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

MTM N/C: 19587

Date: 04/14/06
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:5
Serial No./Qty: C5

Reported By: MIKE GRIFFITH
E-Mail: mGriffith@MajorTool.com
Telephone: 317-636-6433
Fax: 317-634-9420

Problem: PART IS REJECTED PER ASTM A903/A903M LEVEL 1.
SEE ATTACHMENT FOR SIZES AND LOCATIONS.

Proposed Disposition:
CUSTOMER TO ADVISE.

Number of additional pages: 11

Customer Disposition: [ ] Use As Is [X] Rework [ ] Repair [ ] Scrap [ ] Replace

The defects indicated on the attached were reviewed in detail by David Williamson and Phil Heitzenroeder while communicating with Frank Malinowski, Roy Sheppard, and Mike Griffeth at MTM. MTM sent additional photos requested, and each defect was discussed in detail. Based on these discussions, it was jointly decided that the indications should be dispositioned as indicated in the attached Excel spreadsheet.

Approved by:

Phil Heitzenroeder
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: 2006.04.19 17:52:27 -04'00'

Tech. Rep.

Brad Nelson
Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US, o=ORNL, ou=FED, email=nelsonbe@ornl.gov
Date: 2006.04.19 21:59:39 -04'00'

RLM

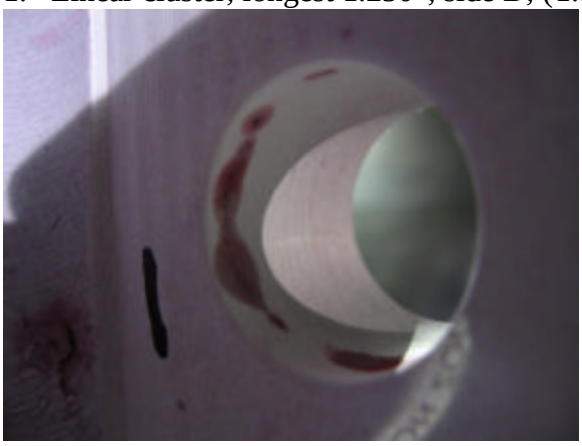
Major Tool Implemented By: _____ **Title:** _____ **Date:** _____

n:\mtmapps\Mtnonc14.qrp

PT Inspection Results of C5 – NC19587

MTM Workorder #: 65707/5.0
NC19587
SE141-116 C5 MODULAR COIL WINDING FORM TYPE-C
PENETRANT TEST: TYPE II, METHOD A, FORM E
REJECT INDICATIONS PER ASTM A903/A903M

