

PPPL NONCONFORMANCE REPORT NO: 3644 **Open Date 03/31/06**

Status	2 - Disposition Needed		Trend	06-Workmanship/Needs Repair	
Department	NCSX		Division	NCSX Project	
Source/Org	VENDOR				
Item Dwg/Part#	SE141-116, r8 - MCWF C-4	Procurement #	S005242-F	Cost Center	9450 1*** 1404
RAP#	3209	Job Doc #	S005242-F	Vendor	Energy Industries of Ohio
RAP Title	NCSX - Modular Coil Winding Forms				

HoldTag Applied

Nonconforming Condition (include requirement(s) violated):

MCWF #4 - On unpacking MCWF C-4, an approximately 4" long linear indication, as shown in the attached photos, was noted. The indication is located at what appears to be a weld repair adjacent to Clamp Hole #1.

Lot Size Recd 1 **Sample Size Insp** 1 **Lot Rejected** **# Rejected** 1
Reported By Chrzanowski J **Validated By** Malinowski F **Validated Date** 03/29/06

Disposition: Rework* Repair* Use As Is* Return To Vendor* Scrap*

For rework or repair of vendor supplied equipments, fill in information below:

#Hours	_____	\$Est Labor	_____	\$G&A	_____
\$Material	_____	\$Burden	_____	\$Total	_____
Disposition By	_____	Date	_____		
Supervisor's Concur	_____	Date	_____		
Eng. Dept. Head Concur	_____	Date	_____		
WCO/Other	_____	Date	_____		
PQA/QC Mgr Dispos Concur	_____	Date	_____		
QC Field Verification By	_____	Date	_____		

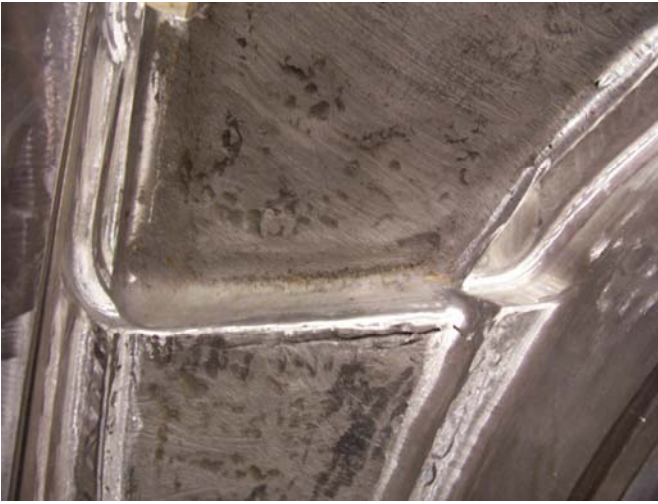
Distribution

Cog Heitzenroeder P
Insp Chrzanowski J
 Proj. Doc Control (when closed)

QC Files
 Malsbury J
 Boscoe J
 Nelson B
 Reiersen W
 Williams M
 Sutton L
 Tyrrell M
 Phelps C

NCR 3644 - MCWF C-4, approximately 4" long linear indication noted.





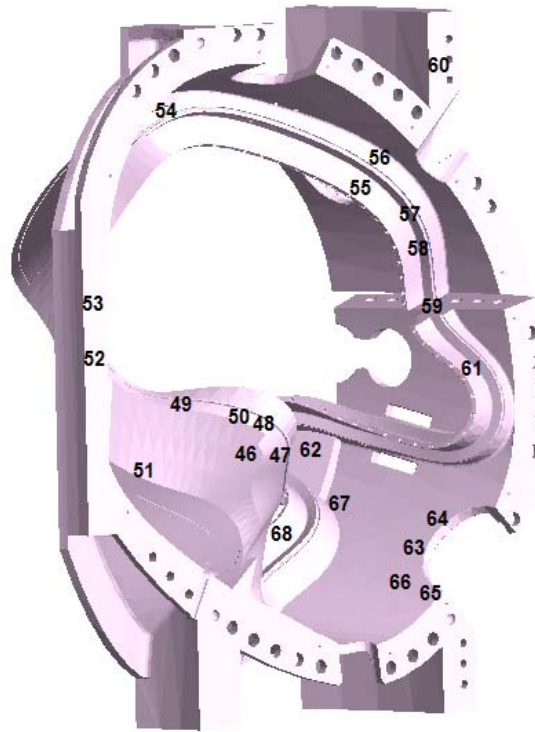
Indication after informal penetrant testing.

