
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-115 / MODULAR COIL, TYPE B

Drawing ID: SE141-115 Revision: 8
W/O Links: 1-Type:W: 65708/1.0 Sub: 1

Customer P.O.: S005242-F/Ln:1
Serial No./Qty: B1

Reported By: MIKE GRIFFITH
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Problem: PART IS REJECTED PER ASTM A903/A903M LEVEL 1.
SEE ATTACHMENT FOR SIZES AND LOCATIONS.

Proposed Disposition:

MTM proposes that indications be accepted as is.

Number of additional pages: 11 page PT summary

Customer Disposition: Use As Is Rework Repair Scrap Replace

These indications were reviewed during a conference call on 9/19 that was attended by J. Chrzanowski, D. Williamson, F. Malinowski, L. Sutton, M. Griffith, N. Horton, P. Djordjevich, and P. Heitzenroeder. All are located in low stress areas, and were consequently accepted as is. We requested that M. Griffith check #4 and 14 for magnetic permeability since these appeared to be cavities which could contain foreign material; he confirmed by e-mail on 9/20 that the check was made, and that both passed. During discussions it was noted that the clusters of indications are most likely caused by loose sand, oxide particles, etc, which were not washed out during the molten stage due to flow obstructions such as corners or poor communication of those regions with risers and gating. 

Approved by:

Tech. Rep.

RLM

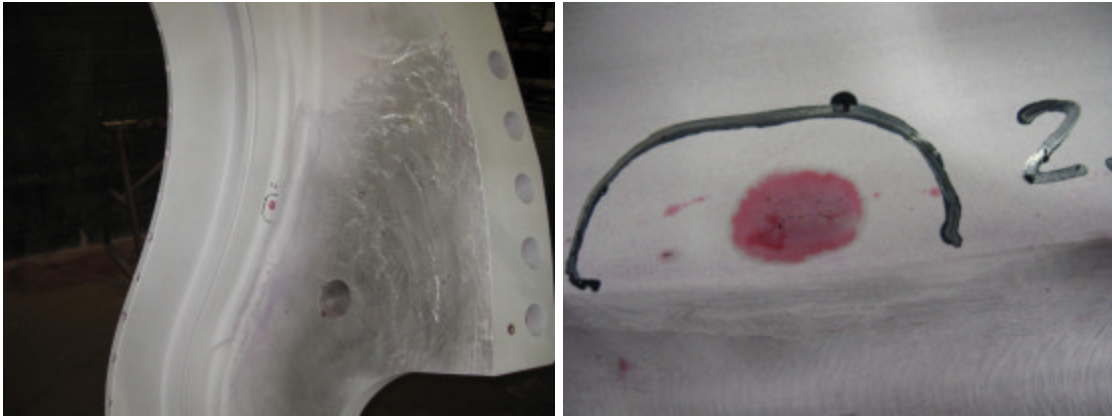
Major Tool Implemented By: _____ Title: _____ Date: _____

PT Inspection Results of B1 – NC20483

1. .250" linear located on large wing of D flange.



2. .350" linear located in radius below VPI groove. (D flange side near T hole 31)

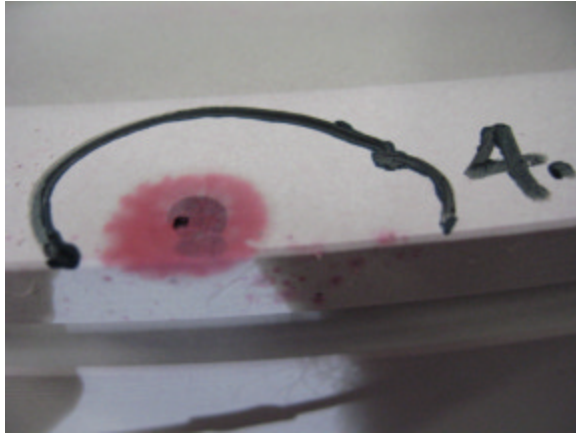


3. .150" linear located on small land between VPI groove and short leg of T. (D flange side near T hole 24)

