

Energy Industries of Ohio

Contract # S005242-F

Modular Coil Winding Forms

C-1 Documentation Package

**Part 1 – Metal Tek International
Casting Data Package**

10/28/2005

C-1 Documentation Package

List of Documents 10-4-2005

Doc #	Description	# Pages
A1	Coil C-1 certificate of conformance S73140-1 revised dated 7-21-05	1
A2	Coil C shim certificate of compliance dated 4-29-05	1
A3	Coil C-1 Shim Final Inspection Report dated 7-26-05	1
A4	Dimensional sketch of shim # 141-073 dated 3-31-05	2
A5	Traveler – MTS Coil C shim orig. dated 12-14-04 – signed/dated	6
A6	Radiographic shooting sketch C shim dated 3-10-05	2
A7	Original MTS for C shim dated 12-14-04	6
4a	MTR from MTK post preventive maintenance	1
4b	MTR from Wisconsin Centrifugal	1
5	Chemistry of weld material Lot # 3012668/82743	1
7	Westmoreland tensile test report @ -320F dated 4-19-05	1
8	St Louis Testing tensile test report @ room temperature dated 4-22-05 – corrected 6-15-05	2
8a	St Louis Testing tensile test report @ room temperature –retest of heat 27728 dated 5-12-05	1
8b	St Louis Testing tensile test report @ room temperature –retest of heat 27728 dated 6-1-05	1
9	St Louis Testing charpy test report of heat 27728 @ -320F dated 1-10-05	1
10	St Louis Testing charpy test report of heat 27728 @ room temperature dated 1-10-05	1
11	Westmoreland tensile test of weld material @ -320F dated 4-28-05	1
12	St Louis Testing tensile test of weld material @room temperature dated 4-22-05	1
13	St Louis Testing tensile test of weld material @ -320F dated 4/6/05	1
15	St Louis Testing tensile test of weld material @room temperature dated 2-28-05 – revised 3-2-05	2
16	Weld map list with mag perm results	11
17	Metal Tek final inspection report	1
18	RT reports – X-ray reader sheets from 1-19-05 & 3-19-05	8
18a	Radiographic Technique sheet	17
19	Heat treat chart – dated 12-28-04	1
19a	Heat treat chart stress relief dated 3-5-05	1
20	CA1219 – major welds dated 2-18-05	2
21	CA1226 – thru wall weld dated 2-18-05	2
22	CA1251 – second weld dated 3-22-05	1
22a	CA 1252 – welding – defects discovered during final LP dated 3/24/2005	1
22b	CA 1320 – Lack of test material Dated 7/5/2005	2
23	CA 1300 – test material- lack of ID dated 5-29-05	1
24	CA 1301 – test material lack of direction dated 5-29-05	1
24a	CA 1323 – CA for sulfur & phosphorus readings dated 7/26/05 + addendum dated 8/17/05	5
25	MTS C-1 Coil original dated 12-14-04 includes supplemental routing card on welding dated 3-21-05 – with dated sign-offs	10
26	Shipping release from EIO	1

Carondelet Division

8600 Commercial Blvd. - Pevely, MO 63070 USA
Phone: 636-479-4499 - Fax: 636-479-3399

C-1 Doc Package
Document A-1

Certificate of Conformance

ENERGY INDUSTRIES OF OHIO

Order Number PPPL-FP-LTS-2

Pattern MCWF-C1

ASTM CF8MNMN MOD

Revised Date 7/21/2005

Cert Number

S73140-1

Coil C-1, certification number S73140-1 was poured from three ladles known as heat numbers 27728, 27730 and 27731. Heat 27728 is actually a ladle containing material from heats 27728 and 27729. Cast on test bars located in each of the three zones were used for testing purposes. Test reports from St Louis Testing use Heat number 27728 for all test bar samples. Test bars did not have zone identification. Corrective action number 1300 was issued to correct.

Weld repairs were made using approved procedures and Lincoln material LMN 44/55, lot number 3012668/82743.

A shim, certification number S73220-1, for C-1 coil was poured from heat number 27728. No weld repairs were necessary.

We certify that we have complied in accordance with the drawings(s) and specifications(s) listed on the above purchase order. The articles furnished were made and/or processed from parts and/or materials in accordance with all applicable drawings(s) and specifications(s) pursuant to the afore mention purchase order except as noted by corrective actions.

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

Superior Quality Engineered Metal Products

www.MetalTekInt.Com

Carondelet Division

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Certificate of Conformance

C-1 Doc Package
Document A-2

ENERGY INDUSTRIES OF OHIO

Order Number PPPL-FP-LTS-2

Pattern SE-141-073 COIL C SHIM

Alloy CF8MNMnMOD

Revised Date 4/29/2005

Cert Number

S73220-1

A shim for C-1 coil was poured from heat number 27728. No weld repairs were necessary. No testing for mechanical properties was performed.

We certify that we have complied in accordance with the drawings(s) and specifications(s) listed on the above purchase order. The articles furnished were made and/or processed from parts and/or materials in accordance with all applicable drawings(s) and specifications(s) pursuant to the afore mention purchase order except as noted by corrective actions.

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

Superior Quality Engineered Metal Products

www.MetalTekInt.Com



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8600 Commercial Blvd. - Pevely, MO 63070 USA
Phone: 636-479-4499 - Fax: 636-479-3399

Final Inspection Report

Customer Name: ENERGY INDUSTRIES OF OHIO
Pattern: SE-141-073 COIL C-1 SHIM

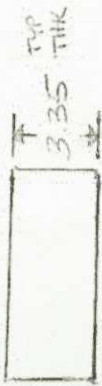
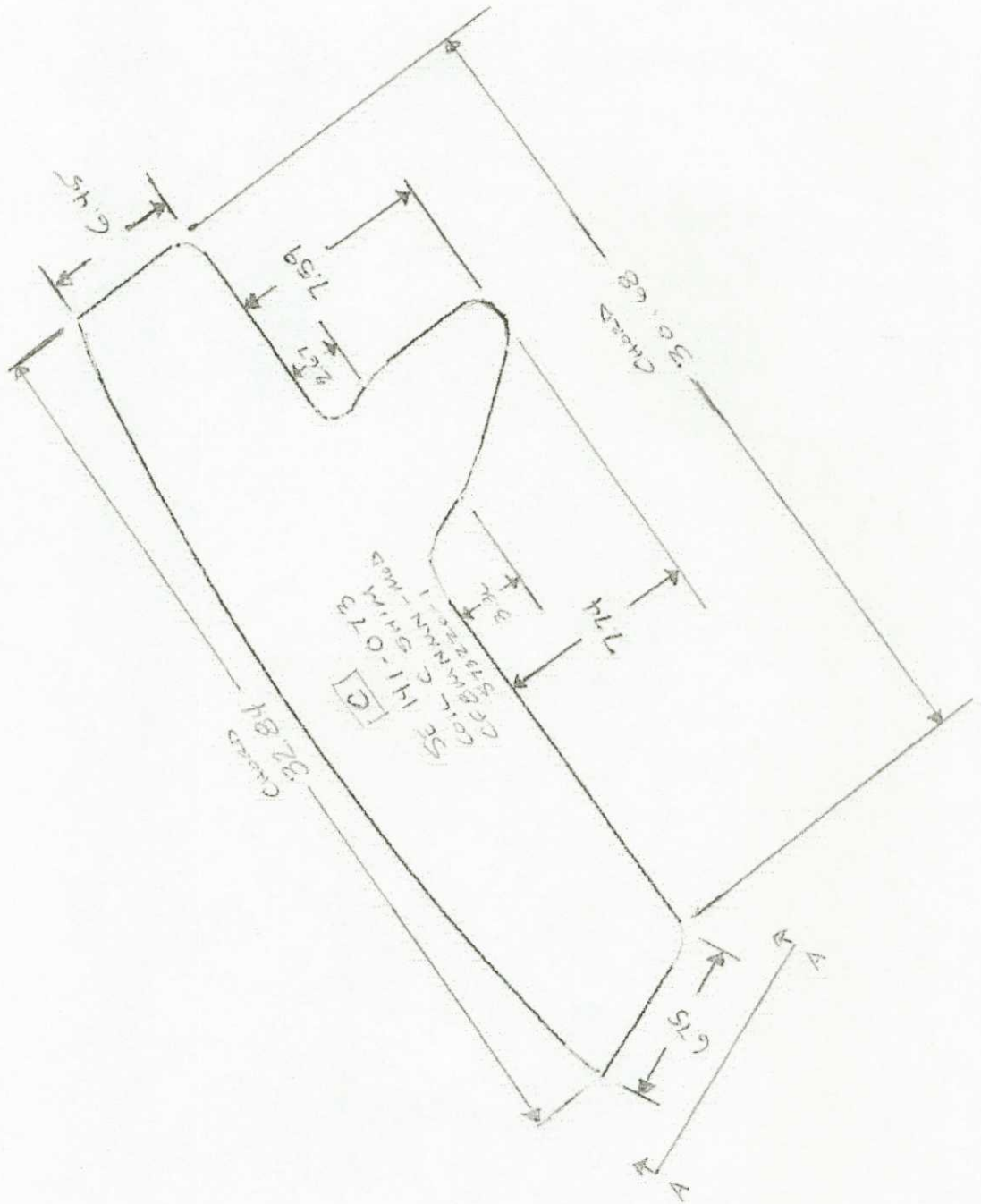
Order Number: PPPL-FP-LTS-2 Revised 7/26/05

ASTM Metal CF8MNMN MOD Date 7/26/2005

Type Description	Cert Number	Procedure	Acceptance Criteria	Actual
Liquid Penetrant	S73220-1	CQP - 300 Rev 9	ASTM A903 Level II	Acceptable
Mag Perm	S73220-1	SOP Mag Perm 100 Rev 1	<1.02	Acceptable
Radiographic	S73220-1	CQP - 401 Rev 5	MSS SP 54	Acceptable
Visual	S73220-1	CQP - 500 REV 4	ASTM A802 LEVEL 2	Acceptable

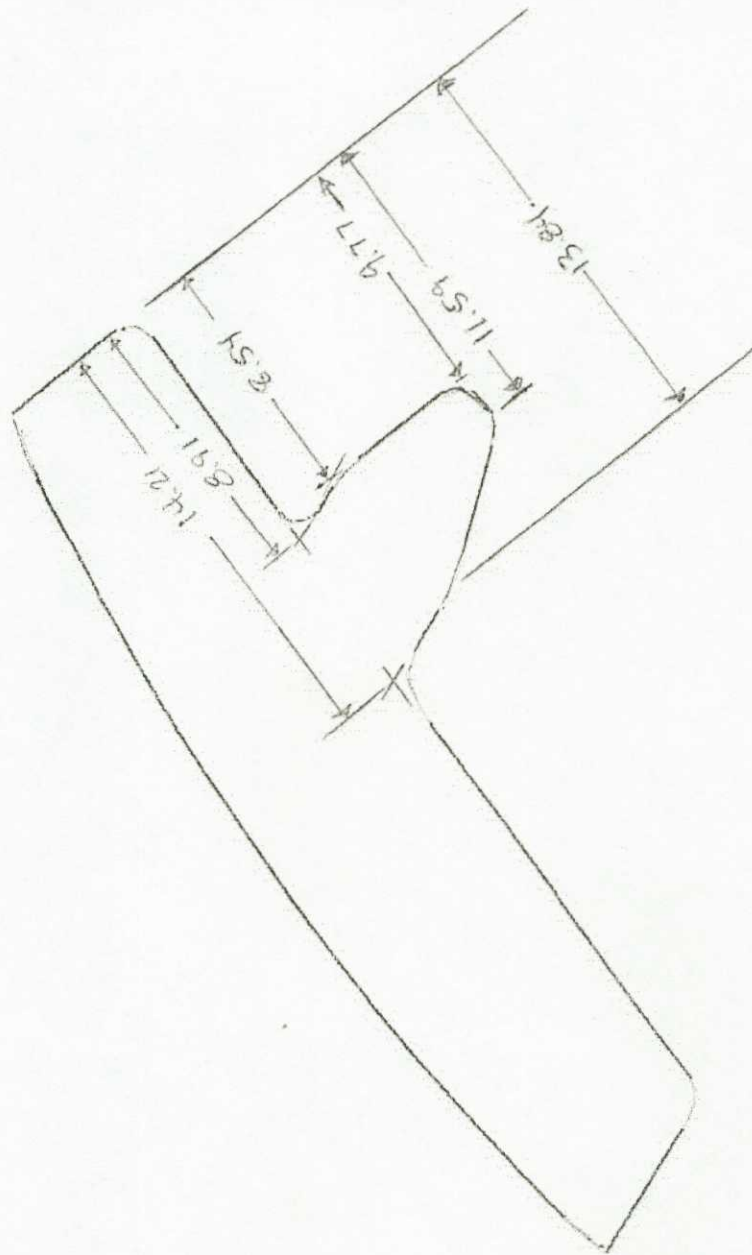
Liquid Penetrant
Technician: Kevin Anderson
ASNT Level II

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager



SECT A-A

SHIM SE 141-073
SKETCH 03/3/05
Kuni Hori



PAGE 2 OF 2
SHIM SE 141-073
SKETCH 03/31/05

Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Coill C Shim-1

CO# 40851, Pattern SE 141-073 S73220-1 Dated December 14, 2004 Revision: Original Page 6 of 6 Dated Issued: 12-14-04

420	GRIND GCIII SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 420. REPEAT UNTILL COMPLIANCE IS ACHIEVED.		NA	
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF MAG PERM STEP. EIO NOTIFIED ON <u>3/23/05</u> DCMA NOTIFIED ON <u>3/23/05</u>		Q ENG OR QA MGR	<u>Chk</u>
430	FINAL 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. OK CHECK HERE _____ AND GO TO STEP 470. IF REJECTED CHECK HERE _____			<u>3/30/05 Chk</u>
440	GRIND GCIII SOP 0100 REV 2	HAND GRIND WITH SUITABLE CONE OR OTHER SIMILAR GRINDER AS REQUIRED TO ENSURE REMOVAL OF MATERIAL TO ACHIEVE MAG PERM REQUIREMENT. CIRCLE AREA REMEDIATE FOR RETEST.		NA	
450	RETEST MAG PERM SOP MAG PERM 100, REV 1	RETEST MAG PERMEABILITY AT FAILED TEST POINTS. MARK NONCOMPLIANT AREAS WITH AN "X" FOR REPAIR. ACCEPTANCE 1.02. IF OK CHECK HERE _____ IF REJECTED CHECK HERE _____ RETURN TO STEP 450			
460	PHOTOGRAPH	TAKE DIGITAL PICTURES.			<u>Chk</u>
470	AUDIT REVIEW	PROCESS DOCUMENT TO PROGRAM MANAGER FOR COMPLIANCE AUDIT.			<u>3/31/05</u>
480	DOC. REVIEW	REVIEW DOCUMENTS AS REQUIRED IN CAF CHECKLIST. ALL DOCUMENTS NOTED TO BE ACCESSIBLE FOR AUDITING. (SHIPPER, C OF C, M.T.R., M.T.S., INSPECTION REPORT, X-RAY READER SHEETS AND HEAT TREAT CHARTS)			<u>3/31/05</u>
NOTICE	RELEASE FROM EIO	PROVIDE DOCUMENTS TO EIO. SENT ON <u>3/30</u> BY <u>Chk</u> RECEIVED RELEASE FROM EIO ON <u>3/30/05</u>		Q ENG OR QA MGR	<u>Chk</u>
490	PACK AND SHIP	PACKAGE, AND SHIP TO MAJOR TOOL.			<u>3/31/05</u>
1000	REVISION HISTORY	ORIGINAL 12-14-04.		Shipped	
				CARUUD	

Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Coill C Shim-1

CO# 40851, Pattern SE 141-073 S73220-1 Dated December 14, 2004 Revision: Original Page 5 of 6 Dated Issued: 12-14-04



330	FINAL L.P. CQP 0300 REV 10	MUST BE PERFORMED BY LEVEL II in VT. FINAL L.P. 100% OF COMPONENT. ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA- LEVEL I FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING. IF OK CHECK HERE <input checked="" type="checkbox"/> WASH AND SEND TO STEP 410. IF REJECTED CHECK HERE _____	LP - LEVEL II KHA 3-30-05
340	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING FINAL PENETRANT INSPECTION.	N/A CA-3-30-05
350	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903.	LP - LEVEL II
370	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING. USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE. FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES _____, REPORT SENT BY _____ DATE _____ DEFECTS < 10% _____ SIGN BY QA ENG.	
380	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED FOR WELDS < 2" - WPS 10-SMAW-CF8MMNMN MOD REV 1 FOR WELDS < 8" - WPS 15-GMAW-CF8MMNMN MOD REV 2	
390	GRIND GCHI SOP 0100 REV 2	HAND GRIND WELDS.	
400	L.P. WELDS CQP 0300 REV 10	L.P. WELD REPAIRS ACCEPTANCE PER ASTM A903. IF OK CHECK HERE _____ WASH AND SEND TO STEP 460. IF REJECTED CHECK HERE _____ AND RETURN TO STEP 390.	LP - LEVEL II
	REPEAT	REPEAT STEPS 390 TO 410 AS REQUIRED TILL WELDS CLEAR FINAL LIQUID PENETRANT INSPECTION. DOCUMENT REWORK ON A SUPPLEMENTAL MTS	QA/ENG.
410	TEST MAG PERM SOP MAG PERM 100, REV 1	TEST MAG PERMEABILITY REPAIR AREAS. RECORD ON WELD MAP LIST. TEST AT LEAST 5 POINTS PER WELD. ACCEPTANCE 1.02. IF OK CHECK HERE _____ AND GO TO STEP 430.	NA

Energy Industries of Ohio
 Manufacturing and Test Sequence (MTS) Coill C Shim-1
 CO# 40851, Pattern SE 141-073 S73220-1 Dated December 14, 2004 Revision: Original Page 4 of 6 Dated Issued: 12-14-04

260	L.P. WELD CQP 0300 REV 10	L.P. WELD REPAIRS ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA-LEVEL 2. IF OK CHECK HERE _____ WASH AND SEND TO STEP 300. IF REJECTED CHECK HERE _____ AND RETURN TO STEP 220.	LP - LEVEL II	NA
	REPEAT	REPEAT STEPS 220 TO 260 AS REQUIRED TILL CLEAR THROUGH VISUAL INSPECTION & PENETRANT INSPECTION. DOCUMENT REWORK ON A SUPPLEMENTAL MTS	QA ENG.	
270	TEST MAG PERM SOP MAG PERM 100, REV 1	TEST MAG PERMEABILITY REPAIR AREAS. RECORD ON WELD MAP LIST. TEST AT LEAST 5 POINTS PER WELD. ACCEPTANCE 1.02. IF OK CHECK HERE _____ AND GO TO STEP 290. IF REJECTED CHECK HERE _____		
280	GRIND GCHI SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 270. REPEAT UNTILL COMPLIANCE IS ACHIEVED.		
290	CAF X-RAY DEFECTS REPAIRED BY WELDING CQP 401 REV 5	X-RAY PER TECHNIQUE: To be determined. USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT - LEVEL II	
300	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE _____ AND SEND TO STEP 310. REJECTED CHECK HERE _____ MARK UP DEFECTS AND SEND THE CASTING TO STEP 200.	RT - LEVEL II	
	REPEAT	REPEAT STEPS 200 TO 300 AS REQUIRED TILL WELDS CLEAR X-RAY. DOCUMENT REWORK ON A SUPPLEMENTAL MTS	QA ENG.	
310	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.		NA
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF VISUAL AND LP STEPS. EIO NOTIFIED ON 7/23/05 DCMA NOTIFIED ON 8/23/05	Q ENG OR QA MGR	CA
320	FINAL VISUAL INSPECTION CQP-500 REV 4	VISUALLY INSPECT 100% of COMPONENT ACCORDING TO ASTM A802 LEVEL 2 ALL CONDITIONS. IF OK CHECK HERE <input checked="" type="checkbox"/> IF REJECTED CHECK HERE _____ MARK AND REPAIR AT STEP 340.	VT - LEVEL 1	3/30/04 R. Garcia-Soria

Energy Industries of Ohio
 Manufacturing and Test Sequence (MTS) Coill C Shim-1
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170	CAP X-RAY CQP 401 REV 5	X-RAY PER TECHNIQUE: To be determined. USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT - LEVEL II RBK	3-10-05
180	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE <input checked="" type="checkbox"/> AND SEND TO STEP 300. 190 then to 310 OK REJECTED CHECK HERE <input type="checkbox"/> MARK UP DEFECTS AND SEND THE CASTING TO STEP 200.	RT - LEVEL II RBK	3-10-05
190	LAYOUT	INSPECT CASTING TO VERIFY DIMENSIONS. THIS MAY BE PERFORMED BEFORE OR AFTER STEP 180. NO BIP AVAILABLE MADE REVISION SCHEMATIC DATE _____ RELEASED _____ (ENGINEER ONLY)	Kobrin 3/31/05	
200	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING RADIOGRAPHY.	NA	
210	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA- LEVEL 2.	LP - LEVEL II	
220	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING, USE SCALF, IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE, FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES _____, REPORT SENT BY _____ DATE _____ DEFECTS < 10% _____ SIGN BY QA ENG.		
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF WELD STEP EIO NOTIFIED ON _____ DCMA NOTIFIED ON _____	Q ENG OR QA MGR	
230	QA APPROVAL, HOLD POINT	QA TO APPROVE ELECTRODE PRIOR TO USE. PROCEDURE USED: _____ MATERIAL USED: _____ QUALITY ENG. Name: _____ Date: _____		
240	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED. FOR WELDS < 2" - WPS 10-SMAW-CF8MMN MOD REV 1 FOR WELDS < 8" - WPS 15-GMAW-CF8MMN MOD REV 2		
250	GRIND GCHI SOP 0100R2	HAND GRIND WELDS.		