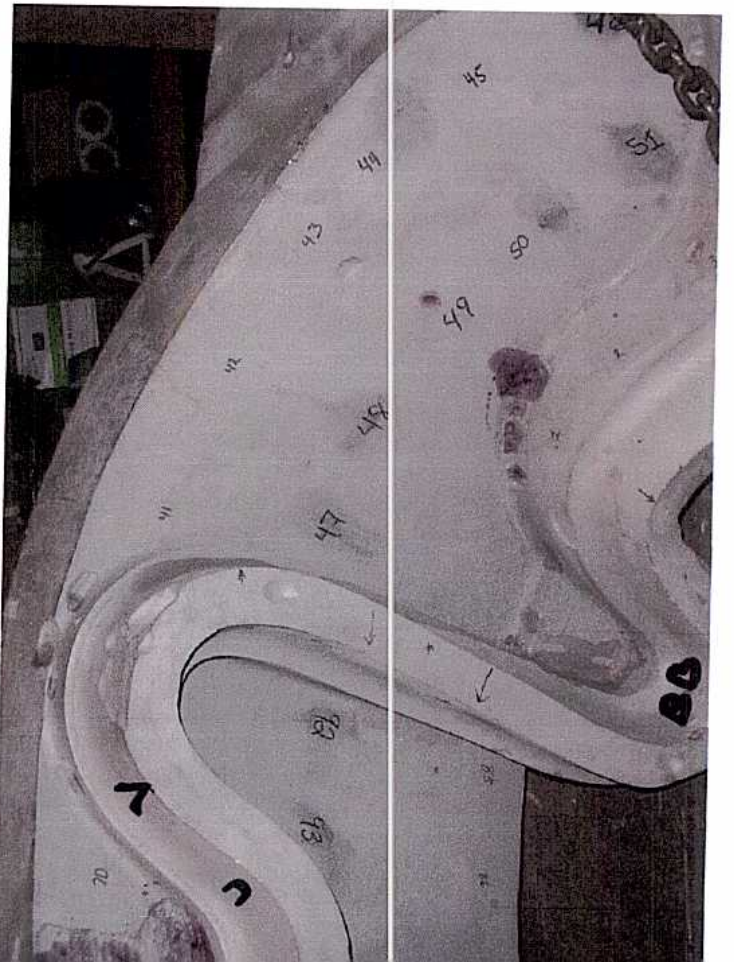
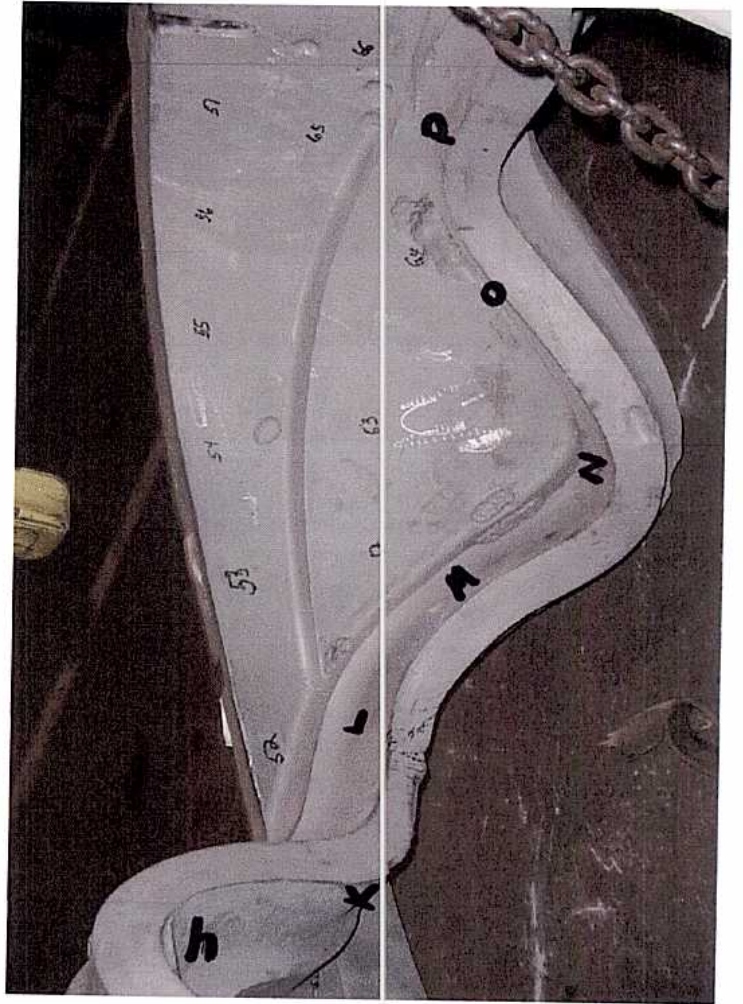