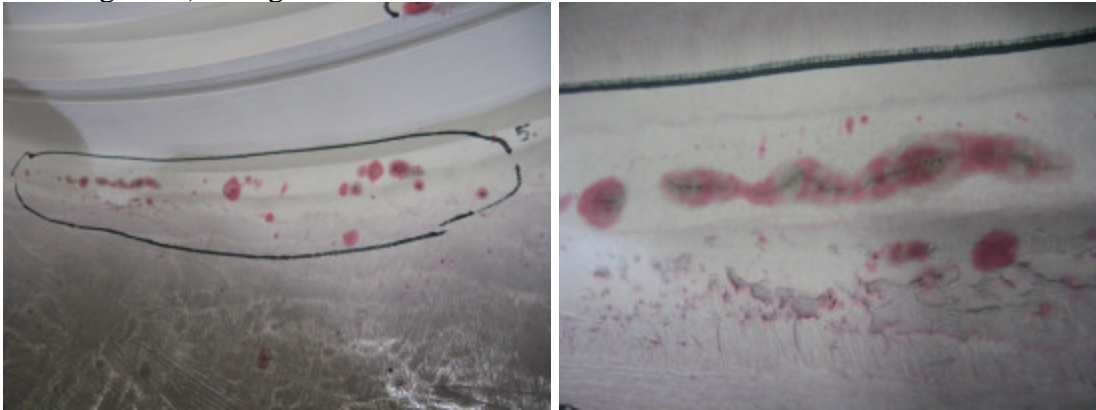


PT Inspection Results of B1 – NC20483

4. .250" rounded inclusion on short leg of T outer edge. (D flange side near hole 22)



5. Cluster of indications in radius below VPI groove between T holes 18 and 22. (D flange side) Longest indication is a 2.1" linear.

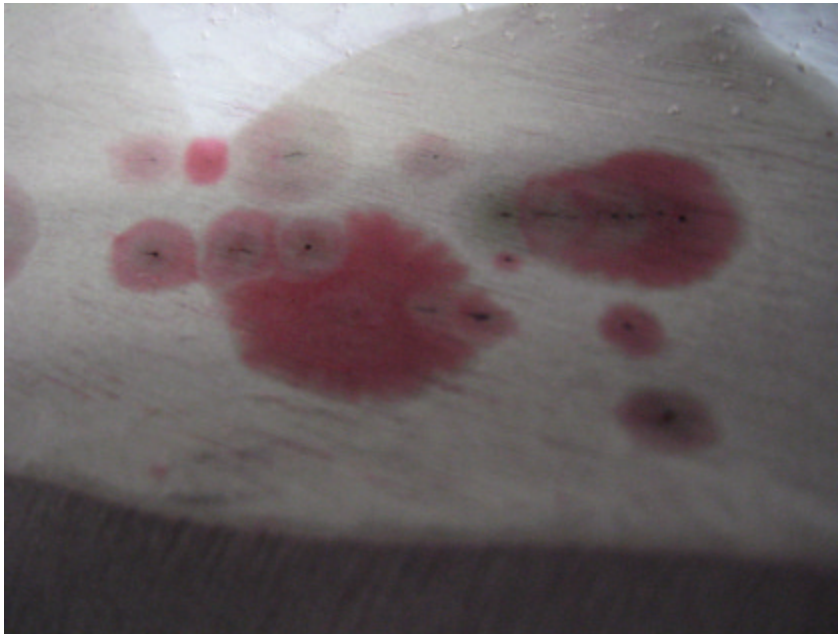


Picture at right is location of reject numbers 3, 4 and 5.



PT Inspection Results of B1 – NC20483

6. Cluster of indications in radius below VPI groove between T holes 8 and 12. (D flange side) Longest indication is a .400" linear.