Handwritten notes:
 12/20/04
 3/31/05
 (Signature)

Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Coill C Shim-1
Dated December 14, 2004 Revision: Original

Page 2 of 6
Dated Issued: 12-14-04

90	GRIND GSA SOP 0100R3 GCHI SOP 0100R2	SWING GRIND TO REMOVE RISER REMAINS AND FLASH IF REQUIRED. CHIP AND HAD GRIND SURFACE OF PART AS REQUIRED.		MA B.C 1-09-05
100	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.		M1W 1-7-05
110	VISUAL INSPECTION CQP-500 REV 4	VISUALLY INSPECT 100% OF COMPONENT ACCORDING TO ASTM A802 LEVEL 3 ALL CONDITIONS. IF OK CHECK HERE _____ IF REJECTED CHECK HERE <u>X</u> MARK AND REPAIR AT STEP 130.		VT - LEVEL IV Pmkh 1-7-05
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF LP STEP. EIO NOTIFIED ON <u>1/3/05</u> DCMA NOTIFIED ON <u>1/3/05</u> <i>again on 1/4/05</i> <i>for as early as 1/7/05</i>		Q ENG OR QA MGR <i>Chad</i>
120	100% L.P. CQP-0300 REV 10	L.P. 100% OF COMPONENT. ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA- LEVEL 2. IF OK CHECK HERE _____ IF REJECTED CHECK HERE <u>X</u> MARK AND REPAIR AT STEP <u>130</u> .		LP - LEVEL II <i>Chad</i> 1/7/05
130	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING 100% VISUAL AND LP INSPECTION. DEFECTS GROUND ON ONLY NO WELDING REQUIRED		<i>Chad</i> 3/9/05
140	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA- I-LEVEL 2.		LP - LEVEL I <i>Chad</i> ↓
150	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.		M1W 3/9/05
160	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE, FILE WITH QA. USE YELLOW MARKER. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES _____, REPORT SENT BY _____ DATE _____ DEFECTS < 10% _____ SIGN BY QA ENG.		N/A ↓
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF XRAY AND LAYOUT STEPS. EIO NOTIFIED ON <u>3/9/05</u> DCMA NOTIFIED ON <u>3/9/05</u>		Q ENG OR QA MGR <i>Chad</i>

Chad
1/7/05
1/7/05

Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Coils C Shim-1
Dated December 14, 2004 Revision: Original

CO# 40851, Pattern SE 141-073 S73220-1 Dated December 14, 2004 Revision: Original Page 1 of 6 Dated Issued: 12-14-04

OPER. #	STATION	DESCRIPTION OF PROCESS	Name	Date
10	QUALITY RELEASE	REVIEW AND APPROVE MTS. RECEIVED APPROVAL FROM EIO ON 12/15/04 FROM <u>Patrick</u> SIGNED QUALITY MANAGER	<u>ADR</u>	12/15/04
20	PATTERN NPAT SOP 0100REV2	APPLY APPROPRIATE PART NUMBER, SERIAL NUMBER, FOUNDRY MARK, TO THE PATTERN.	<u>ADR</u>	12/17
30	MOLD MOLD SOP 0400 REV 8 CALIBRATION PER MOLD SOP 0900 REV 5 PREPARATION PER MOLD SOP 1100R2/1200R2/1300R1 SAND TESTING PER MOLD SOP 1400R2/1500R3/1600R2	MOLD PER WORK INSTRUCTIONS IN MAPICS ROUTING AND SOPS REFERENCED. ENGINEER OF RECORD ROGER BROMAN, CONSULT ON MOLD-RELATED CONCERNS. MOLD MATERIALS REQUIRED PER MAPICS BOM. NOTIFY ENGINEER OF ANY SUBSTITUTIONS.	<u>ADR</u>	12-17-04
40	POUR MELT SOP 0100R5 MELT SOP 0700R2 MELT SOP 0600R2	METAL MUST BE AOD REFINED OR AOD INGOT. VIRGIN METAL ADDITIONS ALLOWED. RECORD POURING TEMPERATURE: <u>2250</u> CASTING POURED AT: <u>5:30 AM</u> DATE: <u>12/19/04</u> HEAT #'S: <u>2728, 2729, 2730, 2731</u> ELAPSED POUR TIME: <u>N/A</u> KEEL BLOCKS POURED: <u>YES</u> Sample from ladle to be analyzed for final chemical analysis and reported on material certifications. Sample Taken by: <u>JG</u> Analyzed: <u>J. Galetke</u> Date: <u>12-19-04</u>	<u>ADR</u>	
50	MELT SOP 0800R2	SHAKEOUT	<u>ADR</u>	12-21-04
60	ARC RISE SOP 0100R1	REMOVE RISERS AS DIRECTED BY SUPERVISOR.	<u>ZAB</u>	12-21-04
70	HEAT TREAT HEAT SOP 0103R5	SOLUTION ANNEAL. With C-1 Coil. 2050° HOLD	<u>DLS</u>	12/28/04
80	PHYSICAL TESTING	OBTAIN TEST SPECIMENS AND SUBMIT FOR PHYSICAL TESTING. REPORT RESULTS AS PART OF STEP 480.	<u>WAT</u>	12/28/04

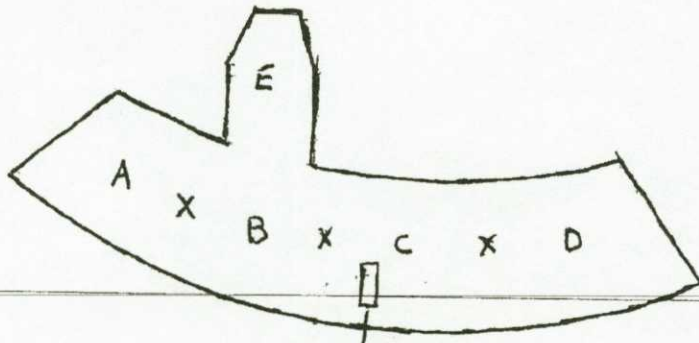
RADIOGRAPHIC STANDARD SHOOTING SKETCH

Customer <u>Energy Industries of Ohio</u>	Pattern Number <u>SE-141-073</u>
Material <u>CFBMNMN-MOD</u>	Traceability Number <u>M573220</u>
Film Manufacturer <u>FUJI</u>	Source Number <u>CO60 24.7 CI</u>
IQI LEVEL <u>2-2T</u> From CQP 401 <input checked="" type="checkbox"/> Other (Specify, E.G. 2-4T, 2-1T) <u>N/A</u>	

Exposures (views)	A	B	C	D	E
Thickness (IN.)	<u>3 3/8"</u>	→	→	→	→
S/F Distance (IN.)	<u>24"</u>	→	→	→	→
Penetrameter	<u>50</u>	→	→	→	→
Time (MIN.)	<u>calculate</u>	→	→	→	→
Focal Spot (IN.)	<u>0.1</u>	→	→	→	→
Film Size (IN.)	<u>14x17</u>	→	→	→	→
Screen Size (Pb) Front/Back	<u>.01</u>	→	→	→	→
S.W.E./D.W.E.	<u>SWE</u>	→	→	→	→
S.W.V./D.W.V.	<u>SWV</u>	→	→	→	→
Film Type	<u>80</u>	→	→	→	→
Acceptance Standard	<u>E186</u>	→	→	→	→
Severity Level	<u>III</u>	→	→	→	→

Shooting Sketch (Use Additional Pages as Needed)

use Spec. MSS-SP-54



TYP. Source Placement

TYP. Penny Placement

TYP. Film Placement

Technique Prepared By: Roy Kelley

Level: II

Date: 3-10-05

Technique Approved By: [Signature]

Level: III

Date: 3-10-05

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER <i>Energy Industries of Ohio</i>		PURCHASE ORDER NUMBER <i>28030003</i>			DATE <i>3-9-05</i>		CONTROL NO. <i>40851</i>		PAGE <i>1 of 1</i>														
PART NO. <i>SE-141-073</i>		SPECIFICATION <i>MSS-SP-54</i>			CLASS <i>See Spec</i>		TOTAL PIECES <i>1</i>		PIECES ACCEPTED <i>1</i>														
RADIOGRAPHED BY: <i>[Signature]</i>				INTERPRETED BY: <i>[Signature]</i>			ASNT LEVEL <i>II</i>																
FILM TYPE <i>FUJI 80</i>		MATERIAL <i>CF8M N/A N-Mo2</i>			ISOTOPE <i>IRIDIUM 192</i> <i>COBALT 60</i> ✓			CODE <i>ASTM E94</i> ✓ <i>ASME</i> <i>MIL-STD-453</i>															
<i>M573220</i>		V I E W		P E N E		A C C E P T		R E J E C T		S H R I N K		I N C L U S I O N		P O R O S I T Y		L I N E A R		S U R F A C E		L O F / L O P		COMMENTS	
<i>RT-1</i>		<i>A</i>		<i>50</i>		/																	
		<i>B</i>				/																	
		<i>C</i>				/																	
		<i>D</i>				/																	
		<i>E</i>				/																	

260	L.P. WELD CQP 0300 REV 10	L.P. WELD REPAIRS ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA-LEVEL 2. IF OK CHECK HERE _____ WASH AND SEND TO STEP 300. IF REJECTED CHECK HERE _____ AND RETURN TO STEP 220.	LP - LEVEL II
270	REPEAT TEST MAG PERM SOP MAG PERM 100, REV 1	REPEAT STEPS 220 TO 260 AS REQUIRED TILL CLEAR THROUGH VISUAL INSPECTION & PENETRANT INSPECTION. DOCUMENT REWORK ON A SUPPLEMENTAL MTS TEST MAG PERMEABILITY REPAIR AREAS RECORD ON WELD MAP LIST. TEST AT LEAST 5 POINTS PER WELD. ACCEPTANCE 1.02. IF OK CHECK HERE _____ AND GO TO STEP 290. IF REJECTED CHECK HERE _____	QA ENG.
280	GRIND GCHI SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 270. REPEAT UNTILL COMPLIANCE IS ACHIEVED.	
290	CAF X-RAY DEFECTS REPAIRED BY WELDING CQP 401 REV 5	X-RAY PER TECHNIQUE: To be determined. USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT - LEVEL II
300	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE _____ AND SEND TO STEP 310. REJECTED CHECK HERE _____ MARK UP DEFECTS AND SEND THE CASTING TO STEP 200.	RT - LEVEL II
	REPEAT	REPEAT STEPS 200 TO 300 AS REQUIRED TILL WELDS CLEAR X-RAY. DOCUMENT REWORK ON A SUPPLEMENTAL MTS	QA ENG.
310	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.	
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF VISUAL AND LP STEPS. EIO NOTIFIED ON _____ DCMA NOTIFIED ON _____	Q ENG OR QA MGR
320	FINAL VISUAL INSPECTION CQP-500 REV 4	VISUALLY INSPECT 100% OF COMPONENT ACCORDING TO ASTM A802 LEVEL 2 ALL CONDITIONS. IF OK CHECK HERE _____ IF REJECTED CHECK HERE _____ MARK AND REPAIR AT STEP 340.	VT - LEVEL II

170	CAF X-RAY CQP 401 REV 5	X-RAY PER TECHNIQUE: To be determined. USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT - LEVEL II
180	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE AND SEND TO STEP 310. REJECTED CHECK HERE MARK UP DEFECTS AND SEND THE CASTING TO STEP 200.	RT - LEVEL II
190	LAYOUT	INSPECT CASTING TO VERIFY DIMENSIONS. THIS MAY BE PERFORMED BEFORE OR AFTER STEP 180. DIMENSIONED _____ DATE _____ RELEASED _____ (ENGINEER ONLY)	
200	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING RADIOGRAPHY.	
210	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA- LEVEL 2.	LP - LEVEL II
220	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE, FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS>10% YES _____, REPORT SENT BY _____ DATE _____ DEFECTS < 10 % _____ SIGN BY QA ENG.	
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF WELD STEP. EIO NOTIFIED ON _____ DCMA NOTIFIED ON _____	Q ENG OR QA MGR
230	QA APPROVAL HOLD POINT	QA TO APPROVE ELECTRODE PRIOR TO USE. PROCEDURE USED: _____ MATERIAL USED: _____ QUALITY ENG. Name: _____ Date: _____	
240	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED. FOR WELDS <2" - WPS 10-SMAW-CF8MNMN MOD REV 1 FOR WELDS <8" - WPS 15-GMAW-CF8MNMN MOD REV 2	
250	GRIND GCHI SOP 0100R2	HAND GRIND WELDS.	

90	GRIND GSA SOP 0100R3 GCHI SOP 0100R2	SWING GRIND TO REMOVE RISER REMAINS AND FLASH IF REQUIRED. CHIP AND HAD GRIND SURFACE OF PART AS REQUIRED.		
100	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.		
110	VISUAL INSPECTION CQP-500 REV 4	VISUALLY INSPECT 100% OF COMPONENT ACCORDING TO ASTM A802 LEVEL 3 ALL CONDITIONS. IF OK CHECK HERE. IF REJECTED CHECK HERE. MARK AND REPAIR AT STEP 130.	VT - LEVEL II	
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF LP STEP. EIO NOTIFIED ON _____ DCMA NOTIFIED ON _____	Q ENG OR QA MGR	
120	100% L.P. CQP 0300 REV 10	L.P. 100% OF COMPONENT. ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA- LEVEL 2. IF OK CHECK HERE. IF REJECTED CHECK HERE. MARK AND REPAIR AT STEP 120.	LP - LEVEL II	
130	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING 100% VISUAL AND LP INSPECTION.		
140	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA- LEVEL 2.	LP - LEVEL II	
150	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.		
160	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR. INSPECTION LEAD MAN OR THEIR DESIGNEE, FILE WITH QA. USE YELLOW MARKER. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES. REPORT SENT BY _____ DATE _____ DEFECTS < 10% SIGN BY QA ENG.		
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF XRAY AND LAYOUT STEPS. EIO NOTIFIED ON _____ DCMA NOTIFIED ON _____	Q ENG OR QA MGR	

**Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Coill C Shim-1**

CO# 40851, Pattern SE 141-073 S73220-1 Dated December 14, 2004 Revision: Original Page 1 of 6 Dated Issued: 12-14-04

OPER. #	STATION	DESCRIPTION OF PROCESS	Name	Date
10	QUALITY RELEASE	REVIEW AND APPROVE MTS. RECEIVED APPROVAL FROM EIO ON _____ FROM _____ SIGNED QUALITY MANAGER		
20	PATTERN NPAT SOP 0100REV2	APPLY APPROPRIATE PART NUMBER, SERIAL NUMBER, FOUNDRY MARK, TO THE PATTERN.		
30	MOLD MOLD SOP 0400 REV 8 CALIBRATION PER MOLD SOP 0900 REV 5 PREPARATION PER MOLD SOP 1100R2/1200R2/13 00R1 SAND TESTING PER MOLD SOP 1400R2/1500R3/16 00R2	MOLD PER WORK INSTRUCTIONS IN MAPICS ROUTING AND SOPS REFERENCED. ENGINEER OF RECORD - ROGER BROMAN, CONSULT ON MOLD-RELATED CONCERNS. MOLD MATERIALS REQUIRED PER MAPICS BOM. NOTIFY ENGINEER OF ANY SUBSTITUTIONS.		
40	POUR MELT SOP 0100R5 MELT SOP 0700R2 MELT SOP 0600R2	METAL MUST BE AOD REFINED OR AOD INGOT. VIRGIN METAL. ADDITIONS ALLOWED. RECORD POURING TEMPERATURE: _____ CASTING POURED AT: _____ DATE: _____ HEAT #'S: _____ ELAPSED POUR TIME: _____ KEEL BLOCKS POURED: _____ Sample from ladle to be analyzed for final chemical analysis and reported on material certifications. Sample Taken by: _____ Analyzed: _____ Date: _____		
50	MELT SOP 0800R2	SHAKEOUT		
60	ARC RISE SOP 0100R1	REMOVE RISERS AS DIRECTED BY SUPERVISOR.		
70	HEAT TREAT HEAT SOP 0103R5	SOLUTION ANNEAL. With C-1 Coil.		
80	PHYSICAL TESTING	OBTAIN TEST SPECIMENS AND SUBMIT FOR PHYSICAL TESTING. REPORT RESULTS AS PART OF STEP 480.		