1. Linear cluster, longest 1.250”, side D, (1.130 diameter hole in foot)

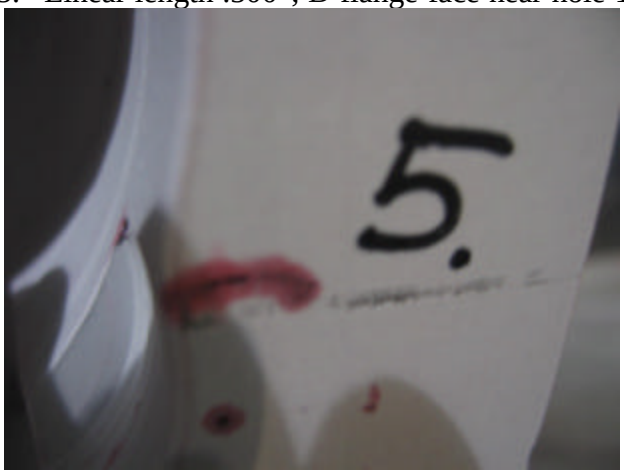


2. Linear cluster, longest .450”, under E flange, under small wing

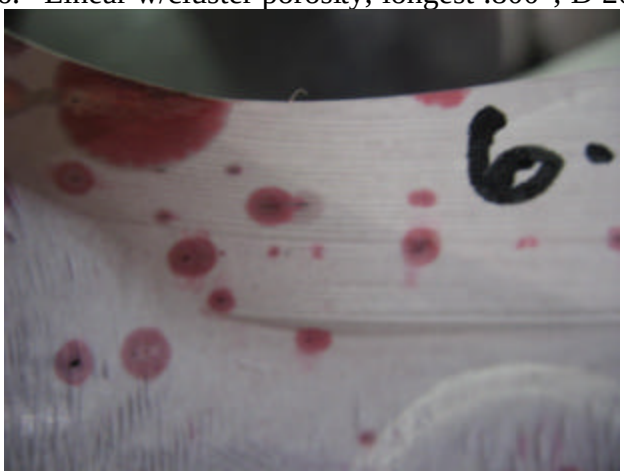
3. Linear, length .300”, on pad near lead block slot

4. Linear cluster, longest .300”, O.D. of D flange near hole 7

5. Linear length .500”, D flange face near hole 16



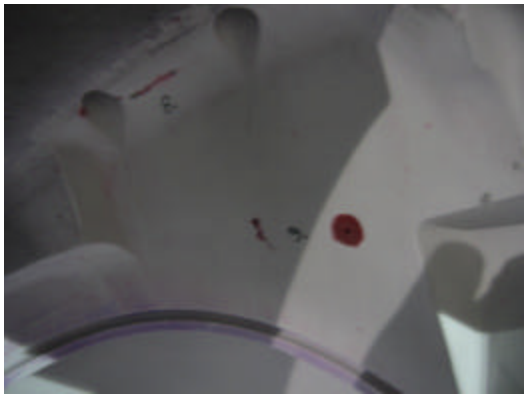
6. Linear w/cluster porosity, longest .800”, D-20



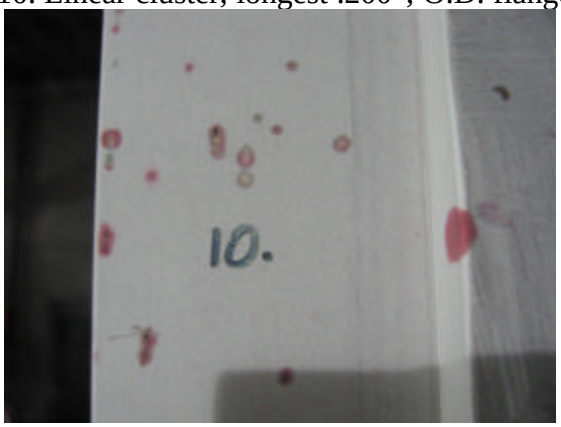
7. Linear (void), length .400”x .100”, D-79 (bottom of cutout sheet 4, zone D5)

8. Linear, length 2.00”, D-76 (between cooling holes sheet 9, zone D7)

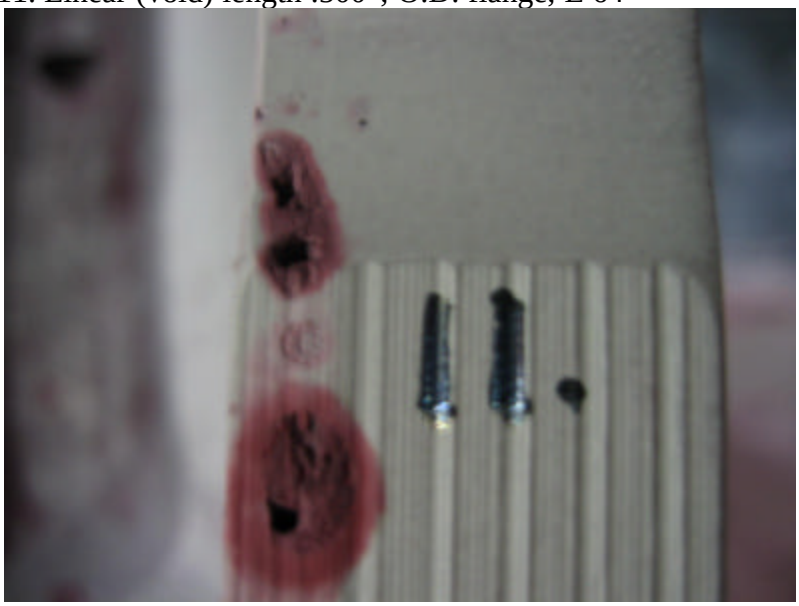
9. Linear, .600” / rounded .125”, D-75 (these are below VPI groove in high stress area)



