



**Customer: ENERGY INDUSTRIES OF OHIO**

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**Part: SE141-115 / MODULAR COIL, TYPE B**

Drawing ID: SE141-115      Revision: 9  
W/O Links: 1-Type:W: 65708/6.0 Sub: 1

Customer P.O.: S005242-F/Ln:6  
Serial No./Qty: B6

Reported By: MIKE GRIFFITH  
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Problem: REJECTABLE INDICATION WERE FOUND AT TIME OF INSPECTION. 9 DEFECTS WERE REJECTABLE PER ASTM A903/A903M LEVEL 1.

- 1) .400" linear
- 2) .300" linear
- 3) 1.3" linear cluster
- 4) .500" linear
- 5) .700" linear
- 6) .400" linear
- 7) .300" linear cluster
- 8) .300" rounded inclusion.
- 9) .400 linear cluster

See attachment for pictures and locations.

**Proposed Disposition:**

MTM proposes to accept deviations as is based on the similarity of these indications to previously accepted coils.

Number of additional pages: 5 page attachment

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

The attached indications were reviewed during a conference call held on 5/23/07 by L. Sutton, J. Chrzanowski, F. Malinowski, D. Williamson, N. Horton, R. Sheppard and P. Heitzenroeder. All were accepted for use as is, since they are all located outside of the high stress region which is also attached. .

Accepted by::

Tech. Rep.

RLM.

Major Tool Implemented By: \_\_\_\_\_ Title: \_\_\_\_\_ Date: \_\_\_\_\_

## Type B Winding Form High Stress Region

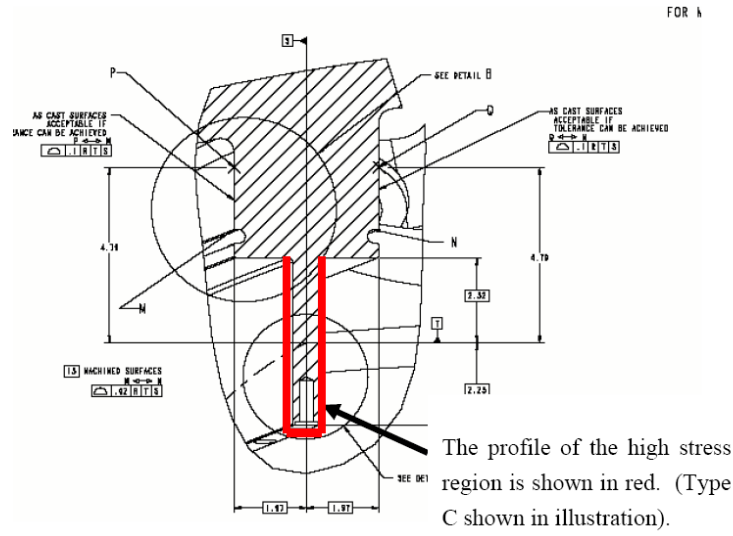


Figure 7-1 – Identification of High Stress Zones

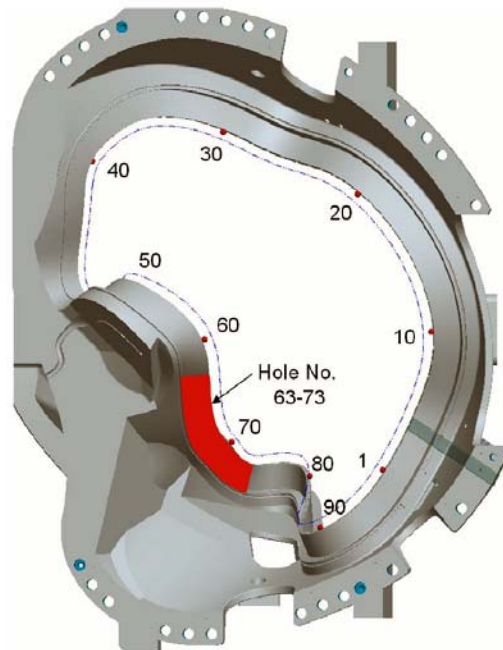
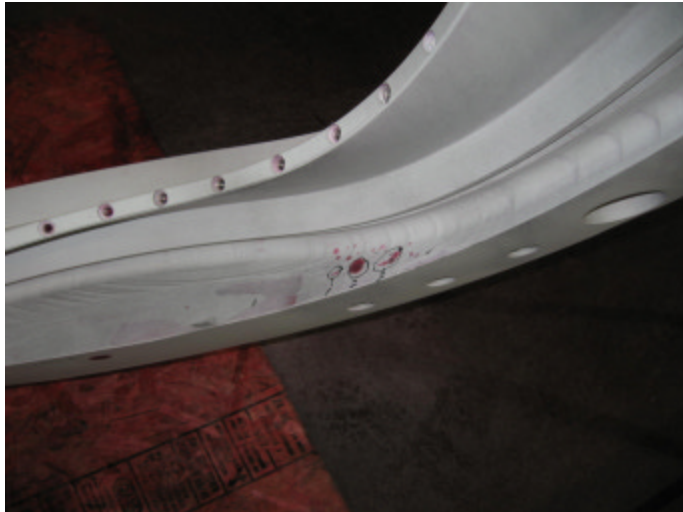