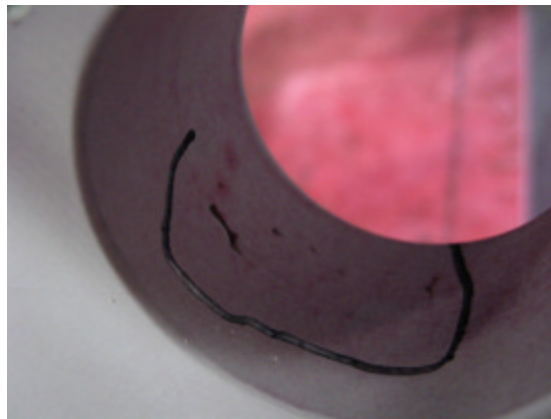


7. 1.6" linear indication on flange face of poloidal break.



PT Inspection Results of B1 – NC20483

8. .300" long inclusion in D flange hole 14.



9. .200" linear on counterbore diameter of D flange hole 6.



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10. .200" linear on counterbore diameter of D flange hole 9.



Picture below is location of rejections 9 and 10.



PT Inspection Results of B1 – NC20483

11. .700" linear on outer edge of E flange near flange hole 5.

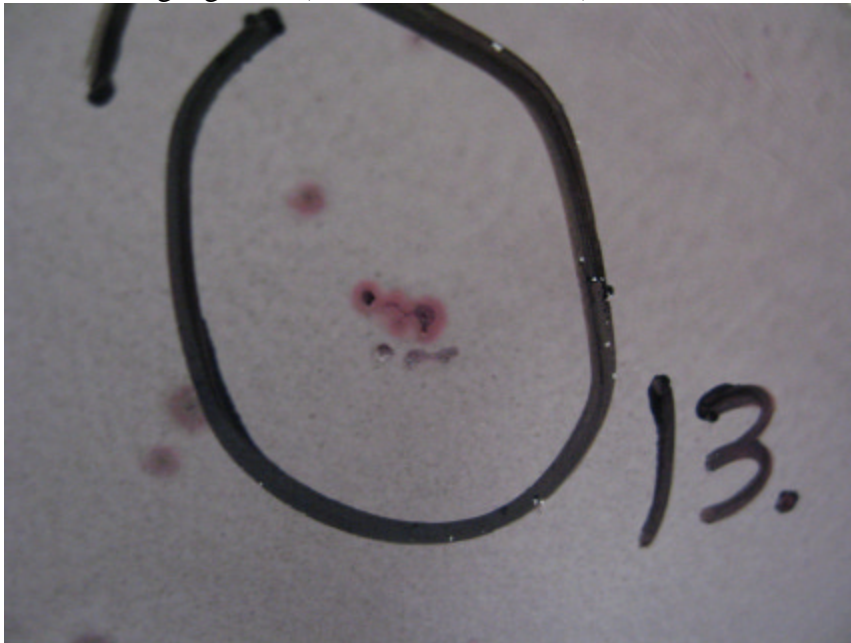


12. Cluster of indications that start on the E flange face and wrap around to the inside of the casting in the radius below the VPI groove. The longest indication is a .300" linear. The indications start between E flange holes 9 and 10.



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13. .200" linear on long leg of T. (E side near T hole 27)

