

**PPPL NONCONFORMANCE REPORT NO: 3638**      **Open Date 03/20/06**

|                       |                                    |                      |                 |                             |                          |
|-----------------------|------------------------------------|----------------------|-----------------|-----------------------------|--------------------------|
| <b>Status</b>         | 2 - Disposition Needed             |                      | <b>Trend</b>    | 06-Workmanship/Needs Repair |                          |
| <b>Department</b>     | NCSX                               |                      | <b>Division</b> | NCSX Project                |                          |
| <b>Source/Org</b>     | VENDOR                             |                      |                 |                             |                          |
| <b>Item Dwg/Part#</b> | Header Bracket Weldment            | <b>Procurement #</b> | PE006421-W      | <b>Cost Center</b>          |                          |
| <b>RAP#</b>           | 3236                               | <b>Job Doc #</b>     | PE006421-W      | <b>Vendor</b>               | ZENEX PRECISION PRODUCTS |
| <b>RAP Title</b>      | NCSX Heating and Cooling Manifolds |                      |                 |                             |                          |

*Holdings Agency*

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

All 24 Header Bracket Standoff Weldments ( Dwgs. SE123-168, Part 1) arrived with the throats of the fillet welds undersized by over 10 percent of the weld length as required per AWS D1.6, 6.28.1.7. Additionally, 13 of 24 Weldments have fillet welds that are excessively undercut beyond the limit set in AWS D1.6, 6.28.1.5.

|                      |          |                         |        |                       |          |
|----------------------|----------|-------------------------|--------|-----------------------|----------|
| <b>Lot Size Recd</b> | 24       | <b>Sample Size Insp</b> | 24     | <b># Rejected</b>     | 24       |
| <b>Reported By</b>   | Boscoe J | <b>Validated By</b>     | Zatz I | <b>Validated Date</b> | 03/17/06 |

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

*RETURN TO VENDOR TO REWELD FILLET.*

For rework or repair of vendor supplied equipments, fill in information below:

|                   |       |                    |       |                  |       |
|-------------------|-------|--------------------|-------|------------------|-------|
| <b>#Hours</b>     | _____ | <b>\$Est Labor</b> | _____ | <b>\$G&amp;A</b> | _____ |
| <b>\$Material</b> | _____ | <b>\$Burden</b>    | _____ | <b>\$Total</b>   | _____ |

|                               |                    |             |         |
|-------------------------------|--------------------|-------------|---------|
| <b>Disposition By</b>         | <i>[Signature]</i> | <b>Date</b> | 3/20/06 |
| <b>Supervisor's Concur</b>    | _____              | <b>Date</b> | _____   |
| <b>Eng. Dept. Head Concur</b> | _____              | <b>Date</b> | _____   |
| <b>WCO/Other</b>              | _____              | <b>Date</b> | _____   |

|                                 |       |             |       |
|---------------------------------|-------|-------------|-------|
| <b>PQA/QC Mgr Dispos Concur</b> | _____ | <b>Date</b> | _____ |
| <b>QC Field Verification By</b> | _____ | <b>Date</b> | _____ |

**Distribution**

**Cog** Dudek L  
**Insp** Boscoe J  
 Proj. Doc Control (when closed)  
 QC Files  
 Malsbury J  
 Boscoe J  
 Nelson B  
 Goranson P  
 Viola M  
 Williams M  
 White A  
 Lumberger J  
 Tyrrell M  
 Malinowski F