
Customer: ENERGY INDUSTRIES OF OHIO

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Part: SE141-116 / MODULAR COIL WINDING FORM TYPE

Drawing ID: SE141-116

Revision: 8

Customer P.O.: S005242-F/Ln:4
Serial No./Qty: C4

Reported By: MIKE GRIFFITH

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Problem: There is a tool gouge in the T-section of the Datum E side. The gouge is along the short leg of the L in the location where the .5" VPI bleed hole intersects the T-section (zone F3 on sheet 9 of the drawing). The gouge is approximately 12" in length and approximately .05" in depth. The width and location of the gouge varies along the surface. See attached pictures for further details.

Proposed Disposition:

Major Tool Proposes to weld the defective area after the completion of all machining operations. Indicators would be placed on and around the T section to monitor any movement that may occur during welding. If required, welds will be performed on the opposite side of the T to counteract any movement that occurs. The welded areas will be blended to the adjacent machined surfaces to maintain the correct profile. Both a PT inspection and permeability check will be performed on any welded areas. Major Tool also proposes a waiver of RT for this repair. Due to the thickness of the casting in this area, it is highly unlikely that an x-ray would produce any evidence of a defect introduced by the welding process.

Number of additional pages: 4

Customer Disposition: Use As Is Rework Repair Scrap Replace

- This tool gouge is located on the base of the "T" between bolt locations 25 and 30. Please see the attached photos also.
 - The size and location of this gouge **requires this defect to be weld repaired.**
 - Major Tool's proposal to waive the RT for this repair and perform PT and permeability checks is accepted

EIO verification of completion: _____

Title: _____ Date: _____

Major Tool Implemented By: _____

Title: _____ Date: _____

Approved by:

Tech. Rep.

RLM

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