

Nonconformance Report: CA1536

Project Disposition:

The manganese level at 0.1% over the 2.8% limit will be accepted for A-3, A-4, A-5 & C-6. However, since the physical properties of the alloy are dependent upon consistent chemistry, NCSX requests that MetalTek do its best to conform to the chemistry as presently stated in the specification. Deviations will be considered on a case by case basis.

Approvals:

**Wayne
Reiersen**

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DN: CN = Wayne Reiersen, C = US, O
= PPPL
Reason: I am approving this document
Date: 2006.02.14 11:18:44 -05'00'

Procurement Technical Representative

Brad Nelson

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Responsible Line Manager:



Corrective Action 1536
Carondelet Division
Corrective Action Type NCR
Date 1-13-06
CA Originator C. Ruud
Applies to: A-3, A-4, A-5 and C-6 Coil

Description of Defect / Non-Conformance

Manganese levels in material produced for A-3 and C-6 coil castings exceed specification limits in PPPL Specification NCSX-CSPEC-141-03-07 Rev 10. Manganese is 0.1% over the maximum of 2.8% for both parts.

Root Cause

Mt has aimed at the higher end of the range for manganese to assure the chemistry is correct in the casting. However the manganese did not fade as much as expected.

Corrective Action

Lower the aim to 2.9%.

Verification of Corrective Action

Chemistry analysis of coil chemistries for A-4 and 5 indicated that we are still 0.1% high. Therefore they have been added to this corrective action. Based on this result we will lower aim to 2.8%.

Preventive Action

The specification for manganese should be increased.

Verification of Preventative Action

Pending

Estimated Completion Date

TBD

Actual Completion Date

TBD

Signed: C. Ruud

A handwritten signature in black ink, appearing to be "C. Ruud", with a long horizontal line extending to the right.

CC: R. Broman, B. Craig, J. Edwards, E.J. Kubick, J. Markham, J. Galaske