

Disposition of NCR 1537 February 10, 2006

The 0.001% over the maximum of 0.035% phosphorus and will be accepted for B1. However since the physical properties of the alloy is 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.

Approved by:

**Phil
Heitzenroeder**

Digitally signed by Phil
Heitzenroeder
DN: CN = Phil Heitzenroeder, C =
US, O = PPPL, OU = Mech. Eng.
Division
Reason: I am approving this
document
Date: 2006.02.10 12:52:44 -05'00'

Technical representative

**Brad
Nelson**

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-05'00'

Responsible line manager



Corrective Action 1537
Carondelet Division
Corrective Action Type NCR
Date 1-13-06
CA Originator C. Ruud
Applies to: B-1 Coil

Description of Defect / Non-Conformance

Phosphorus levels in material produced for B-1 coil casting exceed specification limits in PPPL Specification NCSX-CSPEC-141-03-07 Rev 10. Phosphorus is 0.001% over the maximum of 0.035%.

Root Cause

We have no way to remove phosphorus from the melt and do not intentionally add phosphorus. These results are consistent with our charge material analysis.

Corrective Action

Pending.

Verification of Corrective Action

Chemistry analysis of next coil, A-4 and 5. Phosphorus levels were within the required specification.

Preventive Action

We will request a deviation for phosphorus in the subject parts and also request a permanent specification change to 0.040% maximum for both phosphorus and sulfur, to allow us to provide non-discrepant material.

Verification Of Preventative Action

Pending

Estimated Completion Date

1-20-06

Actual Completion Date

1-20-06

A handwritten signature in black ink, appearing to be "C. Ruud".

Signed: C. Ruud

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