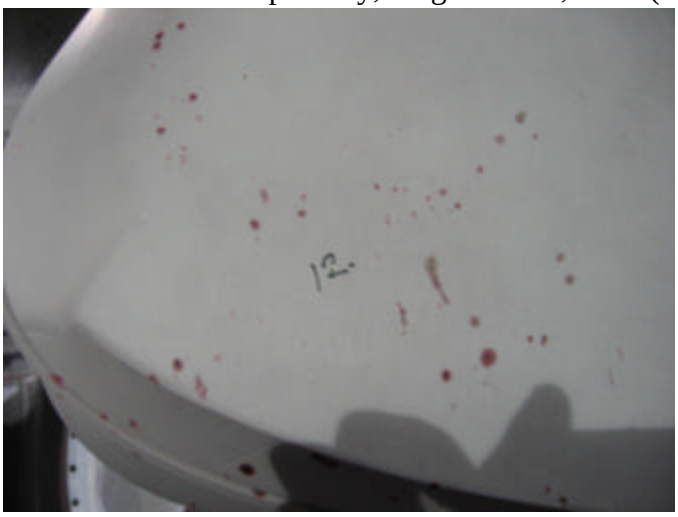
10. Linear cluster, longest .200”, O.D. flange on leg, D-72



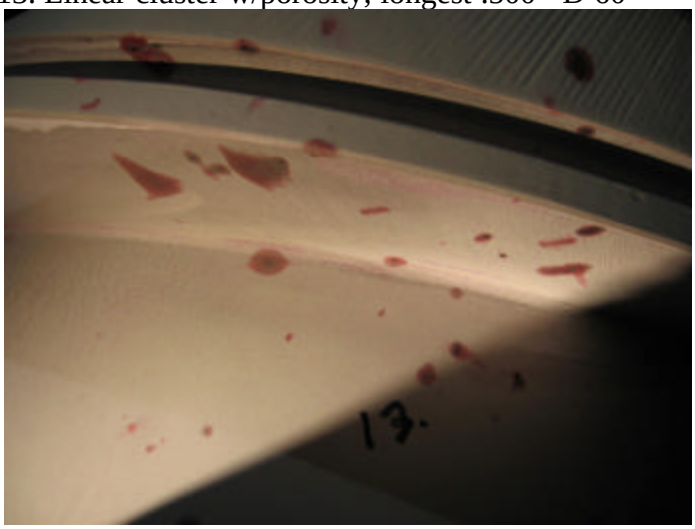
11. Linear (void) length .500”, O.D. flange, E-64



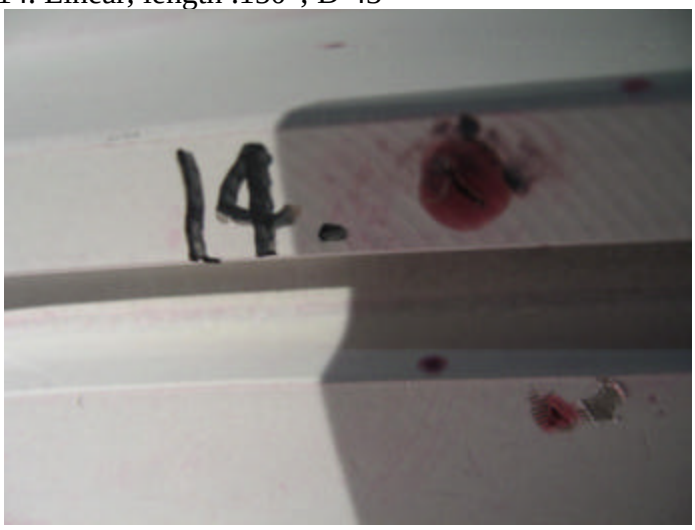
12. Linear cluster w/porosity, longest .800”, D-60 (outside of large wing surface)



