

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: 65708/3.0 Sub: 1

Customer P.O.: S005242-F/Ln:3
Serial No./Qty: B3

Reported By: MIKE GRIFFITH
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Problem: 4 indications exceeding requirements of ASTM A903M level 1. Machined surfaces only.

- #1 Line porosity, outer flange "E" side, 2.5" long.
- #2 Line porosity, "D" side between holes 25-26 in the "T", 2.30" long.
- #3 Line porosity, poloidal break, mating face, .700" long.
- #4 Linear indication w/shrink cluster, "E" side wing O.D. .700" long.

Proposed Disposition:

MTM Proposed that indications be accepted As Is.

Number of additional pages: 2 page PT summary

Customer Disposition: Use As Is Rework Repair Scrap Replace

Indication #1 is in the edge of the flange where the stress is low and can therefore be accepted as is.
Indication #2 is in the thick base section of the T in a low stress region-see attached stress plot.
Indication #3 is in the face section of the poloidal break and will be in compression, which inhibits crack growth and can therefore be accepted as is.
Indication #4 is in a heavy wing section and can therefore be accepted because the crack will not grow through this piece during the machine lifetime.

Major Tool and Machine, Inc. 1458 East 19th Street, Indianapolis, IN 46218-428

Approved by:

Tech. Rep.

RLM

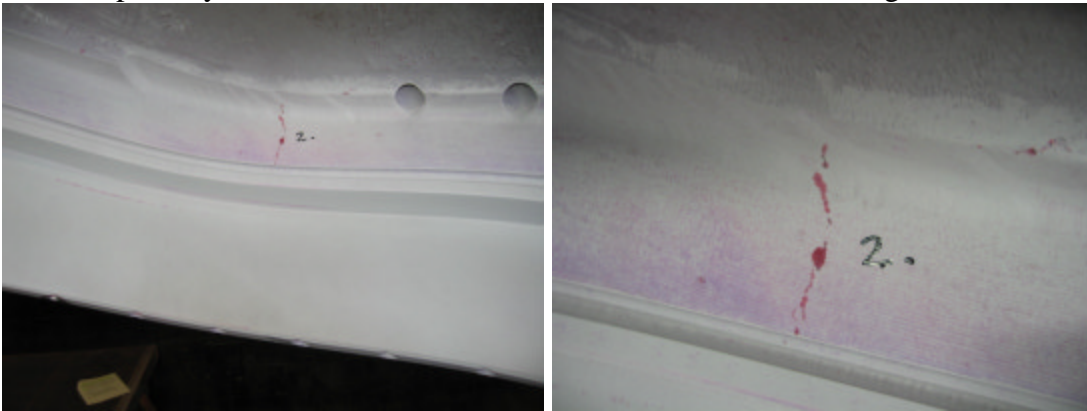
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

PT Inspection Results of B3 – NC20871

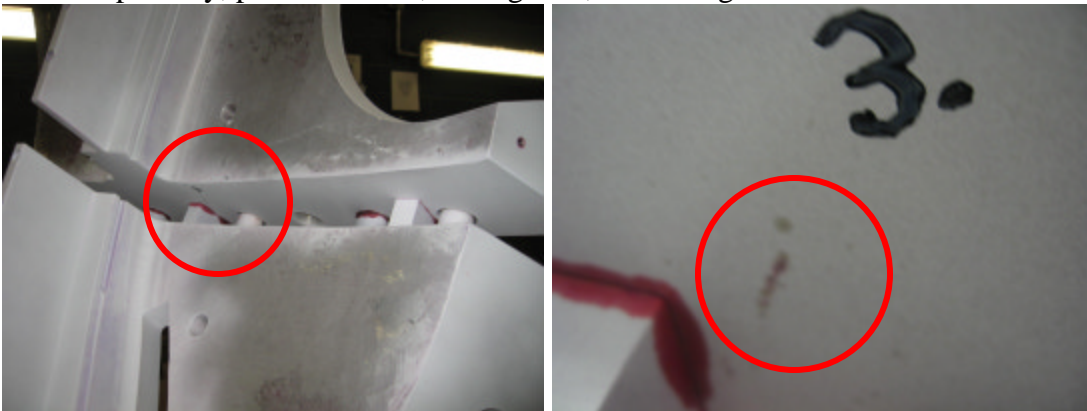
1. Line porosity, outer flange "E" side, 2.5" long.



2. Line porosity, "D" side between holes 25-26 in the "T", 2.30" long.

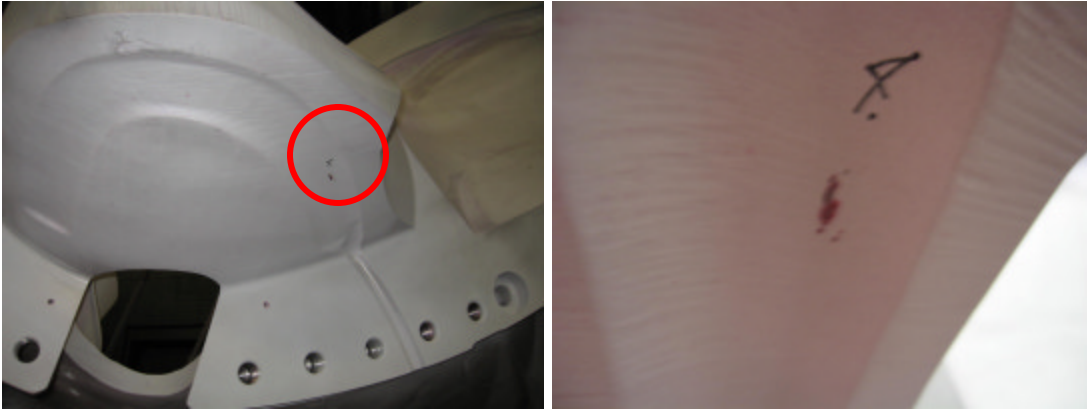


3. Line porosity, poloidal break, mating face, .700" long.



PT Inspection Results of B3 – NC20871

4. Linear indication w/shrink cluster, "E" side wing O.D. .700" long.



1

ANSYS 10.0
NODAL SOLUTION
STEP=1
SUB =1
TIME=1
SZ (AVG)
RSYS=5000
PowerGraphics
EFACET=1
AVRES=Mat
DMX =.002633
SMN =-.338E+09
SMX =.402E+09
-.140E+09
-.124E+09
-.109E+09
-.933E+08
-.778E+08
-.622E+08
-.467E+08
-.311E+08
-.156E+08
0
.156E+08
.311E+08
.467E+08
.622E+08
.778E+08
.933E+08
.109E+09
.124E+09
.140E+09