420	GRIND GCHI SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 420. REPEAT UNTILL COMPLIANCE IS ACHIEVED.		
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF MAG PERM STEP. EIO NOTIFIED ON _____ DCMA NOTIFIED ON _____	Q ENG OR QA MGR	
430	FINAL 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. OK CHECK HERE _____ AND GO TO STEP 470. IF REJECTED CHECK HERE _____		
440	GRIND GCHI SOP 0100 REV 2	HAND GRIND WITH SUITABLE CONE OR OTHER SIMILAR GRINDER AS REQUIRED TO ENSURE REMOVAL OF MATERIAL TO ACHIEVE MAG PERM REQUIREMENT. CIRCLE AREA REMEDIATE FOR RETEST.		
450	RETEST MAG PERM SOP MAG PERM 100, REV 1	RETEST MAG PERMEABILITY AT FAILED TEST POINTS. MARK NONCOMPLIANT AREAS WITH AN "X" FOR REPAIR. ACCEPTANCE 1.02. IF OK CHECK HERE _____ IF REJECTED CHECK HERE _____ RETURN TO STEP 450		
460	PHOTOGRAPH	TAKE DIGITAL PICTURES.		
470	AUDIT REVIEW	PROCESS DOCUMENT TO PROGRAM MANAGER FOR COMPLIANCE AUDIT.		
480	DOC. REVIEW	REVIEW DOCUMENTS AS REQUIRED IN CAF CHECKLIST. ALL DOCUMENTS NOTED TO BE ACCESSIBLE FOR AUDITING. (SHIPPER, C OF C, M.T.R., M.T.S., INSPECTION REPORT, X-RAY READER SHEETS AND HEAT TREAT CHARTS)		
NOTICE	RELEASE FROM EIO	PROVIDE DOCUMENTS TO EIO. SENT ON _____ BY _____ RECEIVED RELEASE FROM EIO ON _____	Q ENG OR QA MGR	
490	PACK AND SHIP	PACKAGE AND SHIP TO MAJOR TOOL.		
1000	REVISION HISTORY	ORIGINAL. 12-14-04.	CARUUD	

**Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Coill C Shim-1**

CO# 40851, Pattern SE 141-073 S73220-1 Dated December 14, 2004 Revision: Original **Page 5 of 6** **Dated Issued: 12-14-04**

330	FINAL L.P. CQP 0300 REV 10	MUST BE PERFORMED BY LEVEL II in VT. FINAL L.P. 100% OF COMPONENT. ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA- LEVEL I FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING. IF OK CHECK HERE _____ WASH AND SEND TO STEP 410. IF REJECTED CHECK HERE _____	LP - LEVEL II
340	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING FINAL PENETRANT INSPECTION.	
350	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903.	LP - LEVEL II
370	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE. FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS >10% YES _____, REPORT SENT BY _____ DATE _____ DEFECTS < 10 % _____ SIGN BY QA ENG.	
380	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED. FOR WELDS <2" - WPS 10-SMAW-CF8MNMN MOD REV 1 FOR WELDS <8" - WPS 15-GMAW-CF8MNMN MOD REV 2	
390	GRIND GCHI SOP 0100 REV 2	HAND GRIND WELDS.	
400	L.P. WELDS CQP 0300 REV 10	L.P. WELD REPAIRS ACCEPTANCE PER ASTM A903. IF OK CHECK HERE _____ WASH AND SEND TO STEP 460. IF REJECTED CHECK HERE _____ AND RETURN TO STEP 390.	LP - LEVEL II
	REPEAT	REPEAT STEPS 390 TO 410 AS REQUIRED TILL WELDS CLEAR FINAL LIQUID PENETRANT INSPECTION. DOCUMENT REWORK ON A SUPPLEMENTAL MTS	QA ENG.
410	TEST MAG PERM SOP MAG PERM 100, REV 1	TEST MAG PERMEABILITY REPAIR AREAS. RECORD ON WELD MAP LIST. TEST AT LEAST 5 POINTS PER WELD ACCEPTANCE 1.02. IF OK CHECK HERE _____ AND GO TO STEP 430.	



Carondelet Division

8600 Commercial Blvd. - Pevely, MO 63070 USA
Phone: 636-479-4499 - Fax: 636-479-3399

C-1 Doc Package
Document #4a

Material Test Report

Replaced by product
analysis - See CA1323

ENERGY INDUSTRIES OF OHIO

Purchase Order Number PPPL-FP-LTS-2
Pattern Number MCWF-C1
CAF Metal Designation CF8MNMnMod
Material Spec CF8MNMnMOD

Cert Number S73140-1
Pour Date 12/19/2004

Weighted average of 3 heats - 27728(32.4%), 27730(25.1%), 27731(42.5%) Total Weight 28779 lbs.

Revised 9/15/05

Element	Min	Actual	Max
C	0.04	0.06	0.07
MN	2.3	2.7	2.8
SI	0.0	0.5	0.7
CR	18.0	18.1	18.5
NI	13.0	13.1	13.5
MO	2.1	2.2	2.5
P*	0.0	0.018	0.035
S*	0.0	0.014	0.025
N	0.24	0.27	0.28

*P & S taken from cast on bar and analyzed by wet chemistries, ASTM E1019-03 for sulfur and Colormetric for phosphorous.

PRODUCT ANALYSIS

Results of spectrometer analysis of cast on test bar after spectrometer preventive maintenance performed.

Element

C	***
MN	1.9
SI	0.7
CR	18.3
NI	13.2
MO	2.4
P	0.024
S	0.013
N	***

***Not analyzed on spectrograph.

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

Superior Quality Engineered Metal Products

www.MetalTekInt.Com



Carondelet Division

8600 Commercial Blvd. - Pevely, MO 63070 USA
Phone: 636-479-4499 - Fax: 636-479-3399

C-1 Doc Package
Document # 4b

Material Test Report

ENERGY INDUSTRIES OF OHIO

Purchase Order Number PPPL-FP-LTS-2

Pattern Number MCWF-C1

CAF Metal Designation CF8MNMnMod

Material Spec CF8MNMnMOD

Analysis performed by Wisconsin Centrifugal

Cert Number S73140-1

Pour Date 12/19/2004

Revised 10-19-05

Element	Min	Actual	Max
C	0.04	0.06	0.07
MN*	2.3	1.8	2.8
SI	0.0	0.7	0.7
CR	18.0	18.3	18.5
NI	13.0	13.4	13.5
MO	2.1	2.4	2.5
P	0.0	0.021	0.035
S	0.0	0.014	0.025
N	0.24	0.24	0.28

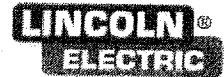
- See Corrective Action Number 1323

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

Superior Quality Engineered Metal Products

www.MetalTekInt.Com

PRODUCT CONFORMANCE REPORT



Product LNM.4455
 Class. EN 12072-99: G 20 16 3 Mn L

Size(s) mm 1,2
 Lot/Batch 3012668/82743
 Item No. 692129

C-1 Doc Package
 Document # 5

Customer CK SUPPLY
 Contact Ernie Simpson
 Eureka (MISSOURI) 63025
 UNITED STATES

Quantity
 Customer ref. P.O.: SL056508
 LSW Order No. SD418352

Chemical analysis (%)

EN10204 3.1B

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	N
0,02	0,4	7,2	0,014	0,003	19,6	15,7	2,7	0,1	0,17

Can't read that high J.G.

Mechanical tests: all weld metal

EN10204

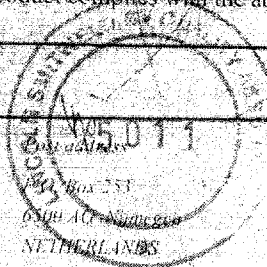
Additional information
 Other tests

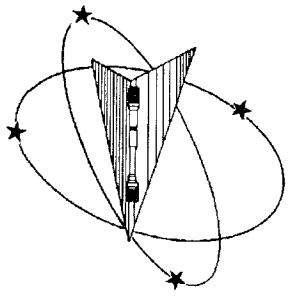
EN10204

Remarks

The product identified above has been manufactured, tested and supplied in compliance with a Quality Assurance Programme that fulfils the requirements of EN 29000/ ISO 9000:BS 5750 or similar standard.
 We herewith certify that the product complies with the above-mentioned standards.
 Certified ISO 9001:2000.

Company	Issued by	Function	Date	Cert.No.
Lincoln Smitweld B.V. Registered Office Van der Dukerbaanweg, 20 6334 AD NIMMIGEN	P. van Etteger Telephone +31 24 3522931	QS Manager Fax +31 24 3522300	27/01/2005	3012668/8274





Westmoreland Mechanical Testing & Research, Inc.
 P.O. Box 388
 Westmoreland Drive
 Youngstown, PA 15696-0388 U.S.A.
 Telephone: 724-537-3131 Fax: 724-537-3151
 Website: www.wmtr.com

WMT&R is a technical leader in the material testing industry.

CERTIFICATION

Section 1 of 1

WMT&R Report No. 5-25287
 WMT&R Quote No. QN250563
 Req No. 2767



621-01 & 621-02



Materials Testing Laboratory

April 19, 2005
 MetalTek International
 The Carondelet Division
 8600 Commercial Blvd.
 I-55 Industrial Park
 Pevely, MO 63070-1528

Attention: Rick Suria
 Subject: All processes, performed upon the material as received, were conducted at WMT&R, Inc. in accordance with the WMT&R Quality Assurance Manual, Rev. 9, dated 4/1/2000.
 The following tests were performed on this order: TENSILE

TENSILE RESULTS: ASTM E21-03a

Requirements: UTS KSI (Min 95/Max ---) 0.2% YS KSI (Min 72/Max ---) 4D Elong: % (Min 32/Max ---) Modulus MSI (Min 21/Max ---)

SOAK TIME: 5 Minutes

SPEED OF TESTING: 0.0050 in./in./min., 0.0500 in./in./in.

MATERIAL: Metatek CF8MNMNMOD

CAST on Bars from C-1 coil *4/1/05*

DISPOSITION: Acceptable

Sample	Test-log Number	Temp. °F	UTS KSI	0.2% YS KSI	Elong %	RA %	Modulus MSI	Ult. Load LBS	0.2% YLD. LBS	Orig. Dia. (in.)	Final Dia. (in.)	4D Orig GL (in.)	4D Final GL (in.)	Orig. Area (Sq. In.)	Machine Number	A/U/R
Tensile-2	B67872	-320	172.0	98.7	62	68	24.2	16590	9522	0.3504	0.1968	1.40	2.27	0.09643131	M9	A
Tensile-4E	B67873	-320	167.4	97.8	44	36	23.3	16120	9416	0.3502	0.2805	1.40	2.02	0.09632126	M9	A
Tensile-5A	B67874	-320	171.2	98.7	61	64	22.5	16450	9481	0.3498	0.2090	1.40	2.25	0.09610135	M9	A

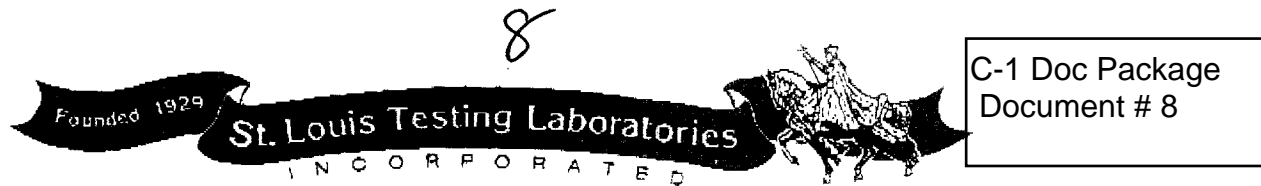
A/U/R: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

C-1 Doc Package Document # 7

KNOWINGLY OR WILLFULLY FALSIFYING OR CONCEALING A MATERIAL FACT ON THIS FORM OR MAKING FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS OR REPRESENTATIONS HEREIN COULD CONSTITUTE A FELONY PUNISHABLE UNDER FEDERAL STATUTES. THIS CERTIFICATE OR REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF WMT&R, INC.

[Signature]
 Roy E. Star/Matt Wojton
 Technical Services Manager / Tensile Supervisor
 April 19, 2005

Testing Specialists for Aerospace, Automotive, and Material Testing Fields
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C-1 Doc Package
Document # 8

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METALTEK INTERNATIONAL
8600 Commercial Blvd.
Pevely, MO 63070

March 22, 2005
Lab No. 05P-0864
P.O. No. 12516
Page 1 of 2
(Corrected Report 6/15/05)

Attention: **Chuck Ruud**

REPORT OF MECHANICAL TESTS

SAMPLE ID: 3 EA., HT# 27728 Alloy CF8MNMNMOD +70°F


Sample ID	Original Area Sq. Inches	Reduced Area Sq. Inches	Reduction in Area %	Yield Strength PSI	Tensile Strength PSI	Modulus of Elasticity	Elongation (2.0" Gage Length)	
							in.	%
27728-1	.1948	.0683	64.9	34,600	82,500	21.3	1.06	53.0
27728-2	.1886	.0697	63.0	34,800	85,100	20.5	1.03	51.5
27728-3	.1924	.0683	64.5	33,300	83,900	21.1	1.00	50.0

Round, reduced section tensiles

Yield taken at .2% offset

Tested in accordance with ASTM A 370-03a

Identification of tested specimens provided by the client.


Ken Schmitz, Director
Materials Testing



Certificate No. 0307-11
Certificate No. 0307-02

AN OFFICIAL COPY OF TEST REPORT WILL BE PROVIDED BY THIS LABORATORY ON REQUEST, DO NOT REPRODUCE.
NOT OFFICIAL WITHOUT THE RAISED SEAL OF ST. LOUIS TESTING LABORATORIES, INC.
SEE REVERSE FOR CONDITIONS

MEMBER
ACIL



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Document # 8

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8600 Commercial Blvd.
Pevely, MO 63070

March 22, 2005
Lab No. 05P-0864
P.O. No. 12516
Page 2 of 2
(Corrected Report 6/15/05)

Attention: **Chuck Ruud**

REPORT OF MECHANICAL TESTS

SAMPLE ID: HT# 28597 & HT# 28679

Sample ID	Original Area Sq. Inches	Reduced Area Sq. Inches	Reduction in Area %	Yield Strength PSI	Tensile Strength PSI	Elongation (2.0" Gage Length)	
						in.	%
28597	.1886	.1140	39.5	54,600	84,100	0.48	24.0
28679	.1863	.1029	44.7	57,400	82,900	0.46	23.0

Round, reduced section tensiles

Yield taken at .2% offset

Tested in accordance with ASTM A 370-03a

Identification of tested specimens provided by the client.

*Unrelated
to project
C/R 4/14/05*

[Signature]
Kar Schmitz, Director
Materials Testing



Certificate No. 0397-01
Certificate No. 0397-02

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METALTEK INTERNATIONAL
8600 Commercial Blvd.
Pevely, MO 63070

May 12, 2005
Lab No. 05P-1439
P.O. No. 12516
Page 1 of 1

Attention: **Chuck Ruud**

REPORT OF MECHANICAL TESTS

SAMPLE ID: HT# 27728

Sample ID	Original Area Sq. Inches	Reduced Area Sq. Inches	Reduction in Area %	Yield Strength PSI	Modulus MSI	Tensile Strength PSI	Elongation (2.0" Gage Length)	
							in.	%
27728	.1948	.0651	66.6	37,300	28.1	83,100	1.1	55.0

Round, reduced section room temperature tensiles

Yield taken at .2% offset

Tested in accordance with ASTM A 370-03a

Identification of tested specimens provided by the client.

KS/tw

Karl Schmitz, Director
Materials Testing



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Certificate No. 0397-01
Certificate No. 0397-02

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8600 Commercial Blvd.
Pevely, MO 63070

June 1, 2005
Lab No. 05P-1658
P.O. No. 12516
Page 1 of 1

May 31

Attention: Chuck Ruud

REPORT OF MECHANICAL TESTS

SAMPLE ID: HT# 27728, 29511, 29497, 29563, 29560, 29553

Retest of material

Sample ID	Original Area Sq. Inches	Reduced Area Sq. Inches	Reduction in Area %	Yield Strength PSI	Tensile Strength PSI	Elongation (2.0" Gage Length)		Modulus of Elasticity (MSI)
						in.	%	
27728	.1886	.0830	56.0	36400	83100	1.05	52.5	24.4
27728b	.1886	.0908	51.9	34100	84300	1.00	50.0	23.4

OK F
OK P F
OK F
OK
OK

Sample ID	Original Area Sq. Inches	Reduced Area Sq. inches	Reduction in Area %	Yield Strength PSI	Tensile Strength PSI	Elongation (2.0" Gage Length)	
						in.	%
29511	.1995	.1878	05.9	40600	60400	0.12	06.0
29497	.1932	.1772	08.3	35700	62100	0.18	09.0
29563	.1847	.1840	00.4	37700	37900	0.04	02.0
29560	.1863	.1728	07.3	47500	69500	0.24	12.0
29553	.1886	.1765	06.4	50100	72700	0.16	08.0

unrelated to project
6/24/05

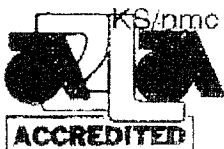
Round, reduced section tensiles

Yield taken at .2% offset

Tested in accordance with ASTM A 370-03a

Identification of tested specimens provided by the client.

Karl Schmitz, Director
Materials Testing



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January 10, 2005
Lab No. 05P-0008
P.O. No. 12516
Page 3 of 3

Attention: Chuck Ruud

REPORT OF CHARPY IMPACT TEST

MATERIAL (SAMPLE ID): HT# 27728, Alloy CF8 MnMN-MOD
SPECIFICATION: ASTM A 370-03a
SPECIMEN TYPE: "A" Vee Notch
SPECIMEN SIZE: 10 mm x 10 mm
TEMPERATURE OF TEST: -320°F

RESULTS:

BASE METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
27728-1	98	0.051	50
27728-2	91	0.060	50
27728-3	80	0.045	50
Average	90	0.052	50
BASE METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
27728-4	77	0.038	40
27728-5	86	0.055	50
27728-6	61	0.032	40
Average	75	0.042	43
BASE METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
27728-7	64	0.041	50
27728-8	67	0.043	50
27728-9	72	0.030	40
Average	68	0.038	47

on chart

Identification of tested specimens provided by client.

[Signature]
Karl Schmitz, Director
Materials Testing



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Certification No. 0397-02

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Pevsley, MO 63070

January 10, 2005
Lab No. 05P-0008
P.O. No. 12516
Page 2 of 3

Attention: **Chuck Ruud**

REPORT OF CHARPY IMPACT TEST

MATERIAL (SAMPLE ID): HT# 27728, Alloy CF8 MnMN-MOD
SPECIFICATION: ASTM A 370-03a
SPECIMEN TYPE: "A" Vee Notch
SPECIMEN SIZE: 10 mm x 10 mm
TEMPERATURE OF TEST: +70°F

RESULTS:

BASE METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
27728-1	139	0.097	100
27728-2	119	0.081	100
27728-3	167	0.091	100
Average	142	0.090	100
BASE METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
27728-4	170	0.107	100
27728-5	124	0.071	100
27728-6	129	0.060	100
Average	141	0.079	100
BASE METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
27728-7	141	0.103	100
27728-8	137	0.052	100
27728-9	150	0.114	100
Average	143	0.090	100

on chart

Identification of tested specimens provided by client.

