



Corrective Action 1525
Carondelet Division
Corrective Action Type NCR
Date 1-9-06 Revised 1-20-06
CA Originator C. Ruud
Applies to: A-2 Coil

Description of Defect / Non-Conformance

A-2 Coil has excess stock in 2 areas.

Root Cause

Excess material is feed pads for risers. They were not removed during arc air operation. There is no work instruction for the A coil.

Corrective Action

Remove excess material at CAF. Verify repairs with VT, PT and mag perm inspections. See attached supplemental MTS and pictures showing the repaired areas.

Verification of Corrective Action

Inspect coil prior to shipping.

Preventive Action

Create work instruction for arc air process.

Verification Of Preventative Action

Work instruction completed and will be verified on A-4.

Estimated Completion Date

1-20-06

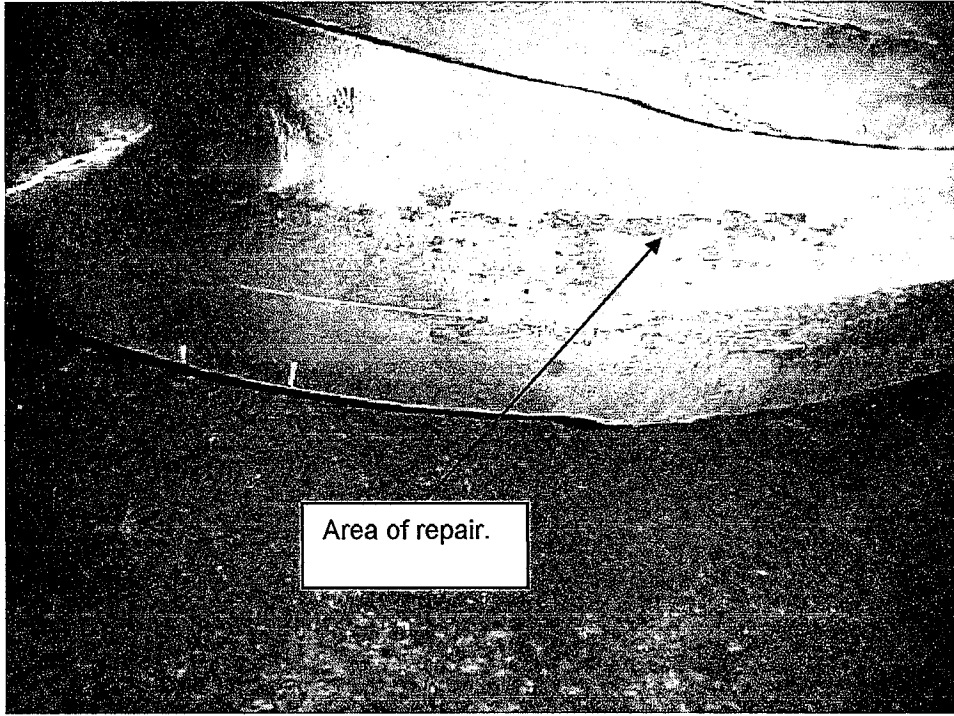
Actual Completion Date

1-16-06

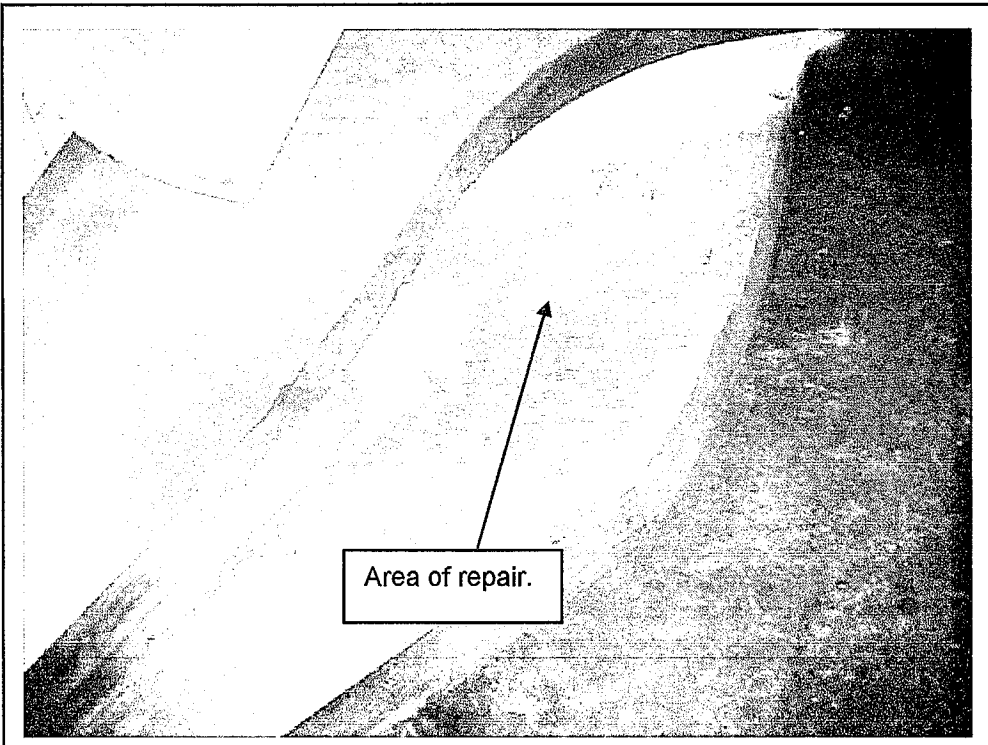
Signed: C. Ruud

A handwritten signature in black ink, appearing to be "C. Ruud", written over a horizontal line.