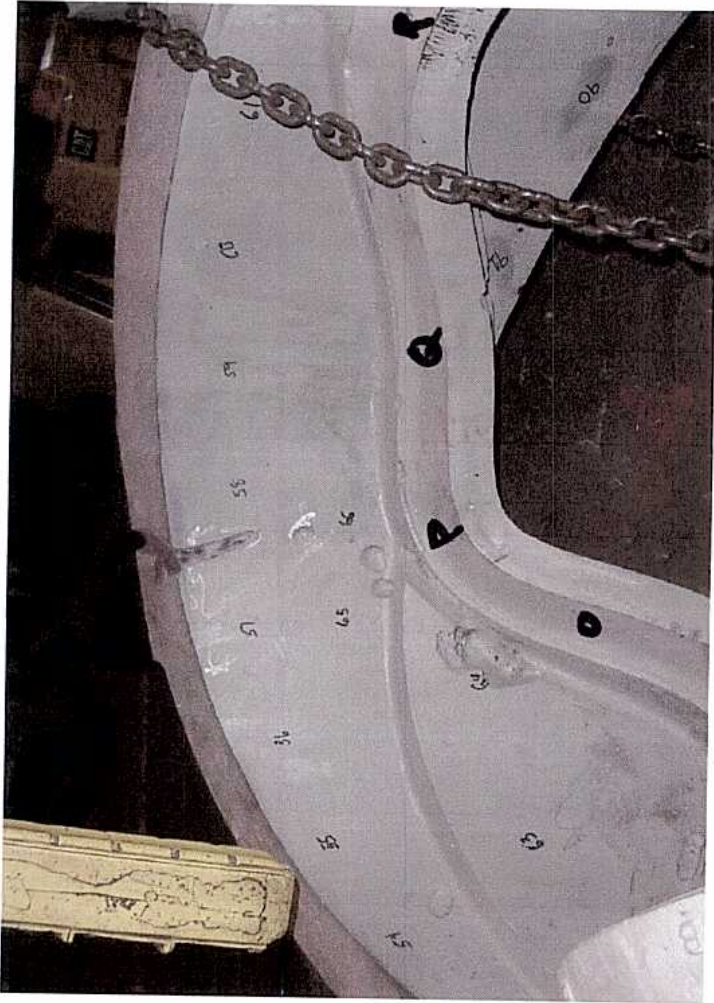