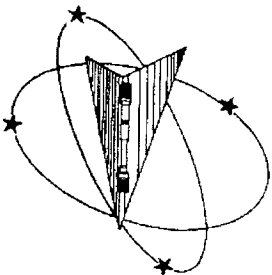
[Signature]
Karl Schmitz, Director
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Certificate No. 0317-01
Certificate No. 0317-02

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April 28, 2005

Metatek International
The Carondelet Division
8600 Commercial Blvd.
L-55 Industrial Park
Pevely, MO 63070-1528

Attention: Rick Suria

Subject: All processes, performed upon the material as received, were conducted at WMT&R, Inc. in accordance with the WMT&R Quality Assurance Manual, Rev. 9, dated 4/1/2000.
The following tests were performed on this order: TENSILE

TENSILE RESULTS: ASTM E21-03a

Requirements: UTS ksi (Min 95Max ---) 0.2% YS ksi (Min 72Max ---) 4D Elong. % (Min 32Max ---) Modulus Msi (Min 21Max ---)

SOAK TIME: 5 Minutes
SPEED OF TESTING: 0.0050 in./in./min., 0.0500 in./in./min.
MATERIAL: 316 S/S

Sample	TestLog Number	Temp. °F	UTS ksi	0.2% YS ksi	Elong %	RA %	Modulus Msi	Ult. Load lbf	0.2% YLD. lbf	Orig. Dia. (in.)	Final Dia. (in.)	4D Orig. GL (in.)	4D Final. GL (in.)	Orig. Area (sq. in.)	Machine Number	AIUR
Bar#1 (Lot#3012668/82743)	B75123	-320	187.7	126.3	33	22	27.1	37740	25394	0.5060	0.4471	2.00	2.65	0.20109020	M9	A
Bar#2 (Batch#W019711)	B75124	-320	166.9	109.5	34	27	26.4	33500	21990	0.5056	0.4315	2.00	2.67	0.20077240	M9	A

AIUR: A=ACCEPTABLE, U=UNACCEPTABLE, R=REPORT

D. J. [Signature]

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Westmoreland Mechanical Testing & Research, Inc.
P.O. Box 388
Westmoreland Drive
Youngstown, Pa. 15696-0388 U.S.A.
Telephone: 724-537-3131 Fax: 724-537-3151
Website: www.wmttr.com
WMT&R is a technical leader in the material testing industry.

CERTIFICATION

Section 1 of 1

WMT&R Report No. 5-26097
P.O. No. 19386R9
WMT&R Quote No. QN250563
Req. No. 4315



[Signature]
Roy E. Starr
Technical Services Manager
Tensile Supervisor
4-28-05

Testing Specialists for Aerospace, Automotive, and Material Testing Fields
Locations in Youngstown, PA U.S.A. ~ Tel: (724) 537-3131 and
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Document # 12

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METALTEK INTERNATIONAL
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April 22, 2005
Lab No. 05P-1170
P.O. No. 12516
Page 1 of 1
(revised 6/15/05)

Attention: **Chuck Ruud**

REPORT OF MECHANICAL TESTS

SAMPLE ID: 1 Ea., Sample Bar #1, Lot 3012668/82743
1 Ea., Sample Bar #2, Batch # WO19711

Sample ID	Original Area Sq. Inches	Reduced Area Sq. Inches	Reduction in Area %	Yield Strength PSI	Tensile Strength PSI	Elongation (2.0" Gage Length)		Elastic Modulus
						in.	%	
#1	.1901	.0855	55.0	56,500	85,000	0.80	55.0	25.5 MSI
#2	.1917	.0881	54.0	63,900	98,100	0.88	54.0	23.1 MSI

Round, reduced section all weld room temperature tensiles

Yield taken at .2% offset

Tested in accordance with ASTM A 370

Identification of tested specimens provided by the client

KS/tw

Karl Schmitz
Karl Schmitz, Director
Materials Testing



Certificate No. 0397-01
Certificate No. 0397-02

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Pevely, MO 63070

April 8, 2005
Lab No. 05P-1007
P.O. No. 12516
Page 1 of 2

Attention: **Chuck Ruud**

REPORT OF CHARPY IMPACT TEST

MATERIAL (SAMPLE ID): 1 Ea., Material (1) LNM4455, Lot # 3012668/82743

SPECIFICATION: ASTM A 370-03a

SPECIMEN TYPE: "A" Vee Notch

SPECIMEN SIZE: 10 mm x 10 mm

TEMPERATURE OF TEST: -320°F

ALL WELD METAL	FOOT LBS.	LATERAL EXPANSION	% SHEAR
LNM4455-1	52	0.027	40
LNM4455-2	50	0.022	40
LNM4455-3	50	0.016	20
Average	51	0.022	33

Identification of tested specimen provided by client.

KS/tw

[Signature]
 Kar Schmitz, Director
 Materials Testing



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Certificate No. 0397-02

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February 28, 2005
Lab No. 05P-0554
P.O. No. 12516
Page 1 of 2
(Revised Report 3-2-05)

Attention: Rick Suria

REPORT OF CHARPY IMPACT TEST

MATERIAL (SAMPLE ID): Electrode LNM 4455 & B316NF
SPECIFICATION: ASTM A 370-03a
SPECIMEN TYPE: "A" Vee Notch, All Weld
SPECIMEN SIZE: 10 mm x 10 mm
TEMPERATURE OF TEST: +70°F

301 266 82743
L W01974
Chc 6/14/05

RESULTS:

ALL WELD	JOULES	FOOT LBS.	LATERAL EXPANSION	% SHEAR
LNM 4455-7	149	110	0.055	50
LNM 4455-8	130	96	0.050	50
LNM 4455-9	134	99	0.051	50
Average	138	102	0.052	50
ALL WELD	JOULES	FOOT LBS.	LATERAL EXPANSION	% SHEAR
B316NF-7	155	114	0.056	50
B316NF-8	151	111	0.053	50
B316NF-9	146	108	0.052	50
Average	151	111	0.054	50

Identification of tested specimen provided by client.

Karl Schmitz
Karl Schmitz, Director
Materials Testing

KS/clm



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Certificate No. 0397-02

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Pevely, MO 63070

February 28, 2005
Lab No. 05P-0554
P.O. No. 12516
Page 2 of 2
(Revised Report 3-2-05)

Attention: Rick Suria

PROCEDURE QUALIFICATION

WELDER: TERRY STANFIELD
MATERIAL: 1" CF8MnMn, Mod
SPECIFICATION: ASME IX
ELECTRODE: B316NF
PROCESS: SMAW

REDUCED SECTION TENSILE

SAMPLE ID	WIDTH INCHES	THICKNESS INCHES	AREA SQ. INCHES	ACTUAL LBS.	TENSILE STRENGTH PSI	FRACTURE
TS-2	.750	1.000	.7500	70,000	93,300	Weld Metal
TS-5	.750	1.010	.7575	71,000	93,700	Weld Metal

GUIDED BEND TEST

SAMPLE ID	BEND	RESULTS
TS-1	Side	Acceptable, No Discontinuities
TS-3	Side	Acceptable, No Discontinuities
TS-4	Side	Acceptable, No Discontinuities
TS-6	Side	Acceptable, No Discontinuities

KS/clm

Karl Schmitz
Karl Schmitz, Director
Materials Testing
CWI No. 92120161



Certificate No. 0397-01
Certificate No. 0397-02

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Doc 16

only welds 7/10²/10
submitted 2/19/05
to EIO.
CJR

C COIL RT1 WELD MAP

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
1	1	3	1 1/2	3/16	NO	OK
2	1	5 1/2	2	1/4	NO	OK
3	1	9	4 1/2	1/4	NO	OK
4	1	12	4	1/4	NO	OK
5	1	2	1	1/4	NO	OK
6	1	2	1	1/4	NO	OK
7	1	3 7/8	3	3/16	NO	OK
8	1	1	1	1/4	NO	OK
9	1	3	2	1/4	NO	OK
10	1	2 3/4	1 3/4	1/4	NO	OK
11	1	1 3/4	1	1/4	NO	OK
12	1	2	1	1/4	NO	OK
13	2	4	3	1/4	NO	OK
14	2	3	1 1/2	1/4	NO	OK
15	2	2	1 1/2	1/4	NO	OK
16	2	2	1	1/4	NO	OK
17	2	1 3/4	1	1/4	NO	OK
18	2	2	1	1/4	NO	OK
19	2	2	1 1/4	1/4	NO	OK
20	2	2	1 1/2	1/4	NO	OK
21	2	1 1/2	1 1/2	1/4	NO	OK
22	58	2	1	1/4	NO	OK
23	3	2	2	1/2	NO	OK
24	3	2	1	3/16	NO	OK
25	3	4	3	3/4	NO YES	OK
26	3	2	3 1/2	3/8	NO	OK
27	3	2	1	1/2	NO	OK
28	3	2 1/2	1 1/2	1/4	NO	OK
29	4	2 1/2	1 1/2	1/4	NO	OK
30	5	1 1/2	2	1/4	NO	OK
31	5	2 1/2	1 1/2	1/4	NO	OK
32	5	3 1/2	1 1/2	1/4	NO	OK
33	5	2	1 1/2	1/4	NO	OK
34	5	3	2	1/4	NO	OK
35	6	3	3/4	1/4	NO	OK

Checked
3/6/05
< 1.02

X

Scanned
5/9/05 EIO.

C COIL RT1 WELD MAP

3/6/05
← 1.02

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
36	6	1 ¹ / ₄	1	3/8	NO	OK
37	6	3 ¹ / ₂	2 ¹ / ₂	3/8	NO	OK
38	6	3	2 ³ / ₄	3/4	NO	OK
39	6	2	1 ¹ / ₂	1/8	NO	OK
40	6	2	1 ¹ / ₂	1/4	NO	OK
41	6	5	2	1	YES	OK
42	6	5 ³ / ₄	3	1 ¹ / ₂	YES	OK
43	7	4 ³ / ₄	1 ¹ / ₂	7/8	YES	OK
44	7	2 ¹ / ₂	1 ¹ / ₂	1/4	NO	OK
45	59	3 ¹ / ₄	1 ¹ / ₄	1/4	NO	OK
46	59	5 ¹ / ₂	3 ¹ / ₂	2	YES	OK
47	7	2	1 ¹ / ₂	1/2	NO	OK
48	7	5	2 ¹ / ₂	2	YES	OK
49	7	6	4	1 ¹ / ₂	YES	OK
50	8	9	4	THRU	YES	OK
51	8	4	1 ¹ / ₂	3/8	NO	OK
52	9	1	1 ¹ / ₂	1/4	NO	OK
53	9	2 ¹ / ₂	2	1/4	NO	OK
54	9	2	1	1/4	NO	OK
55	10	6 ¹ / ₂	3 ³ / ₄	1/2	NO	OK
56	10	2 ¹ / ₂	1 ¹ / ₄	1/4	NO	OK
57	10	3 ¹ / ₂	2 ¹ / ₂	1/8	NO	OK
58	11	2	1 ¹ / ₂	1/4	NO	OK
59	11	2	1 ¹ / ₂	1/4	NO	OK
60	14	2 ¹ / ₂	2	3/4	YES	OK
61	14	2	1 ¹ / ₄	1/2	YES	OK
62	13	13	5 ³ / ₄	THRU	YES	OK
63	14	2 ¹ / ₄	1 ¹ / ₂	1/4	NO	OK
64	14	2 ¹ / ₄	1 ¹ / ₂	1/4	NO	OK
65	14	7 ¹ / ₄	5 ¹ / ₂	1 ³ / ₄	YES	OK
66	14	3	1	1/4	NO	OK
67	14	8 ¹ / ₄	4	1 ¹ / ₂	YES	OK
68	14	5 ¹ / ₂	3	1	YES	OK
69	17	6	2	1 ¹ / ₂	YES	OK
70	17	3	2 ¹ / ₂	1 ³ / ₄	YES	OK
71	17	7 ¹ / ₂	4 ¹ / ₂	2 ³ / ₄	YES	OK
72	17	3	1	1/4	NO	OK

C COIL RT1 WELD MAP

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
73	16	3	1	1/4	NO	OK
74	17	1	1/2	1/4	NO	OK
75	15	3	2 1/2	1/4	NO	OK
76	15	2	1 1/2	1/4	NO	OK
77	16	2	1 1/2	1/4	NO	OK
78	19	2 1/2	1 1/2	1/4	NO	OK
79	18	4 7/8	1 1/2	1/2	YES	OK
80	18	1 1/2	1	1/4	NO	OK
81	18	4	3 3/4	1 1/4	YES	OK
82	20	11 1/2	4 1/2	2	YES	OK
83	20	6	3	1	YES	OK
84	23	1 1/2	1	1/8	NO	OK
85	23	3	1 1/2	1/8	NO	OK
86	23	4	3 1/2	3/8	NO	OK
87	23	6	2	3/8	NO	OK
88	21	5	3 1/4	7/8	YES	OK
89	22	8 1/2	2 1/2	3/4	Yes	OK
90	22	3	1 1/2	3/8	Yes	OK
91	60	1	1	1/8	No	OK
92	60	1	1/2	1/8	No	OK
93	23	4	1 1/2	3/8	Yes	OK
94	23	3	2 1/2	3/8	Yes	OK
95	23	1 1/2	1	1/8	No	OK
96	23	1	1	1/8	No	OK
97	23	3	2	1/8	No	OK
98	61	4 1/2	1 1/2	1/4	Yes	OK
99	24	1 1/2	3/4	7/8	Yes	OK
100	24	9 3/4	4 1/4	2 1/8	Yes	OK
101	24	1 1/2	1	1/8	No	OK
102	24	6	2	1/2	Yes	OK
103	24	1	1	1/8	No	OK
104	24	1	1/2	1/2	No	OK
105	24	3 1/2	3	1 1/4	Yes	OK
106	24	6 7/8	2	1	Yes	OK
107	26	1 1/2	1 1/2	3/4	Yes	OK
108	26	7	5	1 1/2	Yes	OK
109	27	11 1/2	6 1/2	2 1/2	Yes	OK

3/6/05
L102

C COIL RT1 WELD MAP

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
110	25	8 1/2	1	3/8	Yes	OK
111	25	1	1	3/8	Yes	OK
112	62	2	1	3/8	Yes	OK
113	62	1	1/2	3/8	Yes	OK
114	28	2	1	3/8	Yes	OK
115	28	3 3/4	1	3/8	Yes	OK
116	28	1	1	3/16	No	OK
117	29	1 1/2	1 1/2	3/16	No	OK
118	29	4	1 1/2	3/16	No	OK
119	28	2	1 1/2	3/8	Yes	OK
120	28	2	1 1/2	3/8	Yes	OK
121	28	1 1/2	1	3/8	No	OK
122	28	3 1/2	1 1/2	3/8	No	OK
123	28	1	1/2	1/8	No	OK
124	28	2	1	3/8	No	OK
125	28	17	2	3/8	No	OK
126	30	2	1 1/2	1/4	No	OK
127	30	3 1/2	1 3/4	3/4	Yes	OK
128	32	1 3/4	1	3/8	Yes	OK
129	32	2	1	1/2	No	OK
130	32	5	1 3/4	1/2	No	OK
131	32	1	1/2	1/2	No	OK
132	32	1/2	1/2	1/2	No	OK
133	32	2 3/4	1/2	3/8	Yes	OK
134	32	2 3/4	1 3/4	1/4	Yes	OK
135	31	5 1/2	3	1 1/2	Yes	OK
136	31	4	2	1 1/2	Yes	OK
137	31	3	2	3/4	Yes	OK
138	31	5 1/2	2	1	Yes	OK
139	31	3	3	1	Yes	OK
140	31	3 1/2	3	1	Yes	OK
141	31	5 1/4	1 1/2	1/4	No	OK
142	31	1 1/2	1	1/4	No	OK

3/6/05
← 1.02

1. Weld maps submitted to EIO/PPPL on _____ By: _____
2. Weld maps approved by EIO/PPPL on _____ By: _____

C COIL RT1 WELD MAP

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
143	33	2	1	1/8	No	OK
144	33	2	1	1/8	No	OK
145	32	3	1/2	1/8	No	OK
146	32	2	1/2	1/8	No	OK
147	35	4	3	1/8	No	OK
148	35	3	1/2	1/8	No	OK
149	35	2 1/2	1 1/2	1/8	No	OK
150	35	3 1/2	2 1/2	1/8	No	OK
151	34	12 1/2	2 1/2	2	Yes	OK
152	34	3	1 1/2	3/4	Yes	OK
153	34	3	2 1/2	1	Yes	OK
154	34	3	1 3/4	7/8	Yes	OK
155	38	2	1	1/8	No	OK
156	38	5 1/2	1 1/2	1/2	Yes -	OK
157	38	1 1/2	1	3/8	Yes -	OK
158	36	2	1 1/2	3/8	Yes -	OK
159	37	3 1/2	3	1	Yes -	OK
160	37	1 1/2	1	1/2	Yes -	OK
161	37	1	1	3/8	Yes -	OK
162	39	1	1 1/2	3/8	Yes -	OK
163	39	1 1/2	1 1/2	1/2	Yes -	OK
164	39	1	1 1/2	1/2	No	OK
165	39	3 1/2	1	3/2	No	OK
166	39	1	1	1/8	No	OK
167	39	1 1/2	1	3/8	Yes -	OK
168	40	4	2	3/8	No	OK
169	40	8	1 1/2	3/8	Yes -	OK
170	40	1 1/2	1 1/2	1/8	No	OK
171	40	6 3/4	4	3/8	Yes -	OK
172	63	5 1/2	1	3/2	Yes -	OK
173	41	4	2 1/4	3/16	No	OK
174	41	4	1	3/8	Yes -	OK
175	41	5	1	3/8	Yes -	OK
176	42	1	1/2	1/2	No	OK
177	43	1	1	3/8	Yes -	OK

3/6/05
L1.02

[Handwritten signature]

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C COIL RT1 WELD MAP

3/6/05
21.02

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
178	43	1 1/2	1	1/8	No	OK
179	43	1 1/2	1	3/8	No	OK
180	44	1	1	1/2	No	OK
181	44	1	1	1/2	No	OK
182	44	2	2	1	Yes	OK
183	44	2 1/2	2	3/4	Yes	OK
184	45	1	1	1/2	No	OK
185	46	1	1/2	3/8	Yes	OK
186	46	1	1	1/8	No	OK
187	64	2	1 1/2	1/4	No	OK
188	47	2	1 1/2	1/4	No	OK
189	48	2	1 1/2	1/4	No	OK
190	48	3	2 1/4	1/4	No	OK
191	48	9 1/4	3	1 1/8	Yes	OK
192	49	1 1/4	1	3/8	No	OK
193	49	6 1/8	3 3/4	1 1/8	Yes	OK
194	49	1 3/4	1 1/4	3/8	No	OK
195	50	1 1/2	1	1/8	No	OK
196	65	1	1	3/8	No	OK
197	51	2	1 1/4	3/8	No	OK
198	51	6	3/4	1/2	No	OK
199	51	4	1 1/2	3/8	No	OK
200	55	2	1 1/2	1/8	No	OK
201	54	4	3 1/4	2 1/2	Yes	OK
202	52	5	2	1/2	No	OK
203	52	6 3/4	3	3/8	No	OK
204	52	5 1/2	3 1/2	3/4	Yes	OK
205	57	3 1/4	3	2 1/4	Yes	OK
206	56	7 1/2	3	2	Yes	OK
207	66	3	2 1/8	1/8	No	OK
208	66	1	1/2	1/8	No	OK
209	66	2 1/8	1 1/2	3/8	No	OK
210	66	2 1/2	1	3/8	No	OK
211	68	2	1 1/2	1 1/4	Yes	OK
212	68	7	3 1/4	1	Yes	OK
213	68	5 1/2	3 1/4	1 1/2	Yes	OK
214	68	5 1/2	4	3/16	No	OK

