
Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

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

Part: SE141-114 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-114 Revision: 8
W/O Links: 1-Type:W: 65709/6.0 Sub: 15

Customer P.O.: S005242-F/Ln:6
Serial No./Qty: A6

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

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

Problem: LPI inspection indicates 2 rejectable rounded indications near 2 of the seal welded holes (Sheet 7, zone C1).
The 2 indications are marked on the part.
(This NC is in reference to Remedial Action for NC21216)

Proposed Disposition:

MTM proposes that indications be accepted as is. Porosity will not affect integrity of seal welds around inserts.

Number of additional pages: 1 page attachment

Customer Disposition: Use As Is Rework Repair Scrap Replace

This is a low-stress area. PPPL concurs with the proposed disposition is to use as-is.

Procurement Technical Representative

Responsible Line Manager:

Major Tool Implemented By: N/A Title: _____ Date: _____



Nondestructive Test Certification for Liquid Penetrant Examination

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

Date of Inspection:03/05/2007 **Type of Material:**316 SST **NDT#:**19315

Stage of Inspection: <input type="checkbox"/> Incoming Inspection <input checked="" type="checkbox"/> In-Process Inspection <input type="checkbox"/> After Repair <input type="checkbox"/> Final Inspection	Manufacturing Process: <input checked="" type="checkbox"/> Weldment <input type="checkbox"/> Casting <input type="checkbox"/> Bar Stock <input type="checkbox"/> Plate <input type="checkbox"/> Forging <input type="checkbox"/> Other	Surface Condition: <input checked="" type="checkbox"/> Machined <input type="checkbox"/> Rough <input type="checkbox"/> Other	Test Being Run to: <input checked="" type="checkbox"/> Router Instructions <input type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card	Heat Treated: <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No
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Part Information: MTM Job Number: 65709/6.0 -Sub:15 -Op:30 Resource ID: 810-LIQUID PENETRANT INSPECTI Part ID: REWORK PER NC21216 Part Name: MOD COIL WINDING FORM ASSE Serial Number: N/A Customer P.O.: S005242-F Customer Unit/Plant: N/A	Test Results: Quantity Inspected: 1 Quantity Accepted: 0 Quantity Rejected: 1 Run Hours:	Inspection Results: Customer N/C #: <input type="checkbox"/> Accepted <input checked="" type="checkbox"/> Rejected <input type="checkbox"/> N/C-Report <input type="checkbox"/> Rework MTM N/C #: 21308
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Customer Inspection PI N/A Test Step: N/A Revision: N/A Material Test Number: N/A	Inspection Criteria: Customer Specification: ASTM E165 REV: 2002 MTM Spec Number: NDT-WI-009 Acceptance Standard: ASTM A903/A903M SECT. 7 LEVEL 1
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Inspection Materials Used: Manufacturer: SHERWIN Type of Penetrant: DP-51 Batch Number: 69-E47 Developer: D-100 Batch Number: 617-Y6	Penetrant Examination Processes: Type: II (Visible) / Dwell Time: 25 Minutes Method: C (Solvent Wipe) Method of Drying: Normal Evaporation Form: e (nonaqueous for Type II visible dye) / Dwell Time: 20 Min
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Inspection Requirements:

% of all accessible surfaces
 Joint Preps
 Root Pass
 Back Gouge
 Cover Pass
 Other
 SEAL WELDS / MACHINED

Notes:
 Performed inspection of seal welds on repaired holes (sheet 7, zone C1).
 2 rejectable rounded indications found and marked on part.
 Ref. NC# 21308

This is to certify that the pieces specified have been inspected in accordance with the specifications shown.

Inspector: 053-M.DUNN

Date: 03/05/2007

Level II



NC21308 – A6 PT Rejections

Porosity in upper right photograph (.100" x .03").