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



Area of repair.



Area of repair.

NOTES: Repair of A-2 Coil Casting

SUPPLEMENTAL ROUTING CARD

Date: 1-11-06

PART NUMBER: A-2 Coil

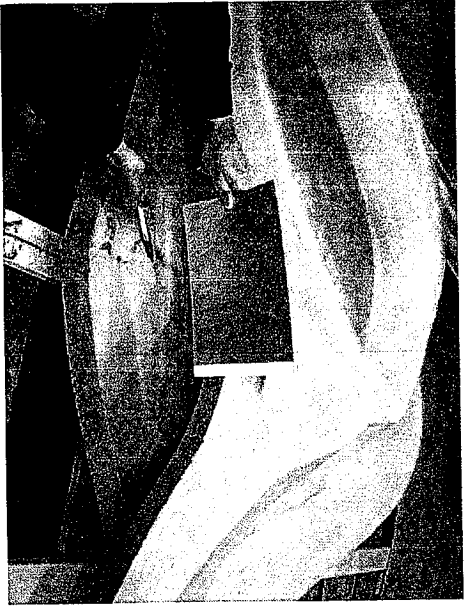
SERIAL NUMBER: A-2

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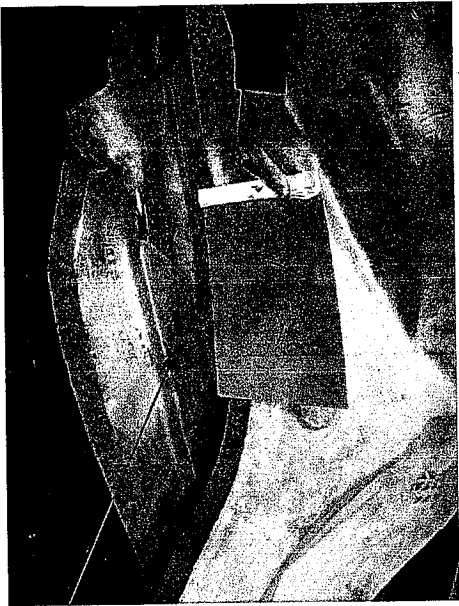
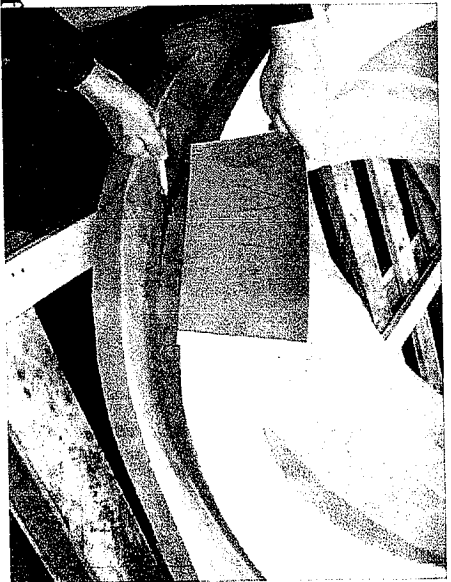
OPER NUMBER				OPERATOR SIGN/DATE
10	WELD SOP 0100 REV 7	Verify with Engineering before and after performing work. EXCAVATE AREA WITH EXCESS MATERIAL.	TD	1-12-06
20	GRIND GCHI SOP 0100R2	HAND GRIND AREA	DP	1-12-06
30	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.	DS	1-12-06
40	L.P. EXCAVATION CQP-300 REV 10	L.P. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA-LEVEL 1 FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING. IF OK CHECK HERE <input checked="" type="checkbox"/> AND GO TO STEP 40. IF REJECTED CHECK HERE _____ RETURN TO STEP 20.	LP - LEVEL II SPS	1-13-06
50	VISUAL INSPECTION CQP-500 REV 4	VISUALLY INSPECT ACCORDING TO ASTM A802 LEVEL 3 ALL CONDITIONS. IF OK CHECK HERE <input checked="" type="checkbox"/> . IF REJECTED MARK AND REPAIR BY GRINDING. DO NOT PROCEED UNTIL ACCEPTABLE. MUST BE PERFORMED BY LEVEL II in VT.	VT - LEVEL II	1-18-06
60	MAG PERM INSPECTION SOP MAG PERM 100, REV 1	PERFORM MAG PERM TESTING WITH SEVRIN GAUGE. ACCEPTANCE 1.02. CHECK THE ENTIRE SURFACE ON A 6" BY 6" GRID. REPORT RESULTS. USE A 6" SQUARE BLOCK TO INDICATE TEST LOCATIONS AND RECORD RESULTS. COMPLIANT AREAS WILL NOT BE MARKED. MARK NONCOMPLIANT AREAS WITH AN "X" FOR REPAIR. GRIND UNTIL ACCEPTABLE. OK CHECK HERE <input checked="" type="checkbox"/> AND GO TO STEP 70.	HRA 1-18-06	
70	PACK AND SHIP	PACKAGE AND SHIP TO MAJOR TOOL. MAKE SURE PROPER MARKINGS ARE PRESENT. PART NUMBER, SERIAL NUMBER A-2, AND FOUNDRY MARK, CERT NUMBER		1/18/06

See other side for pictures.