13. Linear cluster w/porosity, longest .500” D-60



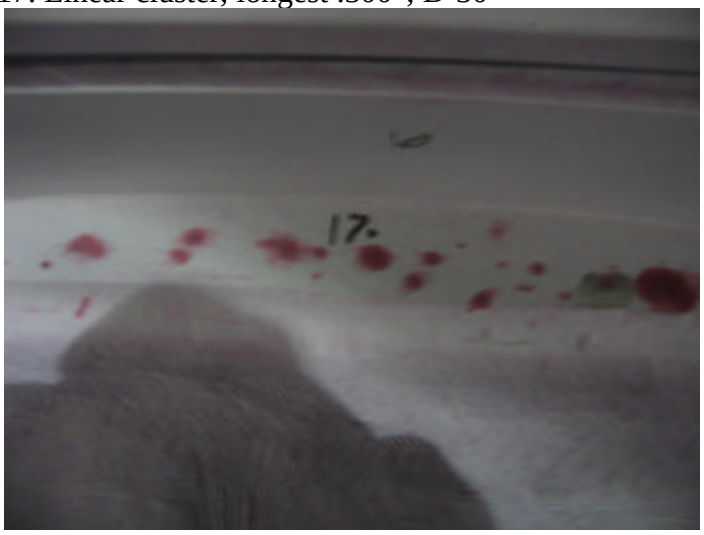
14. Linear, length .150”, D-43



15. Linear cluster, longest .200”, T-face, hole 48

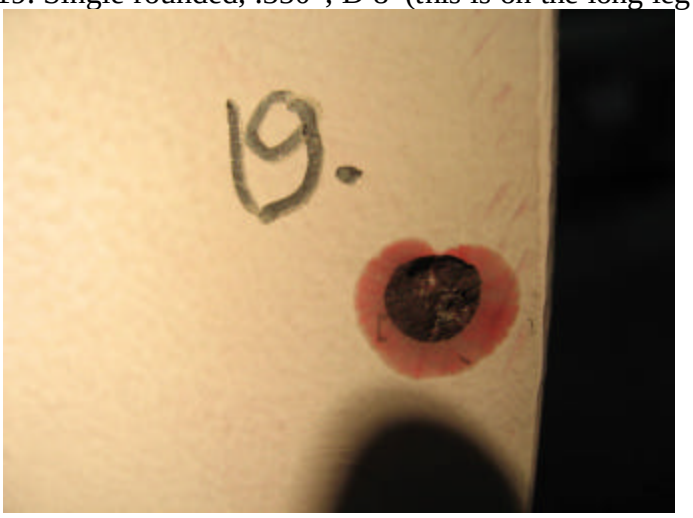
16. Linear, length .200”, T face, hole 61

17. Linear cluster, longest .300”, D-30



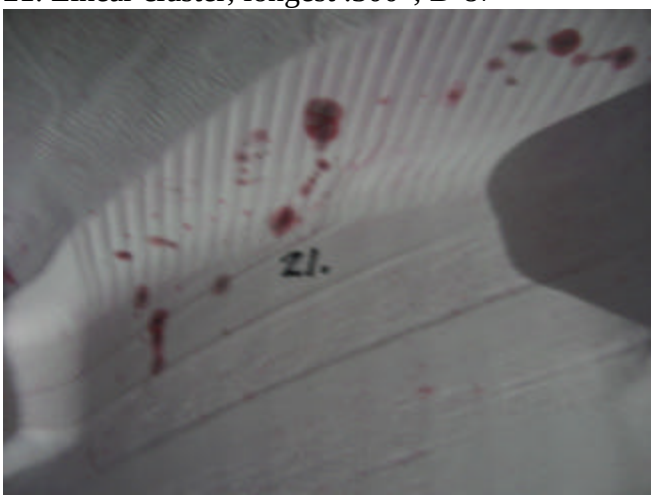
18. Linear cluster w/porosity, longest .200”, D-22