C COIL RT1 WELD MAP

3/6/05
Checked
2.02

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
215	69	2 ³ / ₄	2	1 ¹ / ₈	Yes	OK
216	69	1 ¹ / ₂	1	1 ¹ / ₈	No	OK
217	70	12	11	2	Yes	OK
218	70	1	1 ¹ / ₂	3 ¹ / ₁₆	No	OK
219	71	11 ³ / ₄	1 ¹ / ₂	3 ¹ / ₁₆	No	OK
220	72	2 ³ / ₈	1	3 ¹ / ₈	No	OK
221	73	6	4 ³ / ₄	2	Yes	OK
222	74	1	1 ¹ / ₂	1 ¹ / ₈	No	OK
223	74	1	1 ¹ / ₂	1 ¹ / ₈	No	OK
224	74	3	1 ¹ / ₂	1 ¹ / ₈	No	OK
225	75	9 ¹ / ₂	2 ¹ / ₂	2 ¹ / ₂	Yes	OK
226	76	12 ¹ / ₂	1 ¹ / ₂	1 ¹ / ₈	No	OK
227	76	1	1 ¹ / ₂	1 ¹ / ₈	No	OK
228	77	1	1	3 ¹ / ₄	Yes	OK
229	77	4	1 ¹ / ₂	1 ¹ / ₈	No	OK
230	78	2	1	1 ¹ / ₈	No	OK
231	78	9	5	3 ¹ / ₂	Yes	OK
232	79	1	1 ¹ / ₂	1 ¹ / ₈	No	OK
233	79	4 ¹ / ₂	1 ¹ / ₂	1 ¹ / ₈	No	OK
234	79	1 ³ / ₄	1 ¹ / ₂	3 ¹ / ₈	Yes	OK
235	79	3	2	1	Yes	OK
236	79	2	1 ¹ / ₂	1	Yes	OK
237	80	2	1	3 ¹ / ₈	No	OK
238	81	2	1	3 ¹ / ₈	No	OK
239	82	3	1 ¹ / ₂	1 ¹ / ₂	Yes	OK
240	82	5 ¹ / ₂	1 ³ / ₄	1 ¹ / ₈	No	OK
241	83	2 ¹ / ₂	1 ¹ / ₂	3 ¹ / ₈	No	OK
242	85	1	1	1 ¹ / ₈	No	OK
243	84	2	1 ³ / ₄	3 ¹ / ₈	Yes	OK
244	84	1	1	1 ¹ / ₈	No	OK
245	86	1	1 ¹ / ₂	1 ¹ / ₈	No	OK
246	86	1	1	3 ¹ / ₈	No	OK
247	87	1 ³ / ₄	1	3 ¹ / ₈	No	OK
248	87	2 ³ / ₄	1 ¹ / ₂	1	Yes	OK
249	87	1 ¹ / ₂	1	3 ¹ / ₈	Yes	OK
250	88	1 ¹ / ₂	1	3 ¹ / ₈	No	OK
251	88	1 ¹ / ₂	1	3 ¹ / ₂	No	OK

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C COIL RT1 WELD MAP

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
253	1	1	1	1/8	NO	OK
254	1	1	1	1/8	NO	OK
255	1	2	1 5/8	1/8	NO	OK
256	1	1 1/2	1	3/8	NO	OK
257	2	2 1/2	1 1/2	3/8	NO	OK
258	2	1	1	5/8	NO	OK
259	2	4	1	3/8	NO	OK
260	3	2	1 1/2	1/2	YES	OK
261	3	4	2	3/4	YES	OK
262	4	1	1/2	3/8	NO	OK
263	5	1	1	3/8	NO	OK
264	5	1 1/2	1 1/2	1/2	YES	OK
265	6	1	1	5/8	NO	OK
266	6	9 1/4	2	3/8	NO	OK
267	7	1 1/2	1/2	1/4	NO	OK
268	7	2	1 1/2	1/4	NO	OK
269	7	3	2	1/4	NO	OK
270	7	5	2	1/8	NO	OK
271	7	4	2	1/8	NO	OK
272	7	1 1/2	1 1/2	1/4	NO	OK
273	7	1 1/2	1	1/4	NO	OK
274	7	1	1	3/8	NO	OK
275	8	2	1	1	YES	OK
276	8	1	1	3/8	NO	OK
277	8	1 1/2	1	1/2	NO	OK
278	8	1	1	1/2	NO	OK
279	8	2 1/2	2	5/8	NO	OK
280	9	2 1/2	2	5/8	NO	OK
281	9	2	2	1/2	YES	OK
282	10	1	1	1/8	NO	OK
283	11	4	1 1/2	1/2	YES	OK
284	11	3	1	1/2	YES	OK
285	12	2	1/2	1/4	NO	OK

1. Weld maps submitted to EIO/PPPL on 3/23/05 By: RS
 2. Weld maps approved by EIO/PPPL on NA By: _____

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C COIL RT1 WELD MAP

Defect Number	Photo Number	Length Inches	Width Inches	Depth Inches	Over 10% Wall Yes/No	Weld Permeability Result
286	12	2	2	1	YES	OK
287	12	2	2	1/2	YES	OK
288	12	1	1	1/4	NO	OK
289	12	2 1/2	2	3/8	NO	OK
290	12	4	2	1/4	NO	OK
291	12	1 1/2	1	3/8	NO	OK
292	12	1 1/2	1	1/8	NO	OK
293	12	2	1	3/8	NO	OK
294	12	3	1	5/8	NO	OK
295	12	2	1	3/8	NO	OK
296	13	1	1	1/4	NO	OK
297	13	2	1	1/4	NO	OK
298	13	1	1	1/8	NO	OK
299	13	1 1/2	1 1/2	1/2	NO	OK
300	13	2	1	3/8	NO	OK
301	13	3	2 1/2	1 1/4	YES	OK
302	13	6 1/2	3 1/2	1 1/2	YES	OK
303	13	3 1/2	3 1/2	1	YES	OK
304	14	2 1/2	2 1/2	1	YES	OK
305	14	4	3	1	YES	OK
306	14	1 1/2	1 1/2	3/8	NO	OK
307	15	4	2	3/8	NO	OK
308	15	4	2	3/8	NO	OK
309	15	2 1/2	2 1/2	5/8	NO	OK
310	16	2 1/2	2 1/2	1/2	YES	OK
311	17	3 1/2	3	3/8	NO	OK
312	17	1	1	1/8	NO	OK
313	17	3	1 1/2	1/8	NO	OK
314	17	3	1 1/2	1/8	NO	OK
315	17	2 1/2	2 1/2	3/8	NO	OK
316	17	2 1/2	2	3/8	NO	OK
317	17	1 1/2	1	1/8	NO	OK
318	18	1	1	1/8	NO	OK

1. Weld maps submitted to EIO/PPPL on
2. Weld maps approved by EIO/PPPL on

3/23 By: RS
NA By: _____

A10



C-1 Doc Package
Document # 17

Carondelet Division

8600 Commercial Blvd. - Pevely, MO 63070 USA
Phone: 636-479-4499 - Fax: 636-479-3399

Final Inspection Report

Customer Name: ENERGY INDUSTRIES OF OHIO
Pattern: MCWF-C1

Order Number: PPPL-FP-LTS-2

Revised 7/26/05

ASTM Metal CF8MNMN MOD

Date 7/26/2005

Type Description	Cert Number	Procedure	Acceptance Criteria	Actual
Radiographic	S73140-1	Technique # 12726	MSS SP 54	Acceptable
Liquid Penetrant	S73140-1	CQP - 300 Rev 9	SEE NOTE	Acceptable
Notes Acceptance per ASTM A903. Acceptance criteria - level 1 for high stressed areas, level 2 for all other areas.				
Mag Perm	S73140-1	SOP Mag Perm 100 Rev 1	<1.02	Acceptable
Visual	S73140-1	CQP - 500 REV 4	ASTM A802 LEVEL 2	Acceptable

Liquid Penetrant

Technician: Kevin Anderson
ASNT Level II

Respectfully Submitted,
Charles A. Ruud
Quality Assurance Manager

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Industries of OHIO		PURCHASE ORDER NUMBER 28030003			DATE 1-19-05		CONTROL NO. 40851		PAGE 1 of 6		
PART NO. MCWF-C1		SPECIFICATION MSS-SP-54		CLASS See Spec		TOTAL PIECES 1		PIECES ACCEPTED 1			
RADIOGRAPHED BY: Cooperheat/MRS				INTERPRETED BY: Kelley/Suria			ASNT LEVEL II				
FILM TYPE Kodak		MATERIAL CF8M		ISOTOPE IRIDIUM 192				CODE ASTM E94 / ASME		MIL-STD-453	
				COBALT 60						COMMENTS	
		V I E W		P E N E		A C C E P T		R E J E C T		S H R I N K	
						I N C L U S I O N		P O R O S I T Y		L I N E A R	
						S U R F A C E		L O F / L O P			
CRT, 1											
Inside Rail		1-2		60 120		/				/	
		2-3		60 120		/				/	
		3-4		60 120		/		2		/	
		4-5		/		/		3		/	
		5-6		/		/				/	
		6-7		60 120		/				/	
		7-8		60 80		/				/	
		8-9		60 120		/				/	
		9-10		/		/				/	
		10-11		/		/				/	
		11-12		/		/				/	
		12-13		/		/		2		/	
		13-14		/		/		X		/	
		14-15		/		/				/	
		15-16		/		/				/	
		16-17		/		/				/	
		17-18		/		/				/	
		18-19		/		/				/	
		19-20		/		/				/	
		20-21		/		/				/	

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Industries of OHIO		PURCHASE ORDER NUMBER 28030003			DATE 1-19-05		CONTROL NO. 40851		PAGE 3 of 6		
PART NO. MCWF-C1		SPECIFICATION MSS-SP-54		CLASS SeeSpec		TOTAL PIECES 1		PIECES ACCEPTED 1			
RADIOGRAPHED BY: Cooperheat/MQS			INTERPRETED BY: Kelley/Suria			ASNT LEVEL II					
FILM TYPE Kodak		MATERIAL CF8M/MV Mod			ISOTOPE Varian model 6200 IRIDIUM 192 COBALT 60			CODE ASTM E94 ✓ ASME MIL-STD-453			
		VIEW		ACCEPT		REJECT		SHRINK		INCLUSION	
		PENE		SURFACE		POROSITY		LINEAR		LOF/LOOP	
C.R.T.1										COMMENTS	
Body		13-14		50							
		15-16								Excavations Processor Marks	
		16-17									
		18-19								Excavations	
		19-20								Excavations	
		20-21								Excavations	
		21-22								Excavations	
		23-24				X X				Excavations	
		24-25								Excavations	
		26-27								Excavations	
		27-28		↓ End Material		X X					
		29-30		30		X X					
		30-31								excavation-Processor Marks	
		32-33									
		33-34								Processing Marks	
		35-36								excavations, Film Scratch	
		36-37				X X					
		38-39								excavations	
		39-40		↓		X X					
↓		41-42		30 40		X X					

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Industries of Ohio		PURCHASE ORDER NUMBER 28030003			DATE 1-19-05		CONTROL NO. 40851		PAGE 4 of 6			
PART NO. MCWF-C1		SPECIFICATION MSS-SP-54		CLASS SeeSpec		TOTAL PIECES 1		PIECES ACCEPTED 1				
RADIOGRAPHED BY: Cooperheat/MDS				INTERPRETED BY: Kelley/Suria				ASNT LEVEL II				
FILM TYPE Kodak		MATERIAL CF8M N/Mu Mpd			ISOTOPE Varian model 6200 IRIDIUM 192 COBALT 60			CODE ASTM E94 / ASME MIL-STD-453				
		V I E W	P E N E	A C C E P T	R E J E C T	S H R I N K	I N C L U S I O N	P O R O S I T Y	L I N E A R	S U R F A C E	L O P / L O P	COMMENTS
CRT.1												
Body		42-43	30 40	/								excavation-Processor Mark
		44-45		/								Processor Marks
		45-46		/			1					excavation-Processor Mark
		47-48		/			2					excavation-Processor Mark
		48-49	↓		X	X						
		50-51	↓	/								excavation-Processor Mark
		52-53	30/100 40/140		X	X						
		53-54	↓	/								excavation-Film Scratch
		54-55	30 40/100	/								excavation-Film scratches
		55-56	↓	/								
		56-57	↓	/								excavation-Processor Marks
		57-58	60 140		X	X						
		58-59	30 40	/		1	1					excavation-Light Leak
		59-60	↓	/								excavations
		60-61	↓	/								
		62-63	↓	/			1	1				excavations
		63-64	30	/			1					excavations
		65-66	60/180 140/200	/								excavations
		67-68	30 40/60 40		X	X						
		68-69	40 30	/		1						excavations

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER <i>Energy Industries of OHIO</i>		PURCHASE ORDER NUMBER <i>28030003</i>			DATE <i>1-19-05</i>		CONTROL NO. <i>40851</i>		PAGE <i>5 of 6</i>		
PART NO. <i>MCWF-C1</i>		SPECIFICATION <i>MSS-SP-54</i>		CLASS <i>See Spec</i>		TOTAL PIECES <i>1</i>		PIECES ACCEPTED <i>1</i>			
RADIOGRAPHED BY: <i>Cooperheat/MRS</i>			INTERPRETED BY: <i>Kelley/Suria</i>			ASNT LEVEL <i>H</i>					
FILM TYPE <i>Kodak</i>		MATERIAL <i>CF8Mw Mod</i>		ISOTOPE <i>Varian model 62000</i>				CODE <i>ASTM E94 / ASME MIL-STD-453</i>			
				<i>IRIDIUM 192</i>		<i>COBALT 60</i>					
								COMMENTS			
CET.1											
Body		<i>69-70</i>		<i>30 100 40 120</i>		<i>X X</i>					
		<i>71-72</i>		<i>30 80 50 100</i>						<i>Processor Marks</i>	
		<i>72-73</i>		<i>↓</i>						<i>excavation - Film scratch</i>	
		<i>73-74</i>		<i>30 80 40</i>		<i> </i>				<i>excavation Film scratch</i>	
		<i>74-75</i>		<i>↓</i>						<i>Excavations, crimp</i>	
		<i>75-76</i>		<i>30 40</i>							
		<i>76-77</i>		<i>↓</i>						<i>Excavations</i>	
		<i>78-79</i>		<i>30 40 60</i>						<i>Processor marks</i>	
		<i>79-80</i>		<i>30 40</i>							
		<i>80-81</i>		<i>↓</i>							
		<i>81-82</i>		<i>↓</i>		<i> </i>					
		<i>83-84</i>		<i>30 40 60</i>							
		<i>85-86</i>		<i>30 40</i>							
		<i>86-87</i>		<i>30 40 20</i>							
		<i>87-88</i>		<i>30 40</i>							
		<i>88-89</i>		<i>30 60 40</i>		<i>X X</i>					
		<i>90-91</i>		<i>30 40</i>							
		<i>92-93</i>		<i>↓</i>						<i>Excavation</i>	
		<i>v94</i>		<i>50</i>		<i>X X</i>					
↓		<i>v95</i>		<i>↓</i>						<i>Processor Mark</i>	

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER Energy Industries of Ohio		PURCHASE ORDER NUMBER 28030003			DATE 1-19-05		CONTROL NO. 40851		PAGE 6 of 6			
PART NO. MCWF-C1		SPECIFICATION MSS-SP-54		CLASS See Spec		TOTAL PIECES 1		PIECES ACCEPTED 1				
RADIOGRAPHED BY: Cooperheat/MAS			INTERPRETED BY: Kelly/Suria			ASNT LEVEL II						
FILM TYPE Kodak		MATERIAL CF8M		ISOTOPE VARIAN model 6200 IRIDIUM 192 COBALT 60				CODE ASTM E94 / ASME MIL-STD-453				
		V I E W	P E N E	A C C E P T	R E J E C T	S H R I N K	I N C L U S I O N	P O R O S I T Y	L I N E A R	S U R F A C E	L O F / L O P	COMMENTS
C.R.T.I Body		96-97	50	/								Excavations
		97-98		/								Excavations
		98-99		/								Excavations
		100-101			X	X						
		101-102		/								Excavations
		102-103		/								Excavations
		103-104			X	X						Excavations
		104-105			X	X				/		excavations
		106-107			X				X	/		excavations
		107-108		/				1		/		
		108-109		/						/		excavations
		109-110			X	X				/		excavations
		111-112		/						/		excavations - Processor marks
		112-113		/				1		/		Film scratch: excavations
		114-115			X				X			
		115-116		/						/		excavations Processor Marks
↓		116-117	↓		X				X			
↓		V64	20 30		X	X						

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER <i>Energy Industries of OHIO</i>		PURCHASE ORDER NUMBER <i>2803 0003</i>			DATE <i>3-19-05</i>		CONTROL NO. <i>40851</i>		PAGE <i>1 of 2</i>		
PART NO. <i>MCWF-C1</i>		SPECIFICATION <i>ASS-SP-54</i>		CLASS <i>See Spec</i>		TOTAL PIECES <i>1</i>		PIECES ACCEPTED <i>1</i>			
RADIOGRAPHED BY: <i>Cooperheat/MRS</i>				INTERPRETED BY: <i>Cooperheat/MRS/Kella</i>			ASNT LEVEL <i>II</i>				
FILM TYPE <i>Kodak</i>		MATERIAL <i>CF8M WW Mod</i>		ISOTOPE <i>varian model 2600</i>				CODE <i>ASTM E94 / ASME MIL-STD-453</i>			
				IRIDIUM 192		COBALT 60				COMMENTS	
<i>Repair views</i>		VIEW	PENETRATION	ACCEPTANCE	REJECTION	SHIRTS	INCLUSIONS	POROSITY	LINEAR	SURFACE	LOF/LOP
<i>CRT-1</i>											
<i>Body</i>		<i>8-9</i>	<i>50</i>	<i>/</i>					<i>/</i>		<i>Film Mark</i>
		<i>23-24</i>	<i> </i>	<i>/</i>							
		<i>27-28</i>	<i>↓</i>	<i>/</i>					<i>/</i>		
		<i>29-30</i>	<i>30</i>		<i>X</i>			<i>FBK</i>		<i>X</i>	
		<i>36-37</i>	<i> </i>	<i>/</i>		<i>1</i>	<i>1</i>				
		<i>39-40</i>	<i>↓</i>	<i>/</i>					<i>/</i>		
		<i>41-42</i>	<i>30/40</i>	<i>/</i>		<i>1</i>					
		<i>48-49</i>	<i>↓</i>	<i>/</i>		<i>1</i>	<i>1</i>		<i>/</i>		
		<i>52-53</i>	<i>30/40</i> <i>100/140</i>	<i>/</i>		<i>2</i>	<i>1</i>		<i>/</i>		
		<i>57-58</i>	<i>60/40</i>	<i>/</i>					<i>/</i>		
		<i>67-68</i>	<i>30/40</i> <i>60/40</i>	<i>/</i>					<i>/</i>		
		<i>69-70</i>	<i>30/100</i> <i>40/20</i>	<i>/</i>		<i>1</i>					
		<i>88-89</i>	<i>30/40</i> <i>60/40</i>	<i>/</i>	<i>FBK</i>	<i>2</i>					<i>OK R.S</i>
		<i>V94</i>	<i>50</i>	<i>/</i>					<i>/</i>		
		<i>100-101</i>	<i> </i>	<i>/</i>		<i>3</i>					
		<i>101-102</i>	<i> </i>	<i>/</i>		<i>3</i>					
		<i>103-104</i>	<i> </i>	<i>/</i>		<i>3</i>					
		<i>104-105</i>	<i> </i>	<i>/</i>		<i>1</i>					
		<i>106-107</i>	<i> </i>	<i>/</i>	<i>FBK</i>	<i>2</i>		<i>FBK</i>	<i>/</i>		
		<i>109-110</i>	<i>↓</i>	<i>/</i>		<i>2</i>					

RADIOGRAPHIC INTERPRETATION REPORT

CUSTOMER <i>Energy Industries of Ohio</i>		PURCHASE ORDER NUMBER <i>28030003</i>			DATE <i>3-19-05</i>		CONTROL NO. <i>40851</i>		PAGE <i>2 of 2</i>		
PART NO. <i>MCWF-C1</i>		SPECIFICATION <i>M55-SP-54</i>		CLASS <i>sec spec</i>		TOTAL PIECES <i>1</i>		PIECES ACCEPTED <i>1</i>			
RADIOGRAPHED BY: <i>Cooper Heat/MQS</i>				INTERPRETED BY: <i>M. J. [Signature]</i>			ASNT LEVEL <i>II</i>				
FILM TYPE <i>Kodak</i>		MATERIAL <i>LF8MNMN mod</i>		ISOTOPE <i>Varian Model 2600</i>				CODE <i>ASTM E94 7 ASME MIL-STD-453</i>			
				IRIDIUM 192		COBALT 60		COMMENTS			
Repair views		V I E W	P E N E T	A C C E P T	R E J E C T	S H R I N K	I N C L U S I O N	P O R O S I T Y	L I N E A R	S U R F A C E	L O F / L O P
<i>CRT-1</i>											
<i>Body</i>		<i>114-115</i>	<i>50</i>	<i>/</i>			<i>1</i>	<i>1</i>	<i>/</i>		
<i>↓</i>		<i>116-117</i>	<i>↓</i>	<i>/</i>		<i>2</i>					<i>Processing mark</i>
<i>↓</i>		<i>V64</i>	<i>30</i>	<i>/</i>			<i>1</i>	<i>1</i>			
<i>Inside Rail</i>		<i>13-14</i>	<i>60/120</i>	<i>/</i>							
<i>↓</i>		<i>21-22</i>	<i>↓</i>	<i>/</i>		<i>2</i>					
<i>Body</i>		<i>29-30</i>	<i>30</i>	<i>/</i>		<i>1</i>	<i>1</i>	<i>1</i>			

TEAM COOPERHEAT-MQS, INC.