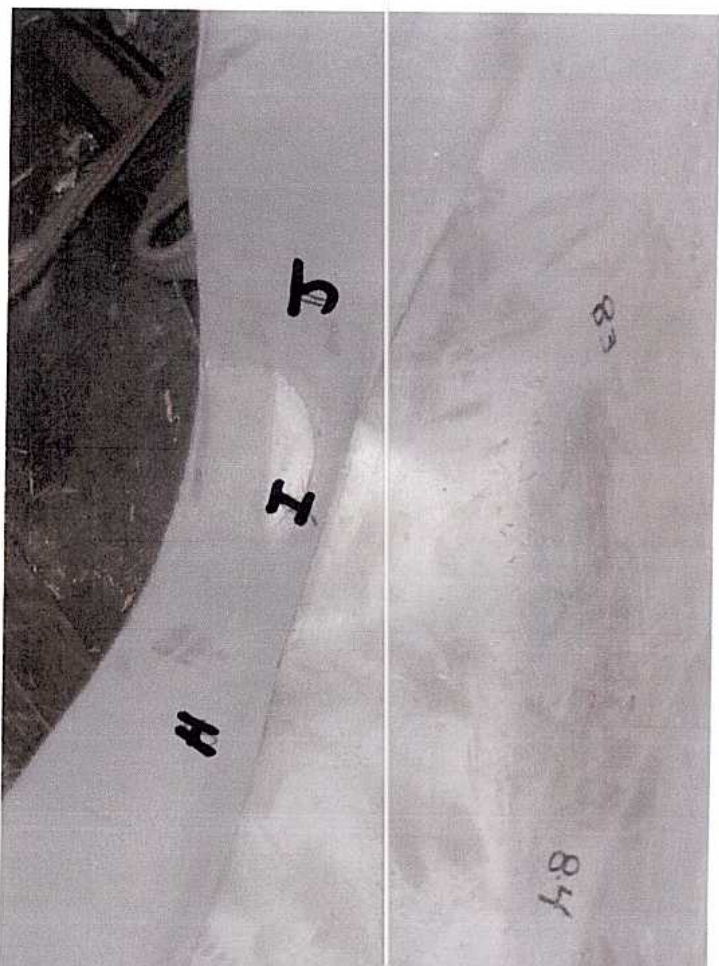
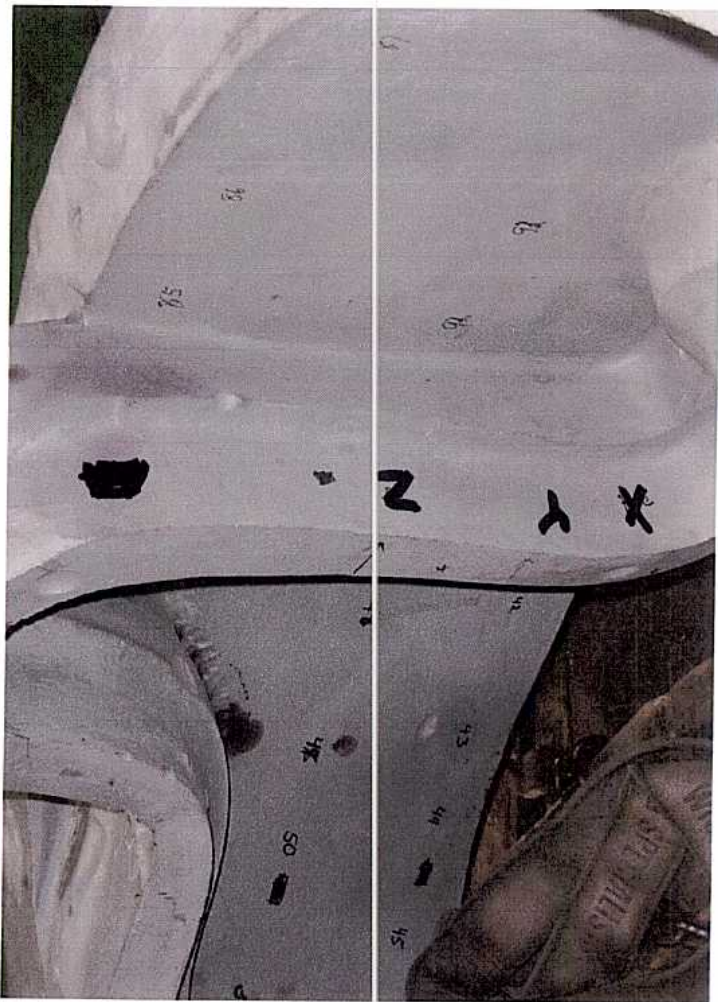
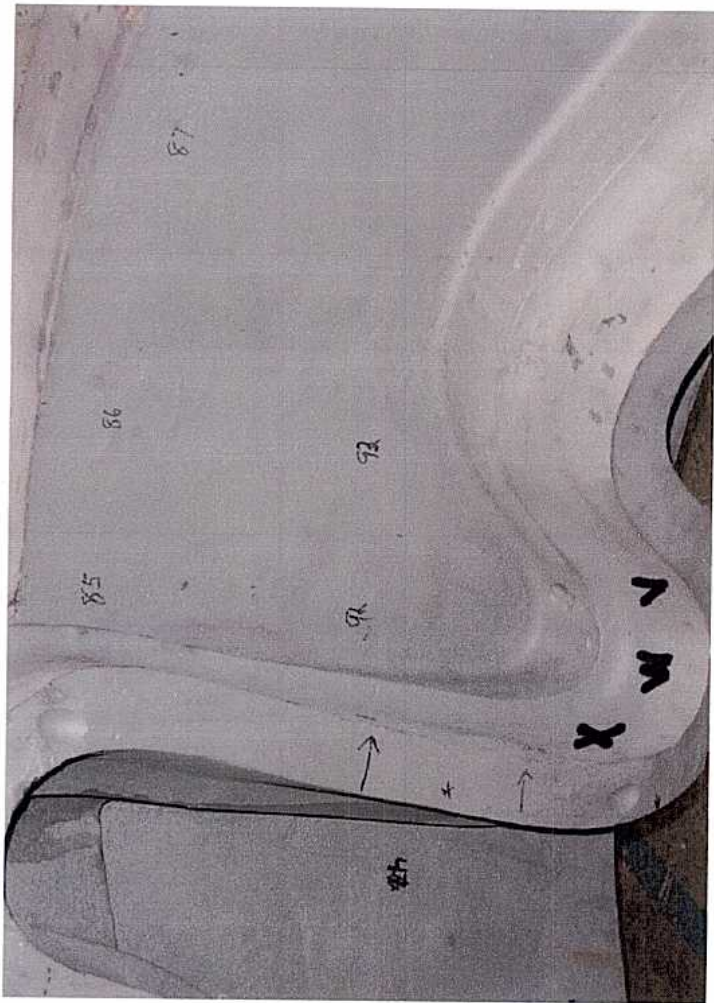
Coil C-4 Weld Map – Metal Tek