19. Single rounded, .350”, D-8 (this is on the long leg of the T near the face)

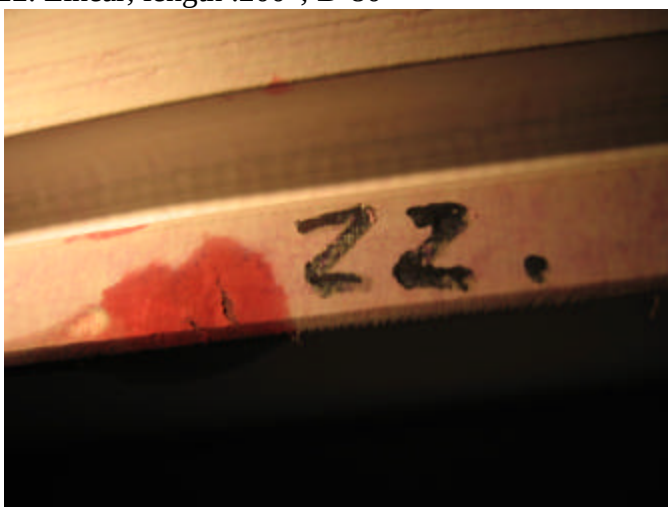


20. Linear, length .200”, D-5

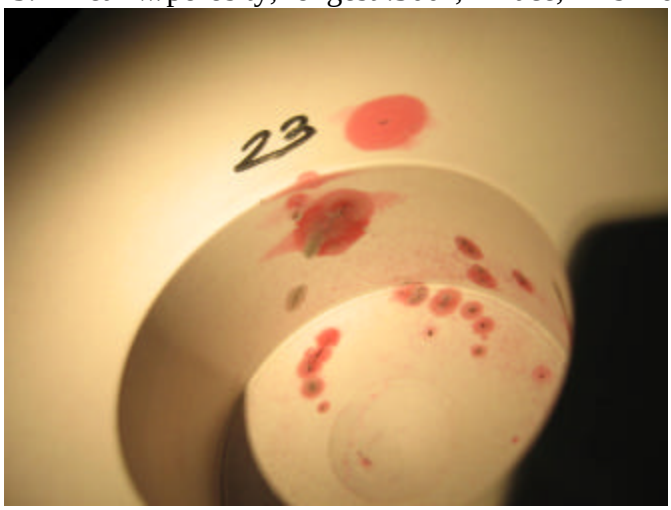
21. Linear cluster, longest .300”, D-87



22. Linear, length .200”, D-80

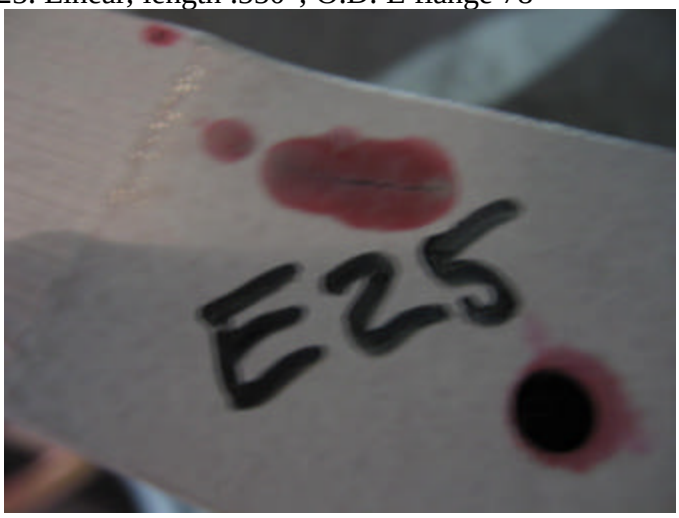


23. Linear w/porosity, longest .500”, D face, 2” blind hole



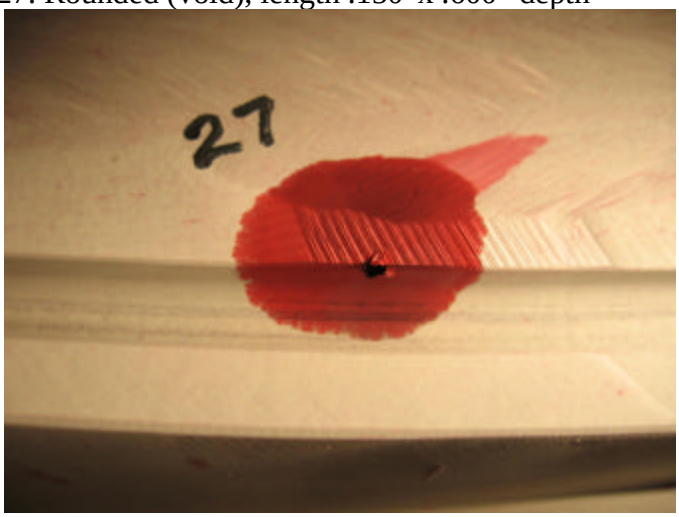
24. Linear, length 1.00”, O.D. E flange 79

