

Major Tool & Machine, Inc.
1458 East 19th Street
Indianapolis, IN 46218-4289

MTM N/C: 19321

Page: 1
Date: 03/03/06
User ID: GRIFFITH

Customer: ENERGY INDUSTRIES OF OHIO

Contact: NANCY HORTON
E-Mail: NKHFlowen@aol.com

Telephone: 216-496-2314
Fax: 216-328-2001

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
E-Mail: mGriffith@MajorTool.com

Telephone: 317-636-6433
Fax: 317-634-9420

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: *Nancy Horton* Title: EIO Program Mgr for NCSY Date: 3/24/06

Major Tool Implemented By: *Mike Griffith* Title: _____ Date: _____

Digitally signed by Mike Griffith
DN: CN = Mike Griffith, C = US, O = Major Tool and Machine, OU = CFT White
Date: 2006.03.24 17:26:45 -0500

Approved by:

Phil Heitzenroeder
Tech. Rep.

Digitally signed by Phil Heitzenroeder
DN: CN = Phil Heitzenroeder, C = US, O = PPPL, OU = Mech. Eng. Division
Reason: I agree to 'specified' portions of this document
Date: 2006.03.22 09:48:12 -0500

Brad Nelson
RLM

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2006.03.21 21:08:57 -0500

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Major

Tool & Machine, Inc.

Nondestructive Test Certification for Liquid Penetrant Examination

1458 E. 19th Street, Indianapolis, In 4621
TEL:(317)636-6433 FAX:(317)634-9420

Date of Inspection:03/24/2006

Type of Material:CAST STAINLESS

NDT#:16147

Stage of Inspection: <input type="checkbox"/> Incoming Inspection <input type="checkbox"/> In-Process Inspection <input checked="" type="checkbox"/> After Repair <input type="checkbox"/> Final Inspection	Manufacturing Process: <input type="checkbox"/> Weldment <input type="checkbox"/> Bar Stock <input type="checkbox"/> Forging <input checked="" type="checkbox"/> Casting <input type="checkbox"/> Plate <input type="checkbox"/> Other	Surface Condition: <input checked="" type="checkbox"/> Machined <input type="checkbox"/> Rough <input checked="" type="checkbox"/> Other FINAL MACHINED & AS CAST	Test Being Run to: <input checked="" type="checkbox"/> Router Instructions <input checked="" type="checkbox"/> Drawing <input type="checkbox"/> Test Plan <input type="checkbox"/> Technique Card SEE NOTES	Heat Treated: <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No
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Part Information: MTM Job Number: 65707/4.0 -Sub:12 -Op:30 Resource ID: 810-LIQUID PENETRANT INSPECTI Part ID: SE141-116 Part Name: MODULAR COIL WINDING FORM Serial Number: Customer P.O.: S005242-F Customer Unit/Plant:	Test Results: Quantity Inspected: 1 Quantity Accepted: 1 Quantity Rejected: 0 Run Hours:	Inspection Results: Customer N/C #: <input checked="" type="checkbox"/> Accepted <input type="checkbox"/> Rejected <input type="checkbox"/> N/C-Report <input type="checkbox"/> Rework MTM N/C #: 19321
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Customer Inspection PI SEE NOTES Test Step: Revision: Material Test Number:	Inspection Criteria: Customer Specification: ASTM A903/A903M MTM Spec Number: PS582 (REF NDT-WI-09) Acceptance Standard: ASTM A903 (SEE NOTES)
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Inspection Materials Used: Manufacturer: SHERWIN Type of Penetrant: DP-51 Batch Number: 41-E47 Developer: D-100 Batch Number: 520-H6	Penetrant Examination Processes: Type: II (Visible) / Dwell Time: 15 Minutes Method: A (Water Wash) Method of Drying: Forced Air Fan Form: e (nonaqueous for Type II visible dye) / Dwell Time: 15 Min
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Inspection Requirements:

100 % of all accessible surfaces Joint Preps Root Pass Back Gouge Cover Pass Other

Notes:

PENETRANT INSPECT WELD REPAIR.
Specification: ASTM A903/A903M LEVEL 1
MTM NDT Cert: REPAIR OF DEFECT NC19321

No defects noted.

This is to certify that the pieces specified have been inspected in accordance with the specifications shown.

Inspector: 674-S.WILLIAMS

Date: 03/24/2006

Sylvester Williams Level II

INSPECTION DATA CHECKLIST

Workorder: 65707/4-0 Sub:12 Op:40

Revision: 03/06/06 7:42

Part: REWORK - REWORK / REPAIR PER N/C - N/C # _____

Drawing ID: SE141-116 Rev: 8		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
(10)		N C 19321 RECORD PERMEABILITY READINGS OF THE REPAIRED AREA. MAG PERMEABILITY TO BE NO GREATER THAN 1.02μ.	MASTER GAGE	QA		J-1165	LESS THAN 1.02	503-B.HO 03-24-06			A

Employees: 503-B.Houk

* To Far Right Indicates Data Package Requirement

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.