

Corrective Action Type FOR CASTING DISCONTINUITIES

Date 7/18/2005

CA Originator C. Ruud

Pattern Number: A-1 Coil

Description of Defect / Non-Conformance

98 major weld defects found in the A-1 coil casting.

Root Cause : Casting defects primarily due gas and shrink.

Corrective Action: Weld upgrade A1 casting. Welding will be performed following the approved procedure FOR WELDS <2" - WPS 10-SMAW-CF8MNMN MOD REV 1. FOR WELDS <8" - WPS 15-GMAW-CF8MNMN MOD REV 2.

Verification of Corrective Action: All repairs will be verified by the inspection method used to discover the original defect.

Preventive Action: We will use the xray information from the A1 casting to determine if changes are required to the tooling.

Verification Of Preventative Action: Radiograph A-2 coil and compare results.

Estimated Implementation Date: Prior to shipment.

Signed: CA Ruud

CC: EIO, Barry Craig, Joe Edwards, E.J. Kubick, Geoff Mergel, File