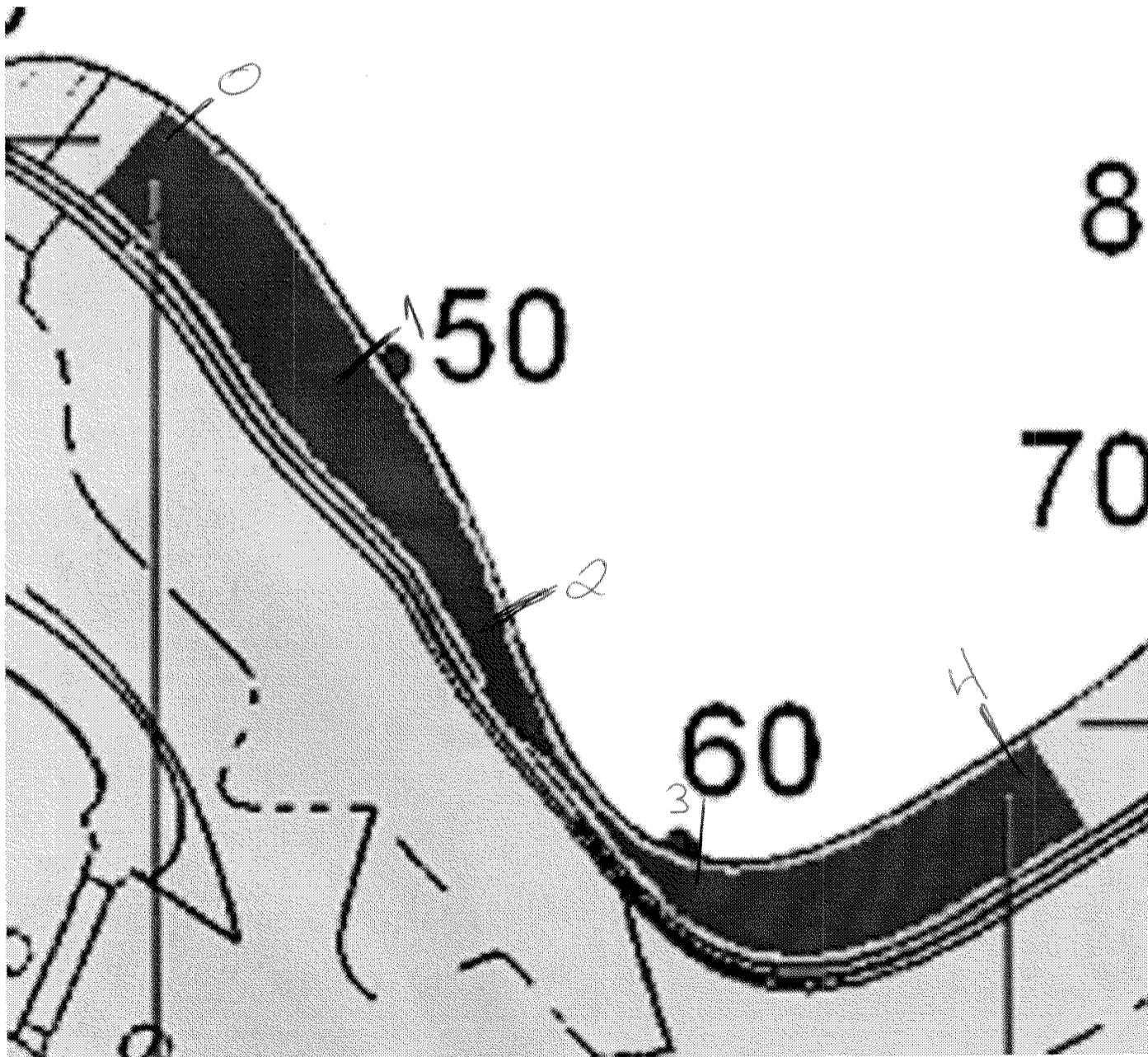
[Signature]  
Customer Representative Signature