C-1 Doc Package
Document 18a
RADIOGRAPHIC TECHNIQUE SHEET

FORM 20.3-61 Rev. 4

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

CUSTOMER RSS NO.: _____ SHEET: _____ REV: _____
 MQS TECH. NO.: 12970 REV.1*
 MQS RSS NO.: _____

CUSTOMER METALTEK INTERNATIONAL DATE: 8-3-2005

PART NO. MCWF-C12103989 DESCRIPTION C COIL CASTING MATERIAL CF8MNM

TOTAL NUMBER OF VIEWS 121 NUMBER X-RAY VIEWS 121 NUMBER GAMMA RAY VIEWS 0

MACH(s) MAKE(s) VARIAN MODEL(s) L2000 S/N(s) 20 MAX KV(s) 7500

SOURCE(s) N/A

PROCEDURE SPECIFICATION MSS-SP-54 ACCEPTANCE CRITERIA MSS-SP-54

MQS PROCEDURE NO. 20.H.010 REV. 0 PENETRAMETER SPEC. ASTM E142-86

PROCESSING: AUTOMATIC PROCESSOR B2000 MANUAL TEMPERATURE 27.2°

TECHNICIAN J.P., S.S. NDT LEVEL II APPROVED BY Chris Hudoff NDT LEVEL III

VIEW IDENTIFICATION	*	IEWS 1-2	THROUGH	116-117	BODY	
SOURCE/X-RAY MACH USED	VARIAN	IEWS A-B	THROUGH	DD-A	RAIL	
CURIES OR KV	7500			REV.1 :	CHANGED RAIL	IEWS TO
MA OR PULSES	N/A				LETTERS	RATHER THAN
SOURCE TO FILM DISTANCE	*				NUMBERS.	
EXPOSURE TIME OR RADS	*					
MATERIAL THICKNESS	1					
MATERIAL GROUP	1					
PENETRATRER SIZE/(AMT)	GP. <input type="checkbox"/>	*	SEE ATTACHED	INFORMATION		
SHIM BLOCK SIZE	GP. <input type="checkbox"/>	N/A				
FILM SIZE	*					
FILM TYPE/BRAND	*					
PB SCREEN, FRONT	.010					
PB SCREEN, BACK	.010					
SENSITIVITY	2-2T					
FILTER TYPE/LOCATION	N/A					
MASKING TYPE/LOCATION	N/A					
ANGLE	*					
NO. OF FILMS IN CASSETTE	*					
VIEWING: SING./DOUB./BOTH	S-B					
FOCAL SPOT SIZE	2 MM					
SKETCH AND/OR REMARKS	SEE ATTACHED					
GEOMETRIC UNSHARPNESS						

C-1 Doc Package Document 18a

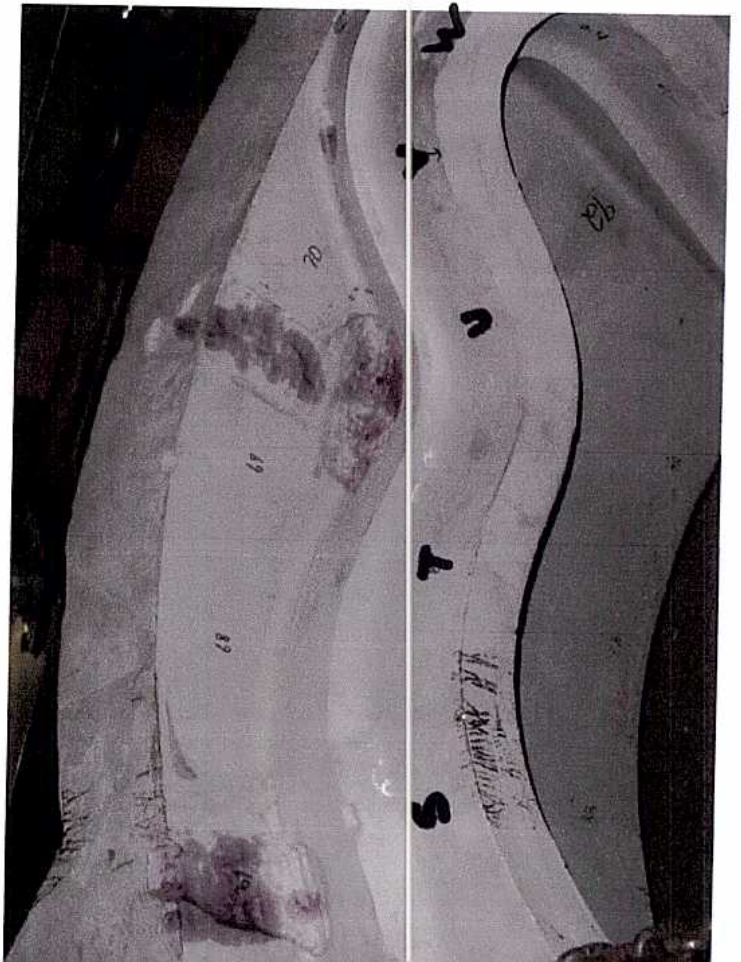
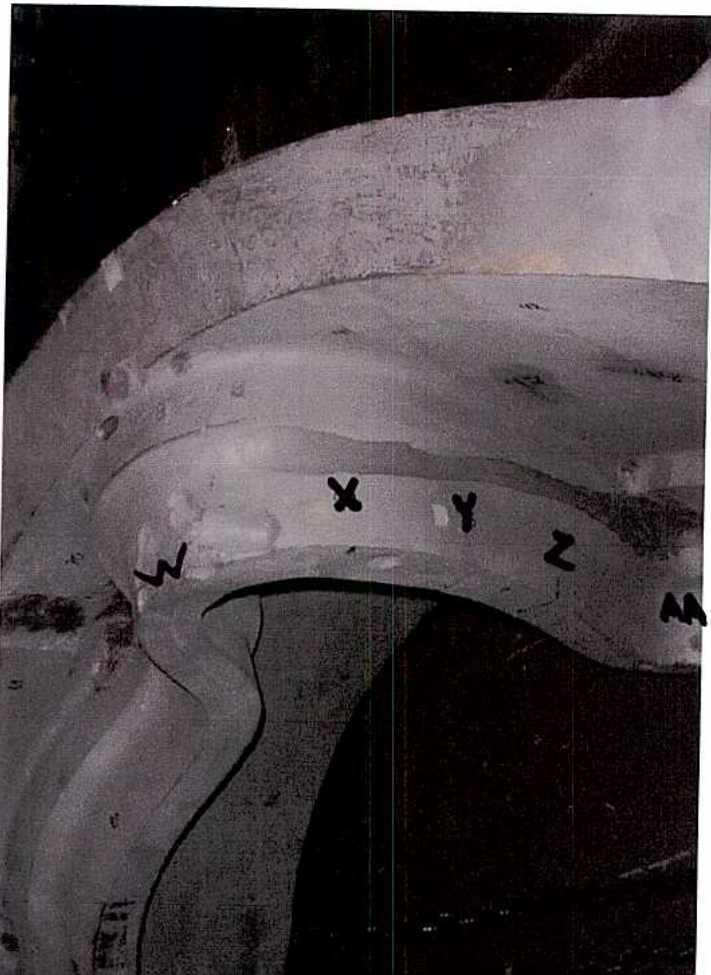
CUSTOMER MetaltexRSS # 12970 Rev.1PART NO. MCWF-C1

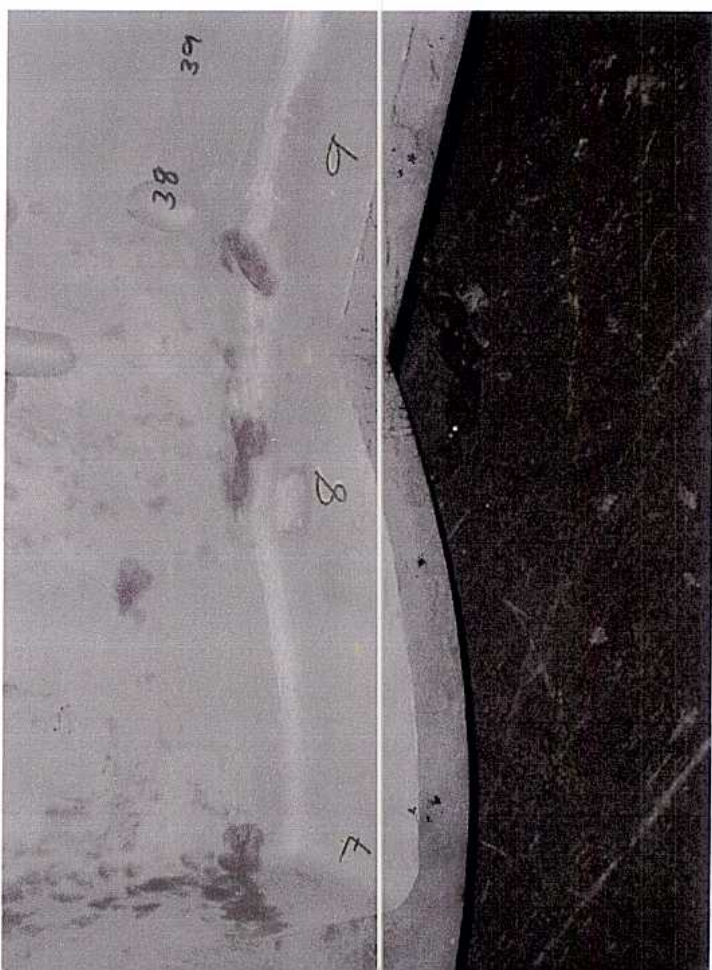
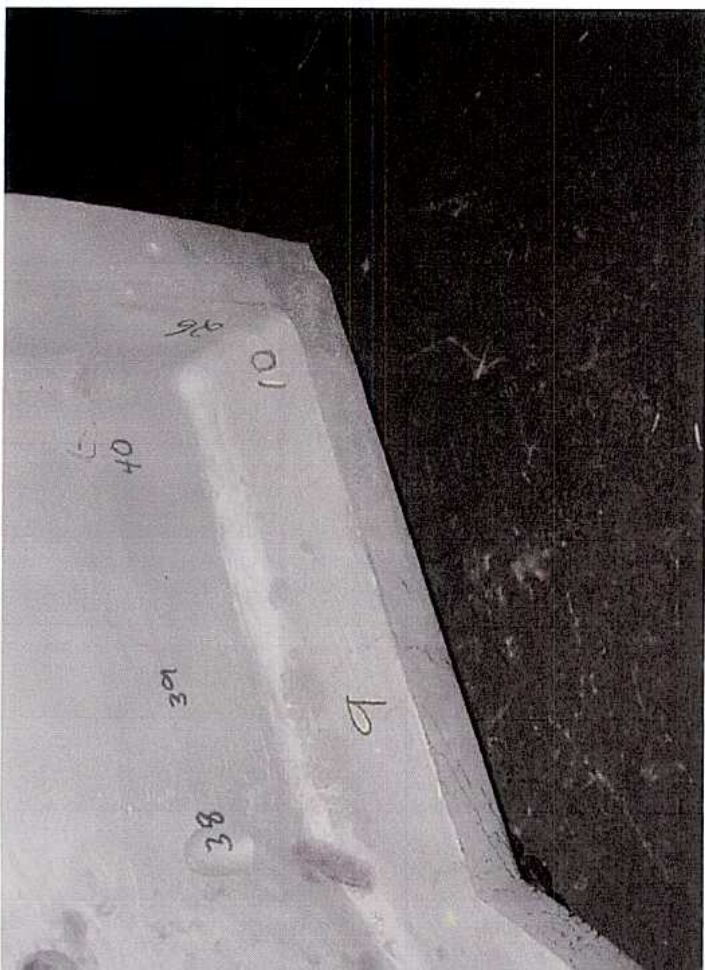
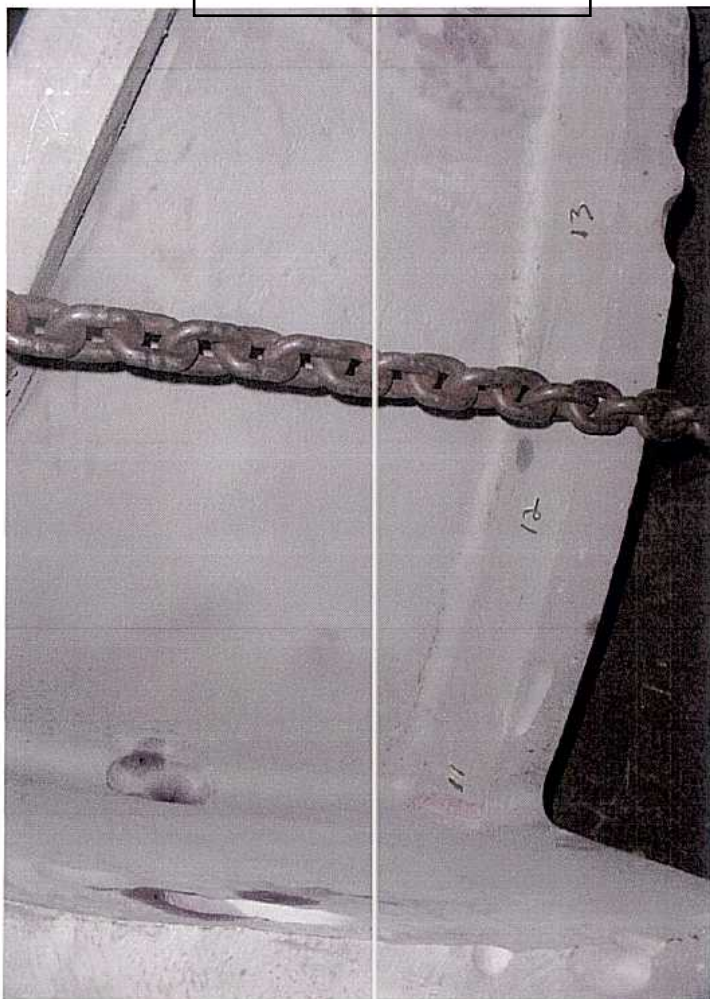
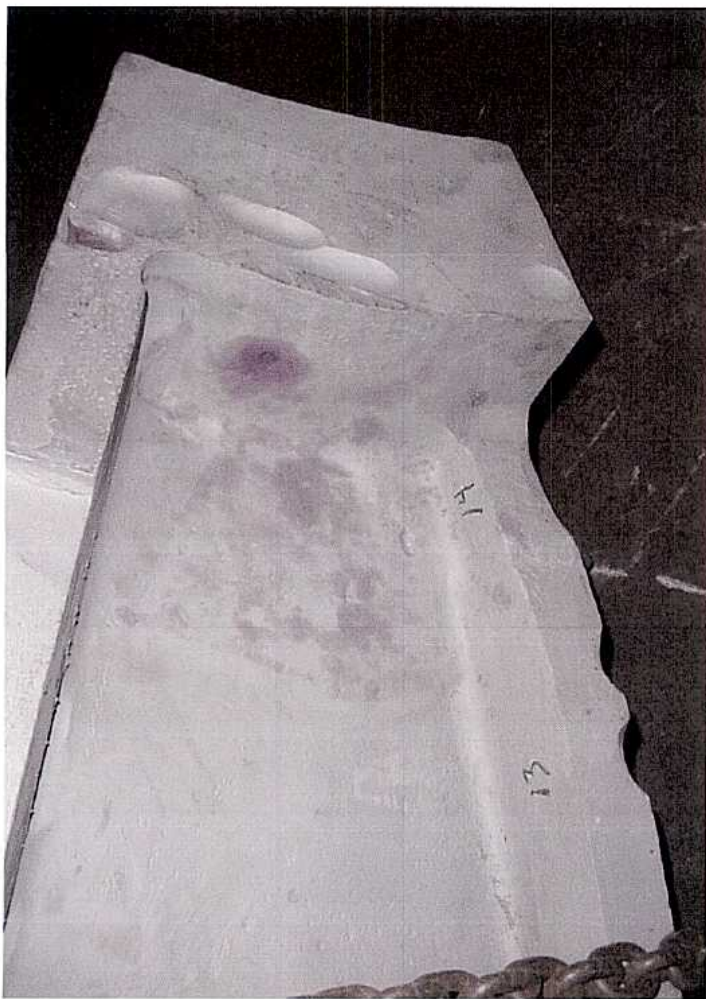
VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
1-2	65"	25 KR	T	14 X 17	2-3/4"	50(2)
2-3	65"	25 KR	T	14 X 17	2-3/4"	50(2)
3-4	65"	25 KR	T	14 X 17	2-3/4"	50(2)
4-5	65"	25 KR	T	14 X 17	2-3/4"	50(2)
5-6	65"	25 KR	T	14 X 17	2-3/4"	50(2)
7-8	65"	25 KR	T	14 X 17	2-3/4"	50(2)
8-9	65"	25 KR	T	14 X 17	2-3/4"	50(2)
9-10	65"	25 KR	T	14 X 17	2-3/4"	50(2)
11-12	65"	25 KR	T	14 X 17	2-3/4"	50(2)
12-13	65"	25 KR	T	14 X 17	2-3/4"	50(2)
13-14	65"	25 KR	T	14 X 17	2-3/4"	50(2)
15-16	65"	25 KR	T	14 X 17	2-3/4"	50(2)
16-17	65"	25 KR	T	14 X 17	2-3/4"	50(2)
18-19	65"	25 KR	T	14 X 17	2-3/4"	50(2)
19-20	65"	25 KR	T	14 X 17	2-3/4"	50(2)
20-21	65"	25 KR	T	14 X 17	2-3/4"	50(2)
21-22	65"	25 KR	T	14 X 17	2-3/4"	50(2)
23-24	65"	25 KR	T	7 x 17	2-3/4"	50(2)
24-25	65"	25 KR	T	7 x 17	2-3/4"	50(2)
26-27	65"	25 KR	T	7 x 17	2-3/4"	50(2)
27-28	65"	25 KR	T	7 x 17	2-3/4"	50(2)
29-30	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
30-31	70"	25 KR	M125	11 x 17	1-1/2"	30(2)
32-33	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
33-34	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
35-36	70"	25 KR	M125	11 x 14	1-1/2"	30(2)
36-37	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
38-39	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
39-40	70"	25 KR	M125	14 x 17	1-1/2"	30(2)
41-42	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
42-43	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
44-45	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
45-46	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
47-48	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
48-49	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
49-50-51	85"	35 KR	T/M125	14 X 17	1-1/2" - 2"	30, 40
52-53	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 7"	30,40,100,140
53-54	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 7"	30,40,100,140
54-55	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 5"	30,40,100