Figure 7-3 – High Stress Region Identification for Type-B MCWF



## NC21847 – B6 PT Rejections



Indications 1 thru 3 are all located on the Datum E side in the radius below the VPI groove between T holes 37 and 38.

Indication 1 is a .400" linear

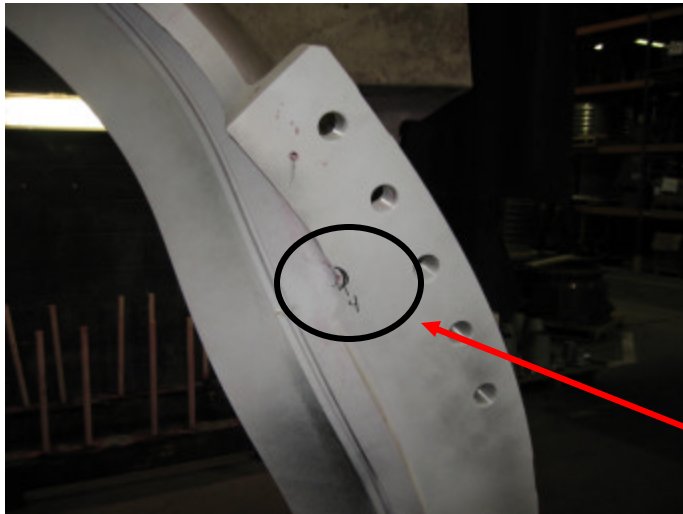
Indication 2 is a .300" linear

Indication 3 is a 1.3" linear cluster

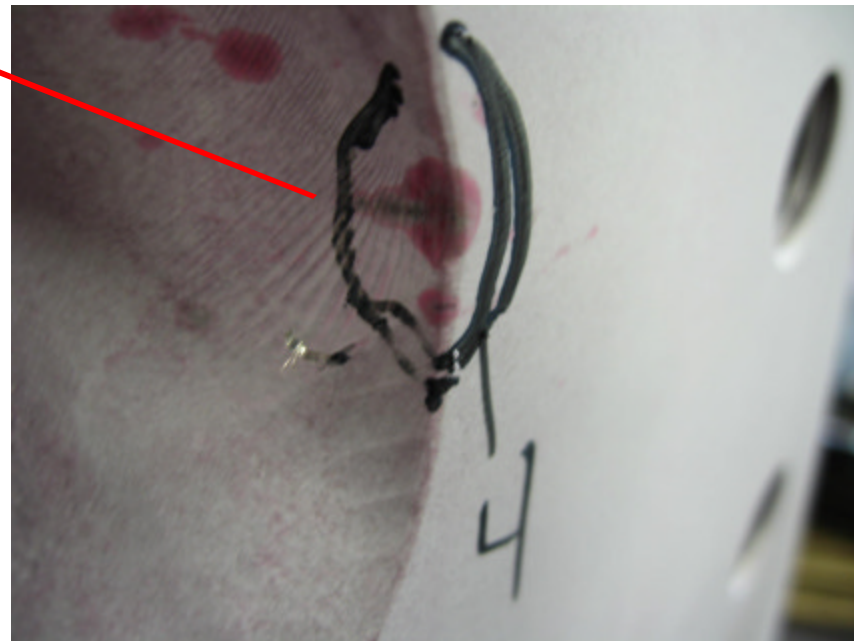




## NC21847 – B6 PT Rejections

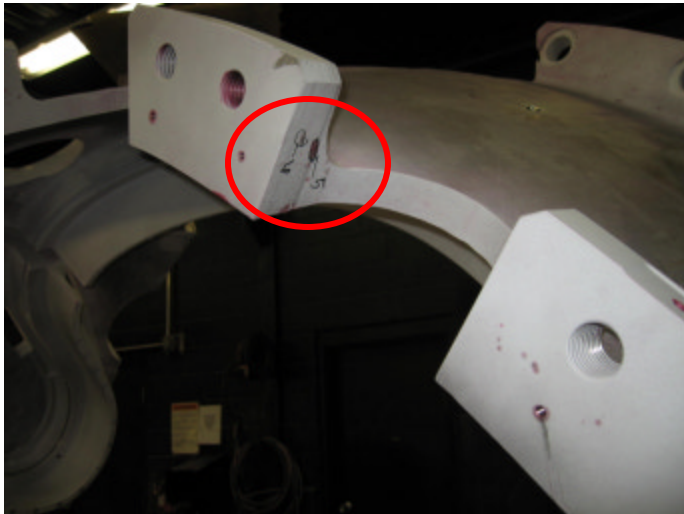


Indication 4 is a .500" linear that starts on the corner of the datum E flange and extends into the inner cast area. This indication is adjacent to datum E flange hole #9.





## NC21847 – B6 PT Rejections



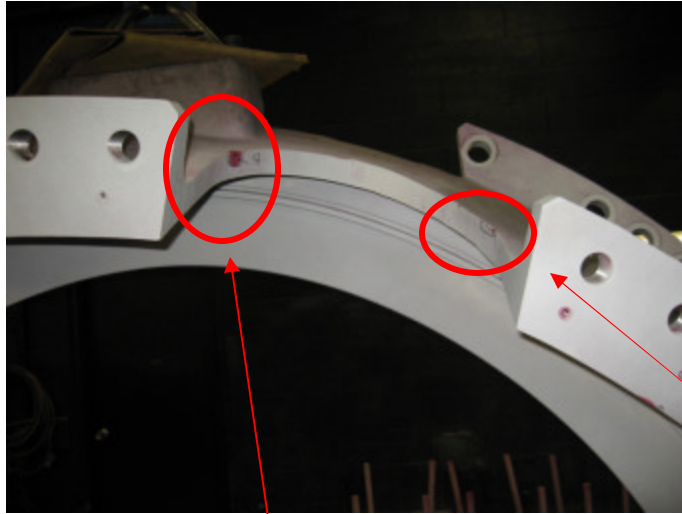