25. Linear, length .550”, O.D. E flange 78

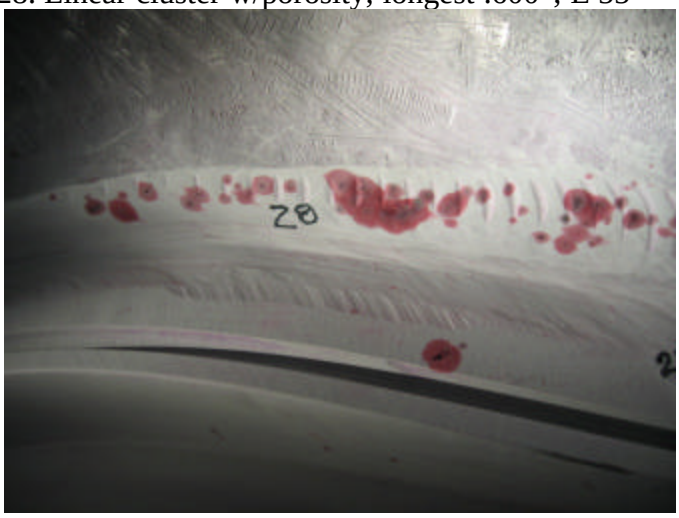


26. Linear cluster w/porosity, longest .200”, E-60

27. Rounded (void), length .150”x .600” depth

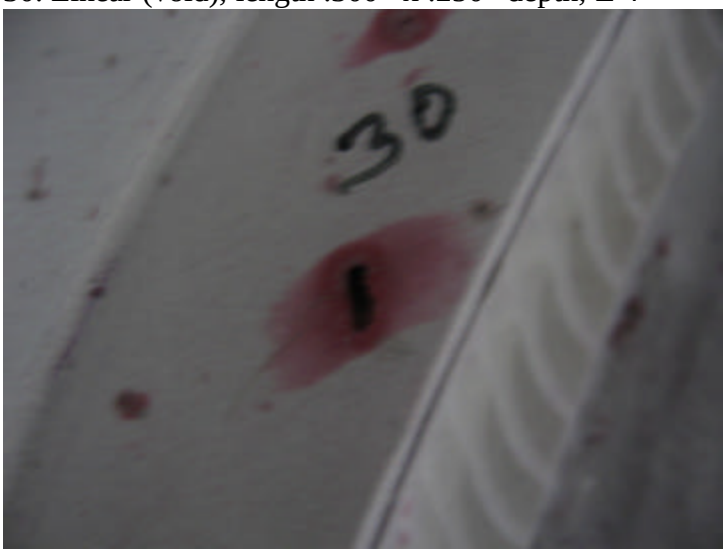


28. Linear cluster w/porosity, longest .600”, E-55

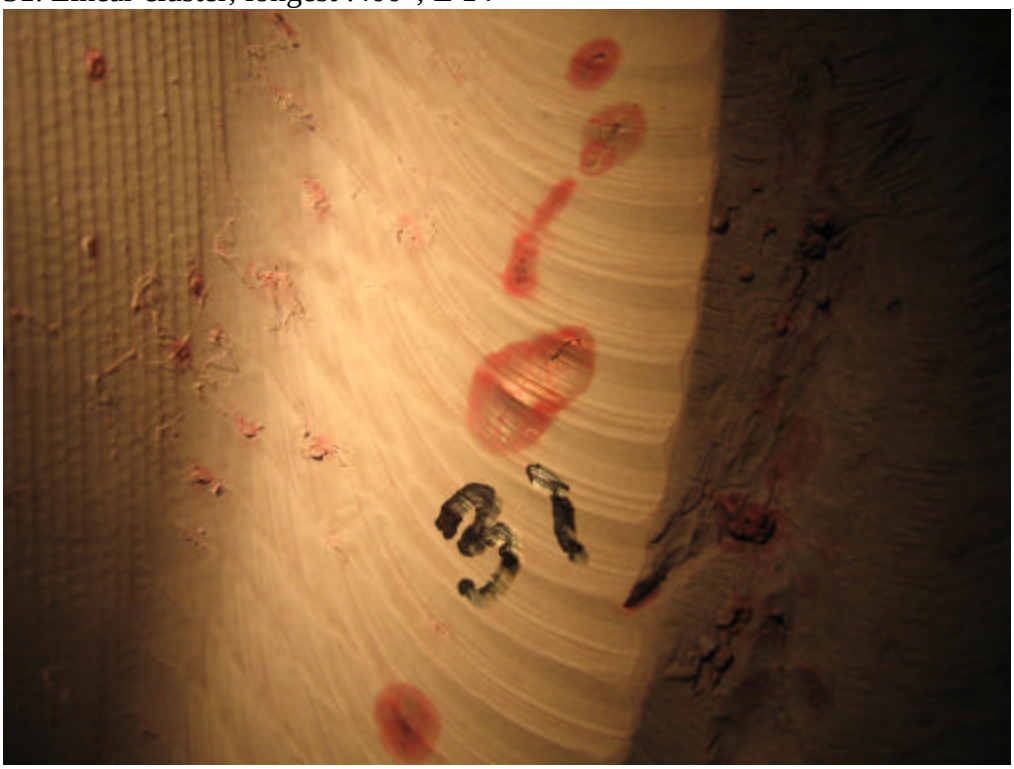


29. Linear cluster, longest .600”, E-49

30. Linear (void), length .300” x .250” depth, E-4



31. Linear cluster, longest .400”, E-14



Resolution for C5 DP Indications

	4/18/2006	4/19/2006
Indication #	**Initial Disposition**	**Final disposition**
1	Grind	As is
2	Grind	As is
3	Grind	grind
4	As Is	As is
5	better view	As is
6	better view	As is
7	Grind	As is
8	Grind	grind
9	As Is	As is
10	better view	As is
11	better view	As is
12	Grind	As is
13	better view	As is
14	grind but be careful to leave corner!	As is
15	grind	As is
16	grind	As is
17	better view	As is
18	grind	As is
19	better view	As is
20	grind	As is
21	grind	grind
22	grind	As is
23	grind large indication under 23.	As is
24	grind	As is
25	grind	As is
26	better view	As is
27	grind carefully	As is
28	grind	As is
29	as is	As is
30	better view	As is
31	grind	As is