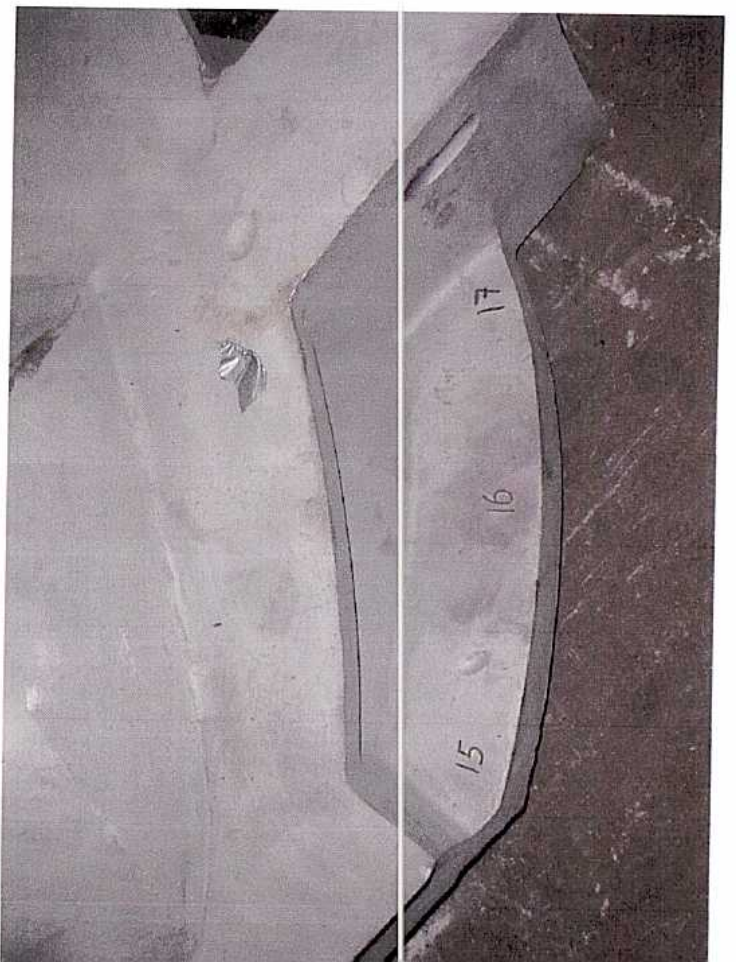
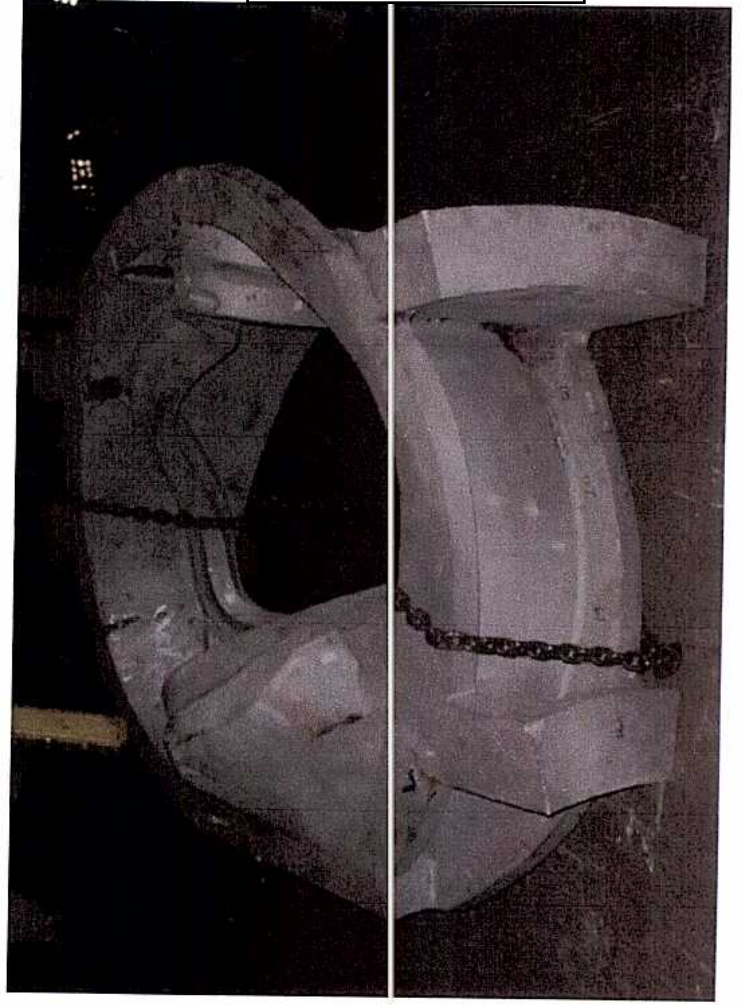
C-1 Doc Package Document 18a

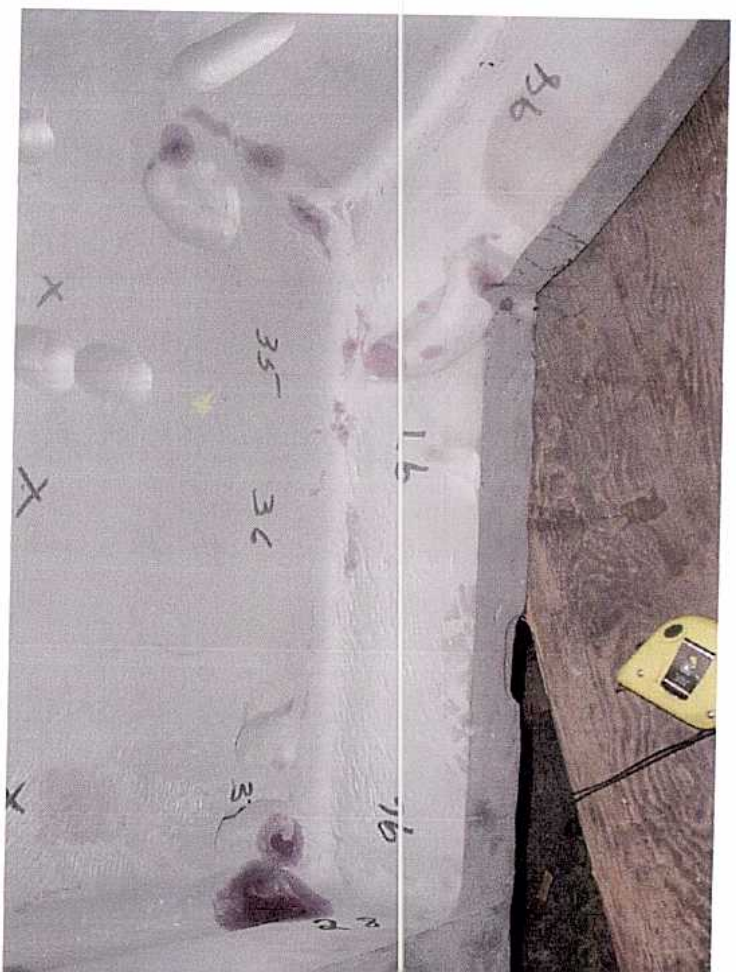
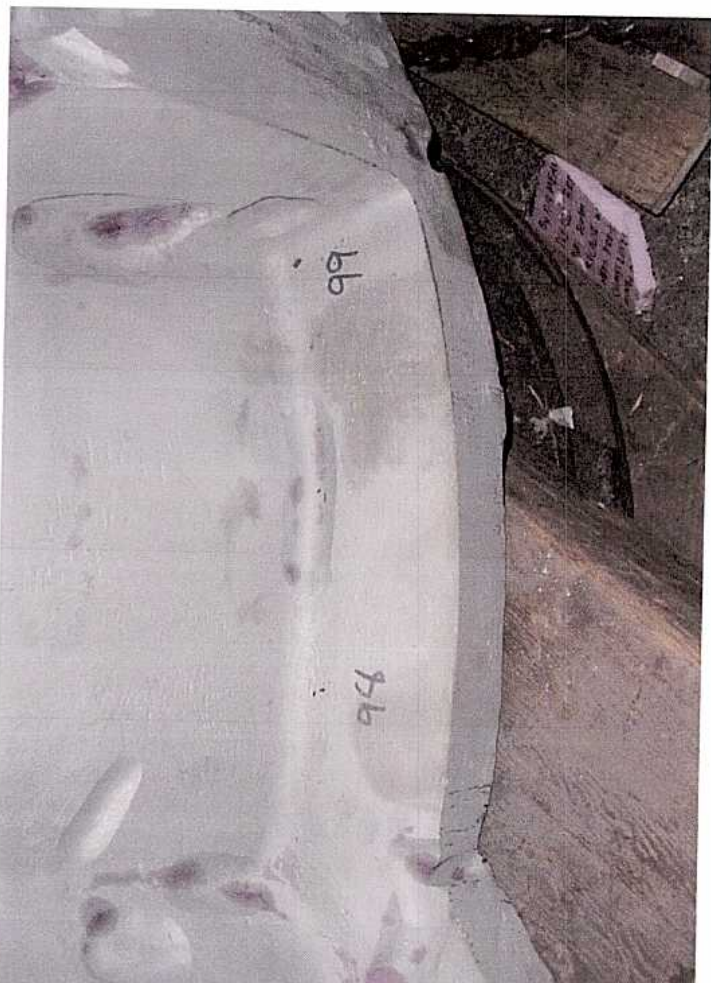
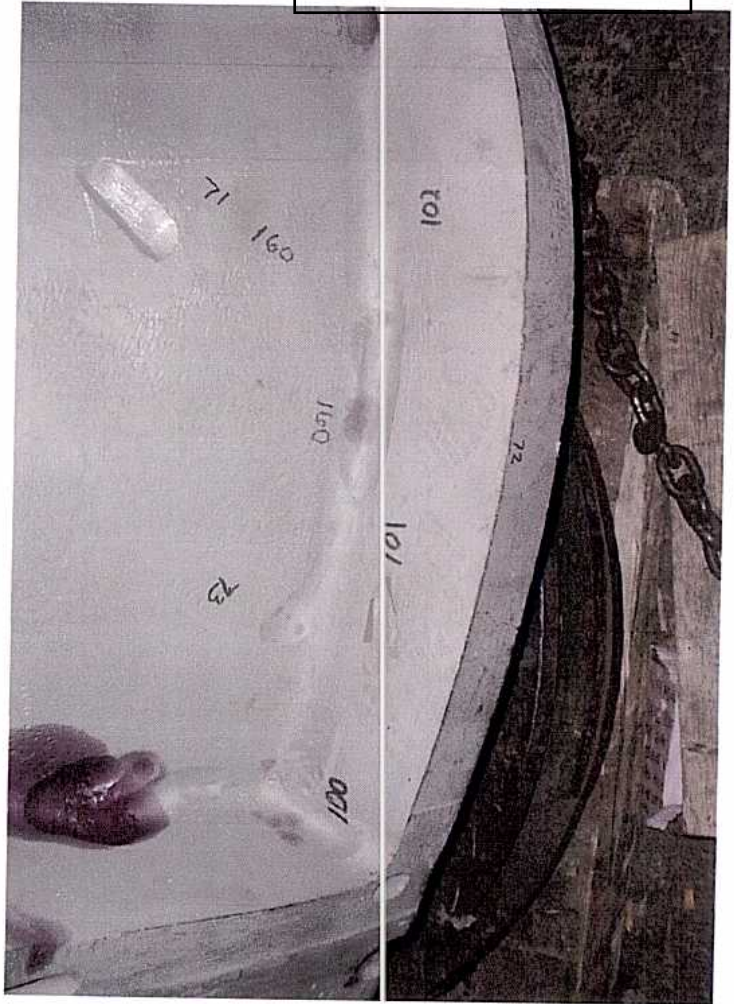
CUSTOMER Metaltex RSS # 12970 Rev.1 PART NO. MCWF-C1

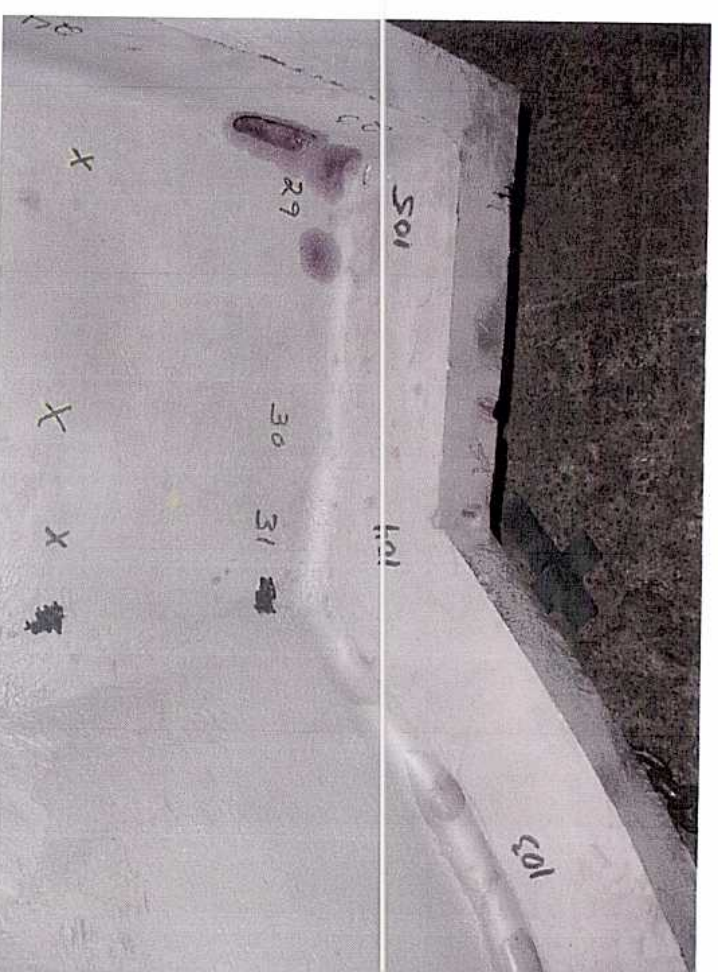
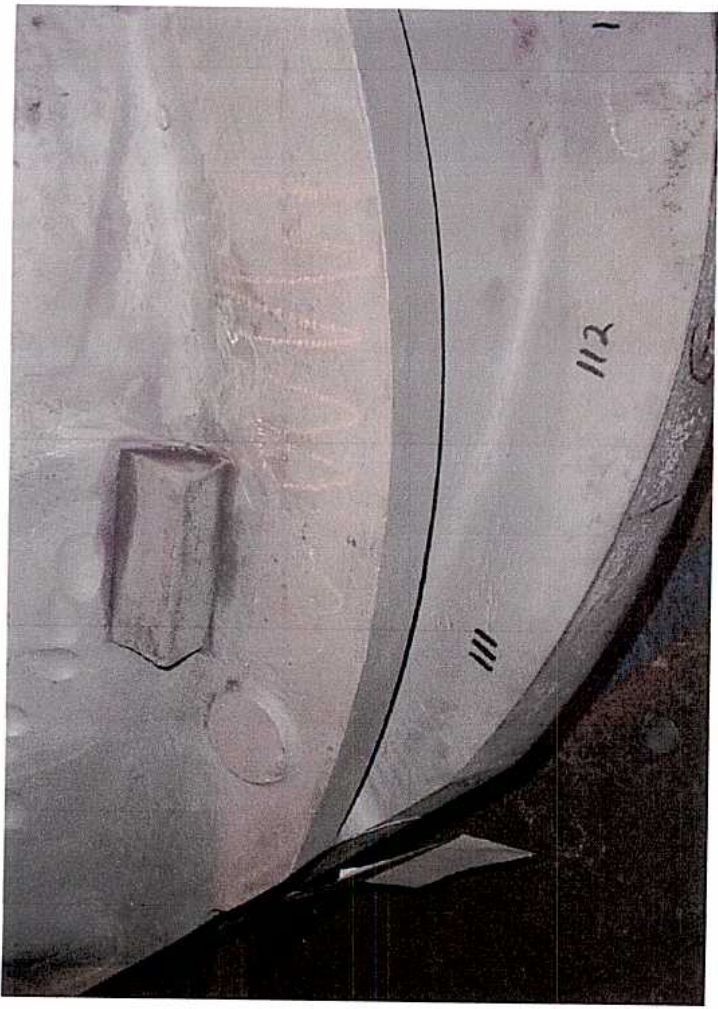
VIEW	SFD	EXP. TIME	FILM TYPE	FILM SIZE	THK. RANGE	IQI
55-56	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 5"	30,40,100
56-57	90"	40 KR	D8/T/AA/Dumb	14 x 17	1-1/2" - 5"	30,40,100
57-58	93"	65 KR	D8/AA/T/D8	14 x 17	3" - 7"	60,140
58-59	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
59-60	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
60-61	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
62-63	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
63-64	90"	35 KR	T/M125	14 x 17	1-1/2"	30(2)
65-66	90"	150 KR	D8/AA/T/D8	14 x 17	3" - 10"	60,140,180,200
67-68	90"	40 KR	T/M125	14 x 17	1-1/2" - 3"	30,40,60
68-69	90"	40 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
69-70	90"	55 KR	D8/M125/AA	14 x 17	1-1/2" - 6"	30,40,100,120
V64	90"	40 KR	M125/M100	11 X 14	1" - 1-1/2"	20,30
71-72	80"	50 KR	AA/M125/T	14 x 17	1-1/2" - 5"	30,50,60,80,100
72-73	80"	90 KR	AA/M125/M100/T	14 x 17	1-1/2" - 5"	30,50,60,80,100
73-74	80"	35 KR	T/M125	14 x 17	1-1/2" - 4"	30,40,80
74-75	80"	35 KR	T/M125	14 x 17	1-1/2" - 4"	30,40,80
75-76	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
76-77	80"	30 KR	T/M125	11 x 14	1-1/2" - 2"	30,40
78-79	80"	35 KR	T/M125	14 x 17	1-1/2" - 3"	30,40,60
79-80	80"	35 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
80-81	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
81-82	80"	30 KR	T/M125	7 x 17	1-1/2" - 2"	30,40
83-84	80"	35 KR	T/M125	14 x 17	1-1/2" - 3"	30,40,60
85-86	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
86-87	80"	60 KR	D8/M125/T	14 x 17	1-1/2" - 6"	30,40,120(2)
87-88	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
88-89	80"	40 KR	AA/M125/T	14 x 17	1-1/2" - 3"	30,40,60
90-91	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
92-93	80"	30 KR	T/M125	14 x 17	1-1/2" - 2"	30,40
V94	72"	25 KR	T	14 x 17	2-3/4"	50
V95	72"	25 KR	T	8 x 10	2-3/4"	50
96-97	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
97-98	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
98-99	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
100-101	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
101-102	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
102-103	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
103-104	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
104-105	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)
106-107	65"	25 KR	T/T	14 x 17	2-3/4"	50(2)