Map of all major welds exceeding 20% of wall, over 1 inch or over 10² inches

Front View







TEAM COOPERHEAT-MQS, INC.

CERTIFIED RADIOGRAPHIC INSPECTION REPORT

FORM 6061-RT- 002 Rev.2

5512 W. State St. Milwaukee, WI 53208 Tel:(414)771-3060 Fax:(414)771-9481 (800)818-6403 www.cooperheat-mqs.com

CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		8/13/2005	361-02454-2
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		21678	GAMMA
PROCEDURE SPECIFICATION ASTM E94-93	ACCEPTANCE CRITERIA MSS-SP-54-1999	SHEET <u>2</u> OF <u>6</u>	

PART NUMBER	Serial No	View	No Apparent Indications		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejection	Dross or Slag	Porosity	Lack of Fusion Gas Cracks	Hot Tears	Under cut	Surface	
MCWF-C-4	3536	✓									
	3637			R				3-4			
E.I.O. C040851	3839			R					R		
	3940			R				4			See Also V9/10
MS75920-4	4142			R				3			
RBK	4243			R					4-5		
RBK	4445	✓		OK					OK		
Re Test RBK	4546	✓		R				4			
	4748			R					R		
	4849			R					R		
	49-50-51	✓									
	5253	✓									
	53-54	✓									
	* 5455	✓									
	5556			R					2-3		
	5657	✓									
	57-58	✓									
	58-59	✓									
	5960	✓									
	6061	✓									
	6263	✓									
	6364			R					R		
	6566			R					3-4		
	6768			R					R		
	6869	✓									

NO. ACCEPTED	0	NO. REJECTED	1	MQS TECH. NO.	12970	SHT.	REV. 1
COMMENTS	* R.S. when returned for upgrade 40 Pins not present.			CUST. RSS NO.		SHT.	REV.
				REVIEWER	<i>John Petrucci</i>		
				CERTIFIED NDT LEVEL (RT)	RT II		

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CUSTOMER		DATE	WORK ORDER NO.
NAME METAL TEK INTERNATIONAL		10/09/2005	361-02596
ADDRESS 8600 COMMERCIAL BLVD		P.O. NUMBER	XRAY X
CITY PEVELY STATE MO ZIP 63070		22184	GAMMA
PROCEDURE SPECIFICATION	ACCEPTANCE CRITERIA	SHEET ____ OF ____	
ASTM E94-93	MSS-SP-54-1999*	NCSX-CSPEC-141-03-08 Ref Para. 3.1.1.7	

PART NUMBER	Serial No	View	No Apparent Indications		Incomplete Penetration		Shrinkage		Film Artifacts		REMARKS
			Acceptable	Rejected	Inclusion or Porosity	Lack of Fusion Gas Cracks	Hot Tears	Under Surface			
MCWF-C-4	4 (RI)	1-2	✓								
	* 4-5		✓								
E.I.O. C040851	* 5-6		✓								✓
	9-10		✓					1-2			
MS75920-4	15-16		✓					1			✓
	36-37		✓								✓
	38-39		✓								
	39-40		✓								
	41-42		✓								
	42-43		✓								✓
	45-46		✓							✓	
	47-48		✓								
	48-49		✓		✓						
	53-56		✓								
	63-64		✓					1-2			
	65-66		✓								✓
	67-68		✓								
	73-74		✓								
	75-76			R							
	78-79		✓								
	79-80		✓								
	83-84		✓		2-3						
	85-86		✓								
	92-93			R				R			
	96-97		✓								✓

NO. ACCEPTED	NO. REJECTED	MQS TECH. NO.	SHT.	REV.
0	1	12970		
COMMENTS		CUST. RSS NO.	SHT.	REV.
		REVIEWER		
		CERTIFIED NDT LEVEL (RT)		
		John Petroske RT II Exp. 01/08		