Indications 5 & 6 are on the inside of the cutout that is located between E flange holes 10 & 11.

Indication 5 is a .700" linear and indication 6 is a .400" linear.





## NC21847 – B6 PT Rejections



Indications 7 & 8 are on the inside of the cutout that is located between E flange holes 12 & 13.

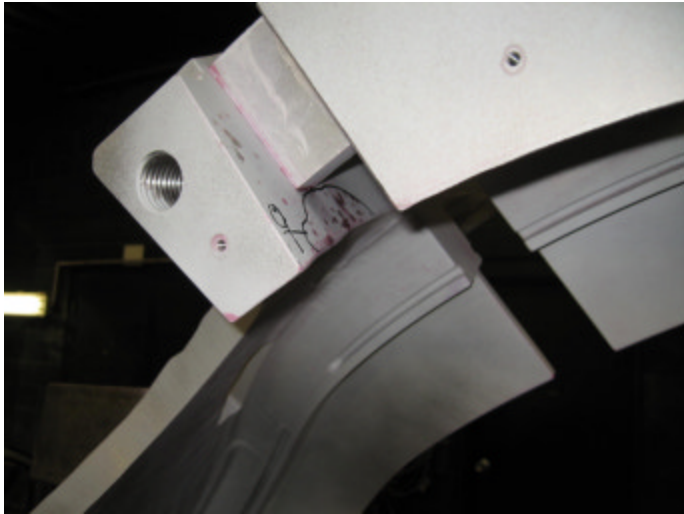
Indication 7 is a cluster of linear indications, the longest being .300”.

Indication 8 is indication is a .300” rounded inclusion.





## NC21847 – B6 PT Rejections



Indication 9 is a cluster of linear indications on the face of the poloidal break on the datum E side of the casting. The longest indication is approximately .400”.