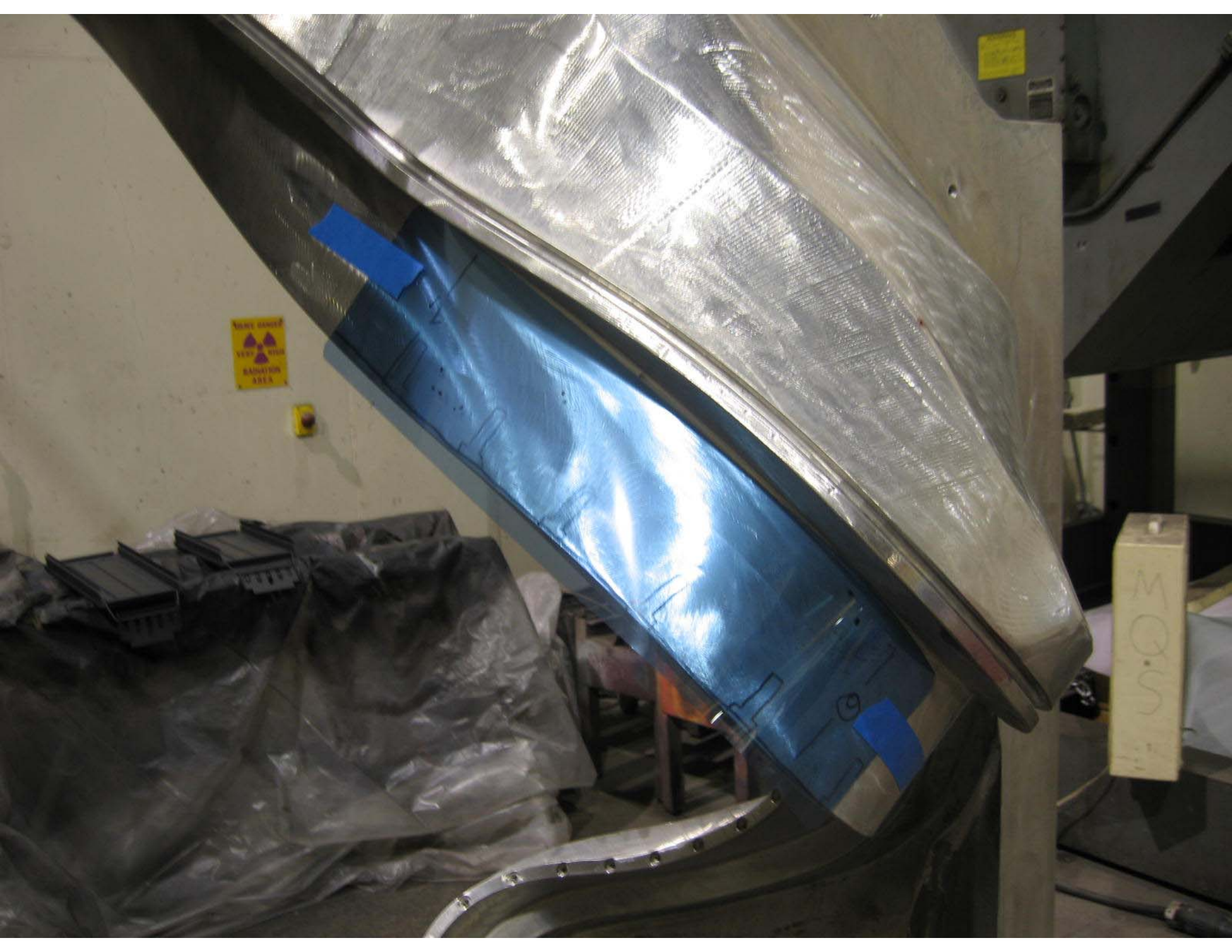
4/13/06  
Date



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NCR 19607

Figure 7-2 – High Stress Region Identification for Type-C MCWF





ACUTE HAZARD  
SEEK HELP  
RADIATION AREA

M.S.G.