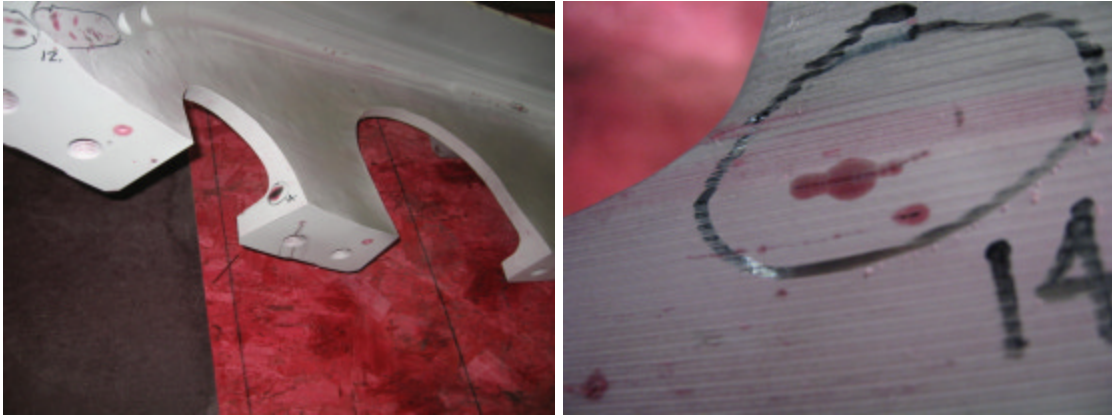


Picture below is location of rejections 12 and 13.



PT Inspection Results of B1 – NC20483

14. .700" linear in the cutout between E flange holes 10 and 11.



15. Cluster of indications in radius below VPI groove (E side near T hole 9). Longest is a .300" linear.



16. Cluster of indications in radius below VPI groove (E side near T hole 94). Longest is a .250" linear.

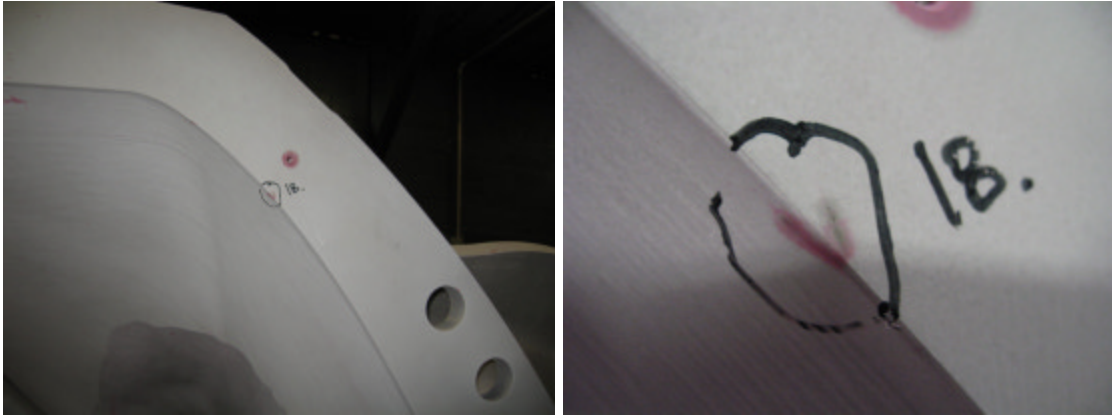


PT Inspection Results of B1 – NC20483

17. Cluster of indications in radius below VPI groove (E side near T hole 50). Longest is a .350" linear.



18. .300" linear on edge between E flange and inner casting wall. Indication is near 1/4-20 tapped hole located at drawing zone D2 of sheet 5.

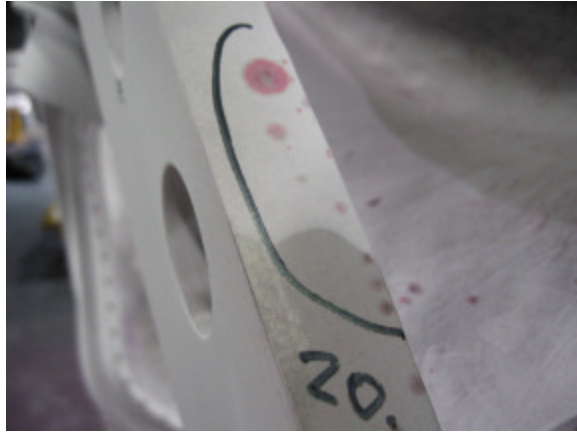


19. .100" linear on diameter of E flange hole 29.



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20. .150" linear on outer edge of E flange near flange hole 28.



21. 1.200" linear on outer edge of E flange between flange holes 26 and 27.



Location of rejections 19, 20 and 21



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22. 1.00" linear on pad (sheet 3, zone C6 of drawing).

