

**PPPL NONCONFORMANCE REPORT NO: 3632**      **Open Date 03/09/06**

<b>Status</b>	9 - Closed NCR		<b>Trend</b>	03-Code Deviation	
<b>Department</b>	NCSX		<b>Division</b>	NCSX Project	
<b>Source/Org</b>	FABRICATION, OPERATIONS & MAINTENANCE				
<b>Item Dwg/Part#</b>	SE-1409-013	<b>Procurement #</b>	Welding/Brazing	<b>Cost Center</b>	
<b>RAP#</b>	890	<b>Job Doc #</b>	Welding/Brazing	<b>Vendor</b>	
<b>RAP Title</b>	PPPL WELDING/BRAZING PROGRAM (QC GENERIC RAP FOR WELD DEVIATIONS)				
<input type="checkbox"/> HoldTag Applied					

**Nonconforming Condition (include requirement(s) violated):**

The Modular Coil Cryostat Base Skid has the following non-conforming conditions on all horizontal position tube steel to tube steel welds:  
 1) Welder is qualified for flat position only for GMAW process per ASME Sec. IX, QW461.9. Welds are in horizontal position. 2) Welds have undercut exceeding limits of AWS D1.1, Sect. 6, Table 6.1 for Tubular Connections.

<b>Lot Size Recd</b>	<u>0</u>	<b>Sample Size Insp</b>	<u>0</u>	<input type="checkbox"/> Lot Rejected	<b># Rejected</b>	<u>0</u>
<b>Reported By</b>	<u>Boscoe J</u>	<b>Validated By</b>	<u>Phelps C</u>	<b>Validated Date</b>	<u>03/09/06</u>	

**Disposition:**    Rework\*       Repair\*       Use As Is\*       Return To Vendor\*       Scrap\*       **Repair**

For Item #2: Welding operator shall repair undercut with TIG process (GTAW).  
 For Item #1: PPPL must develop a weld procedure specification for future GMAW work in all relevant positions.  
 3/14/06: JAM: Verification of CA for item #1 will be performed when future GMAC work arises.

<p><b>For rework or repair of vendor supplied equipments, fill in information below:</b></p> <table style="width:100%;"> <tr> <td><b>#Hours</b></td> <td><u>          </u></td> <td><b>\$Est Labor</b></td> <td><u>          </u></td> <td><b>\$G&amp;A</b></td> <td><u>          </u></td> </tr> <tr> <td><b>\$Material</b></td> <td><u>          </u></td> <td><b>\$Burden</b></td> <td><u>          </u></td> <td><b>\$Total</b></td> <td><u>          </u></td> </tr> </table> <table style="width:100%;"> <tr> <td><b>Disposition By</b></td> <td><u>Gettelfinger G</u></td> <td><b>Date</b></td> <td><u>03/09/06</u></td> </tr> <tr> <td><b>Supervisor's Concur</b></td> <td><u>Dudek L</u></td> <td><b>Date</b></td> <td><u>03/09/06</u></td> </tr> <tr> <td><b>Eng. Dept. Head Concur</b></td> <td><u>Williams M</u></td> <td><b>Date</b></td> <td><u>03/09/06</u></td> </tr> <tr> <td><b>WCO/Other</b></td> <td><u>N/A</u></td> <td><b>Date</b></td> <td><u>          </u></td> </tr> </table> <table style="width:100%; margin-top: 20px;"> <tr> <td><b>PQA/QC Mgr Dispos Concur</b></td> <td><u>Malsbury J</u></td> <td><b>Date</b></td> <td><u>03/14/06</u></td> </tr> <tr> <td><b>QC Field Verification By</b></td> <td><u>Boscoe j</u></td> <td><b>Date</b></td> <td><u>03/14/06</u></td> </tr> </table>	<b>#Hours</b>	<u>          </u>	<b>\$Est Labor</b>	<u>          </u>	<b>\$G&amp;A</b>	<u>          </u>	<b>\$Material</b>	<u>          </u>	<b>\$Burden</b>	<u>          </u>	<b>\$Total</b>	<u>          </u>	<b>Disposition By</b>	<u>Gettelfinger G</u>	<b>Date</b>	<u>03/09/06</u>	<b>Supervisor's Concur</b>	<u>Dudek L</u>	<b>Date</b>	<u>03/09/06</u>	<b>Eng. Dept. Head Concur</b>	<u>Williams M</u>	<b>Date</b>	<u>03/09/06</u>	<b>WCO/Other</b>	<u>N/A</u>	<b>Date</b>	<u>          </u>	<b>PQA/QC Mgr Dispos Concur</b>	<u>Malsbury J</u>	<b>Date</b>	<u>03/14/06</u>	<b>QC Field Verification By</b>	<u>Boscoe j</u>	<b>Date</b>	<u>03/14/06</u>	<p><b>Distribution</b></p> <p><b>Cog</b> <u>Gettelfinger G</u>  <b>Insp</b> <u>Boscoe J</u>                  Proj. Doc Control (when closed)                   QC Files                  Malsbury J                  Boscoe J                  Dudek L                  Williams M                  Keilbach R</p>
<b>#Hours</b>	<u>          </u>	<b>\$Est Labor</b>	<u>          </u>	<b>\$G&amp;A</b>	<u>          </u>																																
<b>\$Material</b>	<u>          </u>	<b>\$Burden</b>	<u>          </u>	<b>\$Total</b>	<u>          </u>																																
<b>Disposition By</b>	<u>Gettelfinger G</u>	<b>Date</b>	<u>03/09/06</u>																																		
<b>Supervisor's Concur</b>	<u>Dudek L</u>	<b>Date</b>	<u>03/09/06</u>																																		
<b>Eng. Dept. Head Concur</b>	<u>Williams M</u>	<b>Date</b>	<u>03/09/06</u>																																		
<b>WCO/Other</b>	<u>N/A</u>	<b>Date</b>	<u>          </u>																																		
<b>PQA/QC Mgr Dispos Concur</b>	<u>Malsbury J</u>	<b>Date</b>	<u>03/14/06</u>																																		
<b>QC Field Verification By</b>	<u>Boscoe j</u>	<b>Date</b>	<u>03/14/06</u>																																		