Attachment to Supplemental router for A-2
Differences between A-1 & A-2



Detail on A-1 was ground off



Detail on A-2 needs to be removed



NOTES: Repair of A-1 Coil Casting

SUPPLEMENTAL ROUTING CARD

Date: 1-11-06

PART NUMBER: A-1 Coil

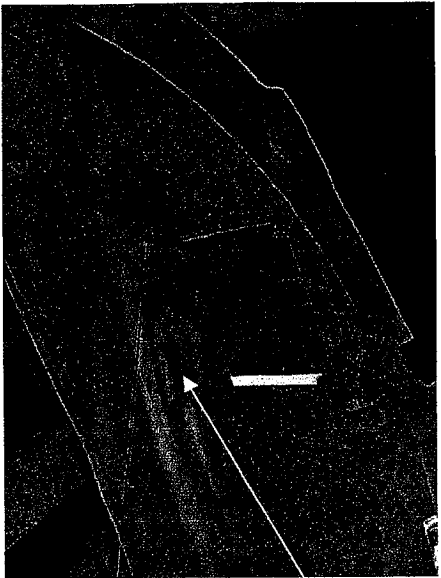
SERIAL NUMBER: A-1

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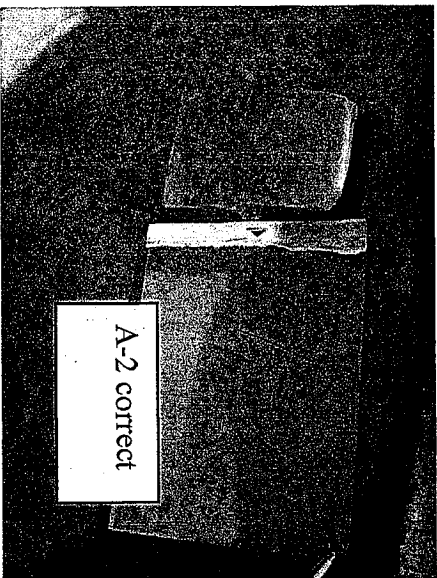
OPER NUMBER				OPERATOR SIGN/DATE
10	WELD SOP 0100 REV 7	Verify with Engineering before and after performing work. EXCAVATE AREA WITH EXCESS MATERIAL.	MW	1-12-06
20	GRIND GCHI SOP 0100R2	HAND GRIND AREA.	MS	1-12-06
30	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.	CS	1-13-06
40	L.P. EXCAVATION COP-300 REV 10	L.P. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA-LEVEL 1 FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING. IF OK CHECK HERE <input checked="" type="checkbox"/> AND GO TO STEP 40. IF REJECTED CHECK HERE _____ RETURN TO STEP 20.	LP- LEVEL II	JPS 1-13-06
50	VISUAL INSPECTION COP-500 REV 4	VISUALLY INSPECT ACCORDING TO ASTM A802 LEVEL 3 ALL CONDITIONS. IF OK CHECK HERE <input checked="" type="checkbox"/> IF REJECTED MARK AND REPAIR BY GRINDING. DO NOT PROCEED UNTIL ACCEPTABLE. MUST BE PERFORMED BY LEVEL II in VT.	VT- LEVEL II	KRA 1-17-06
60	MAG PERM INSPECTION SOP MAG PERM 100, REV 1	PERFORM MAG PERM TESTING WITH SEVRIN GAUGE. ACCEPTANCE 1.02. CHECK THE ENTIRE SURFACE ON A 6" BY 6" GRID. REPORT RESULTS. USE A 6" SQUARE BLOCK TO INDICATE TEST LOCATIONS AND RECORD RESULTS. COMPLIANT AREAS WILL NOT BE MARKED. MARK NONCOMPLIANT AREAS WITH AN "X" FOR REPAIR. GRIND UNTIL ACCEPTABLE. OK CHECK HERE <input checked="" type="checkbox"/> AND GO TO STEP 70.	KRA	1-17-06
70	PACK AND SHIP	PACKAGE AND SHIP TO MAJOR TOOL. MAKE SURE PROPER MARKINGS ARE PRESENT. PART NUMBER, SERIAL NUMBER A-1, AND FOUNDRY MARK, CERT NUMBER	CS	1/18/06

See Reverse side for pictures

Attachment to Supplemental router for A-1
 Differences between A-1 & A-2



This detail is acceptable,
 leave as is.



This is excess material, remove.



A-1
 See engineering for
 the material to be
 removed from this
 boss.

Detail D on A-1 - MTM to machine flat