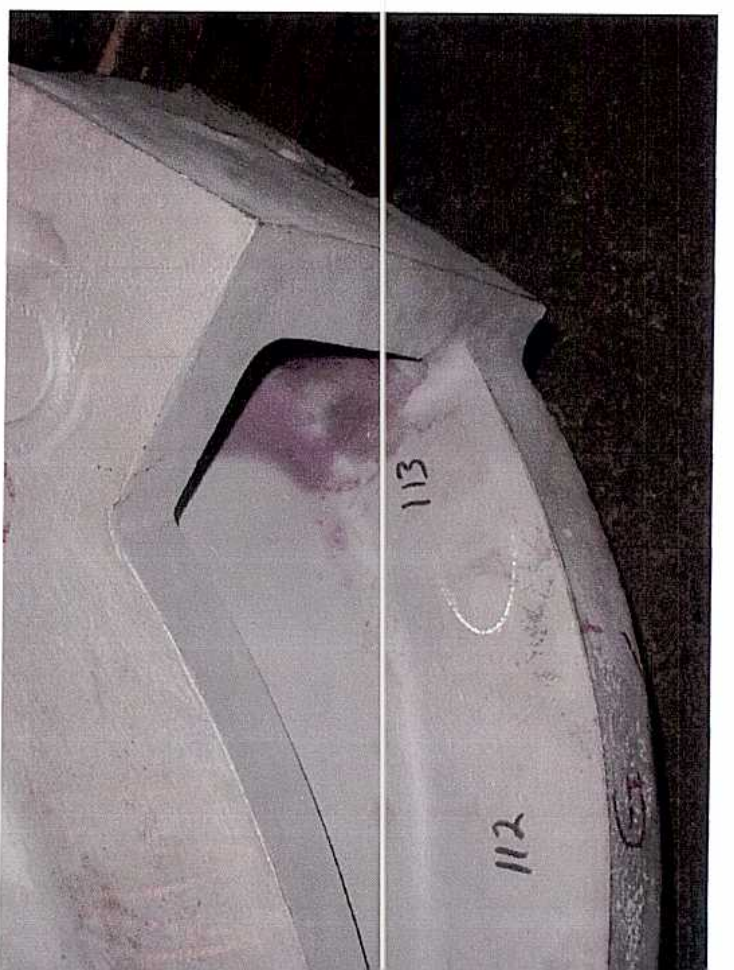
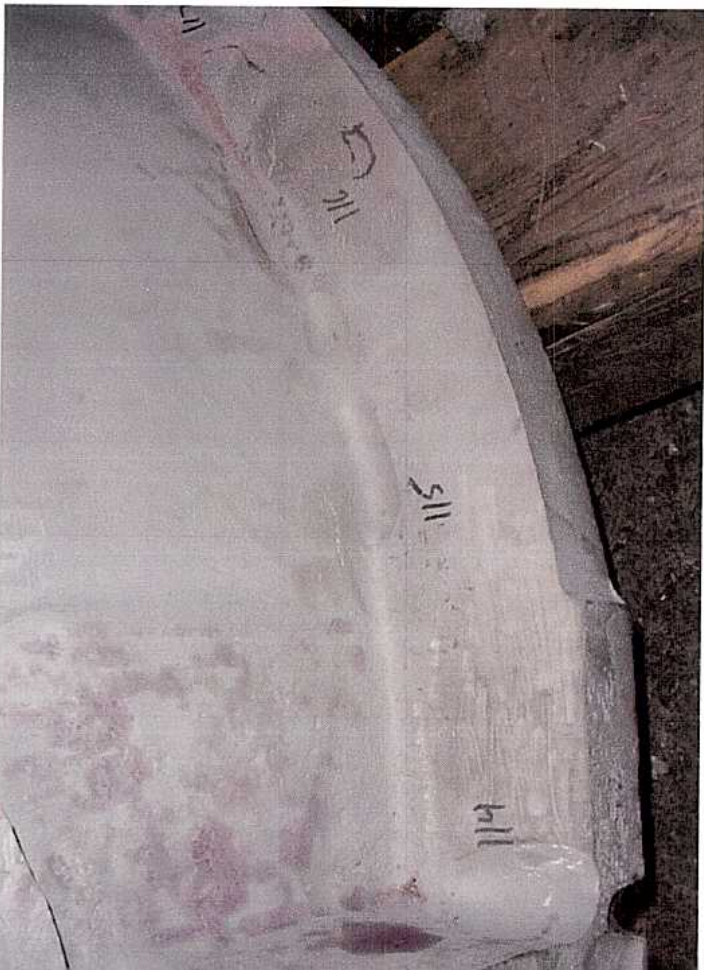
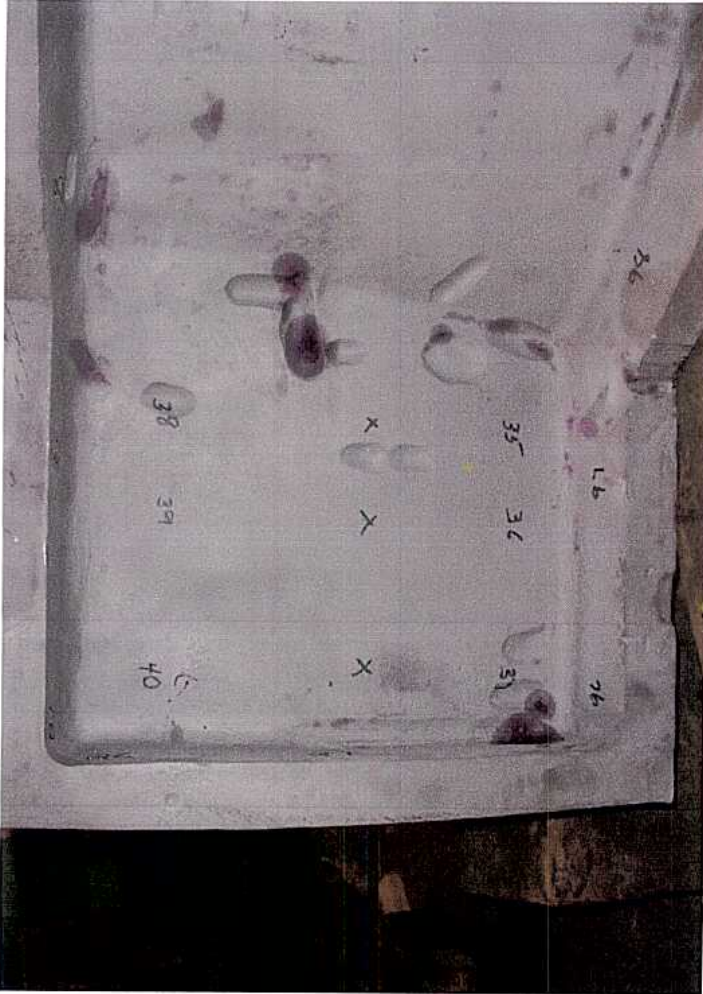


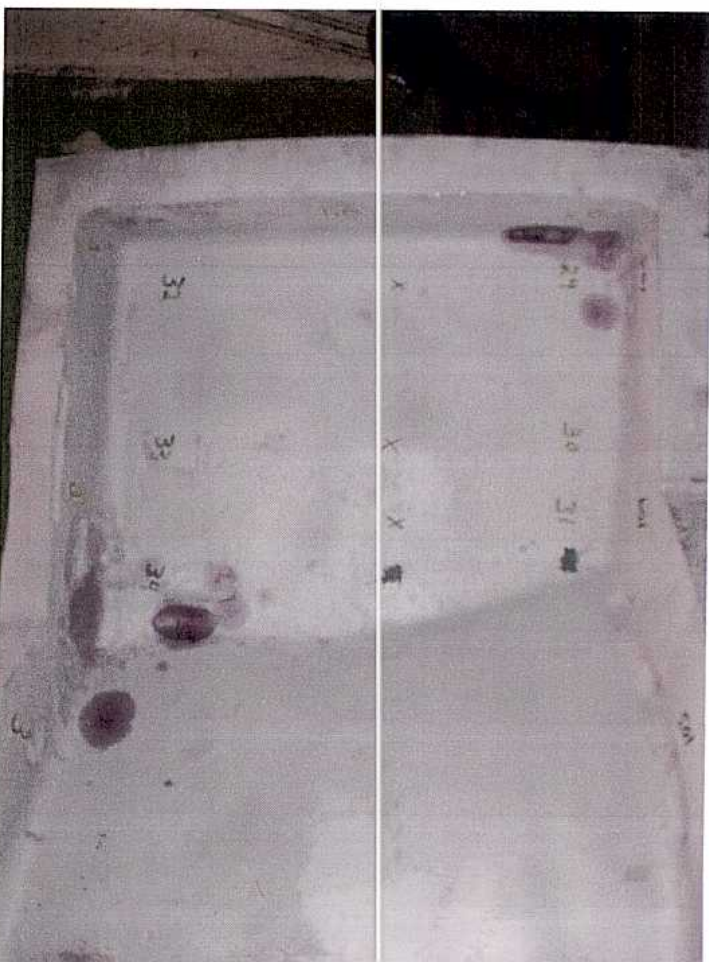
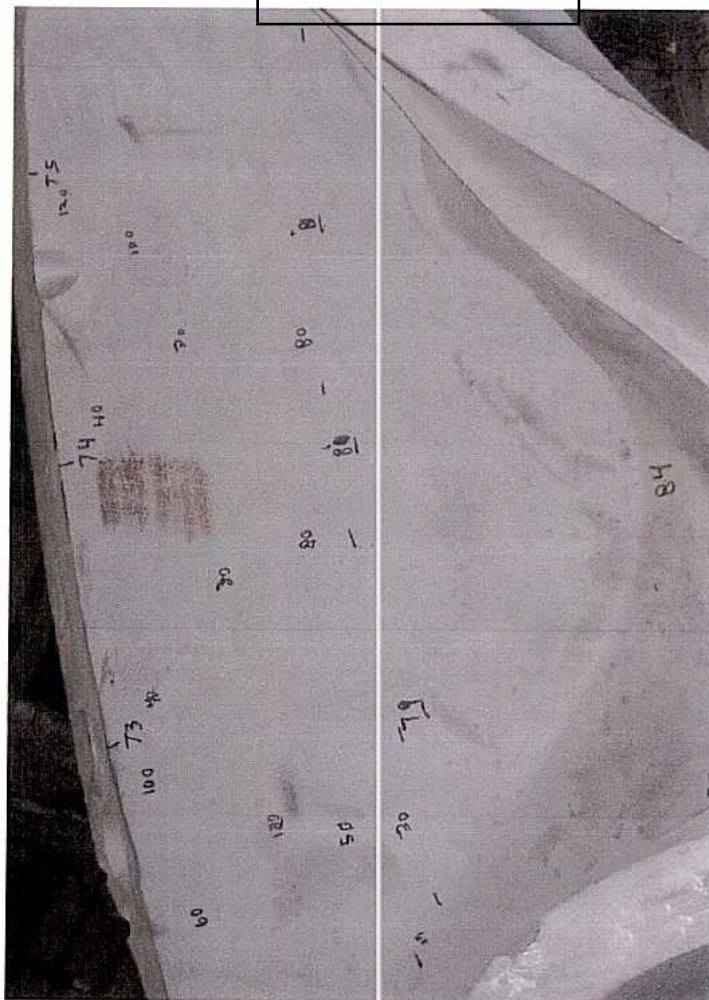


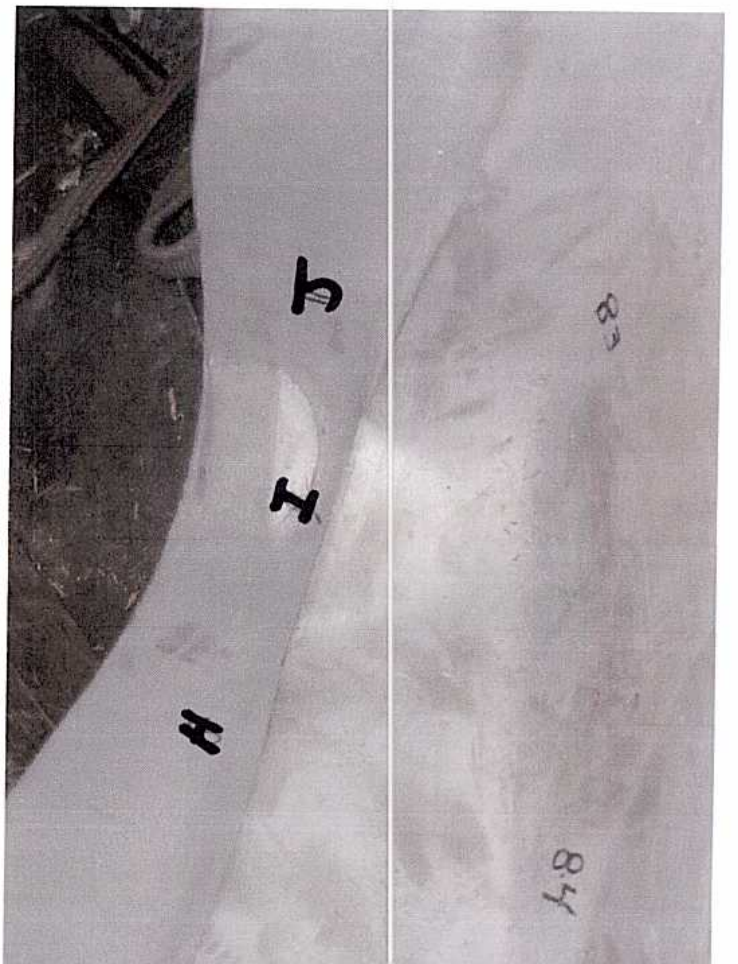
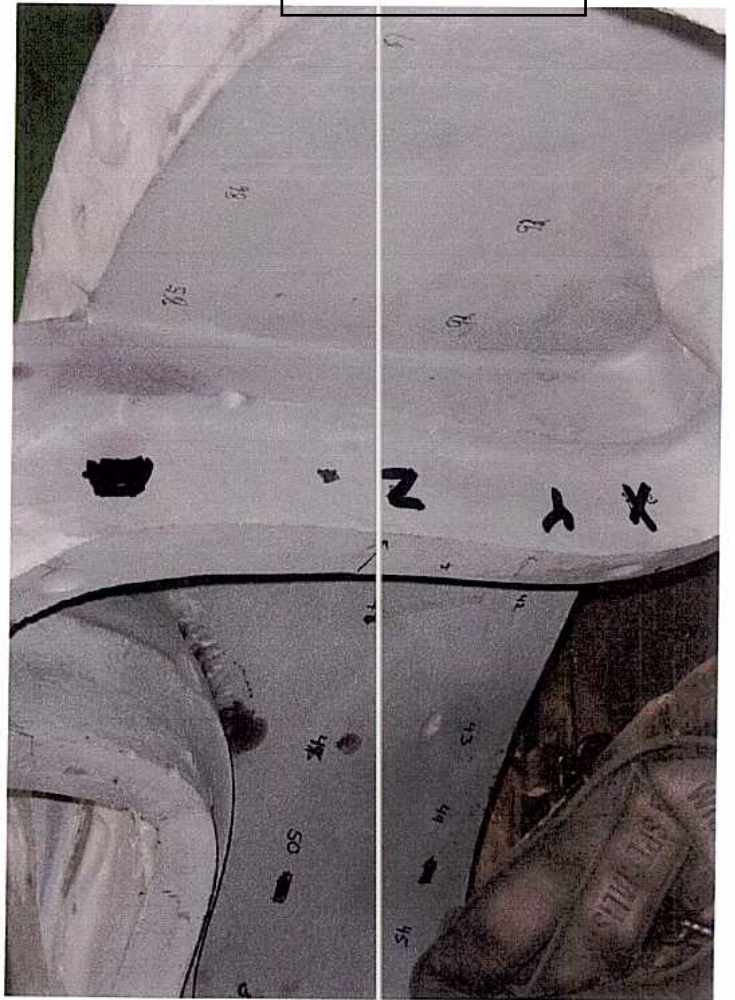


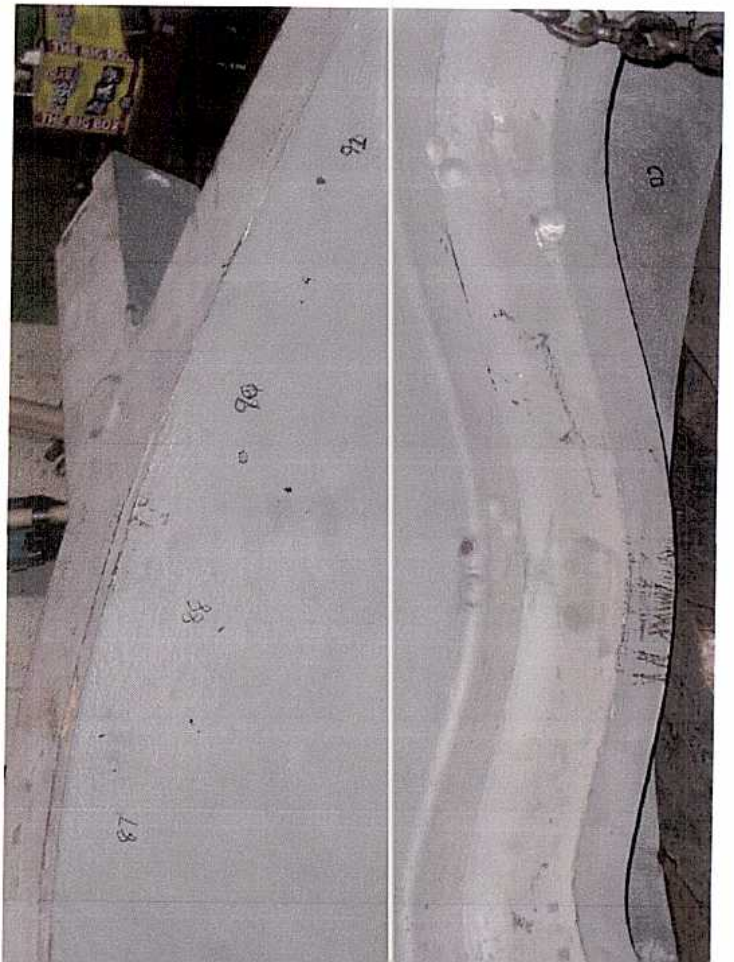
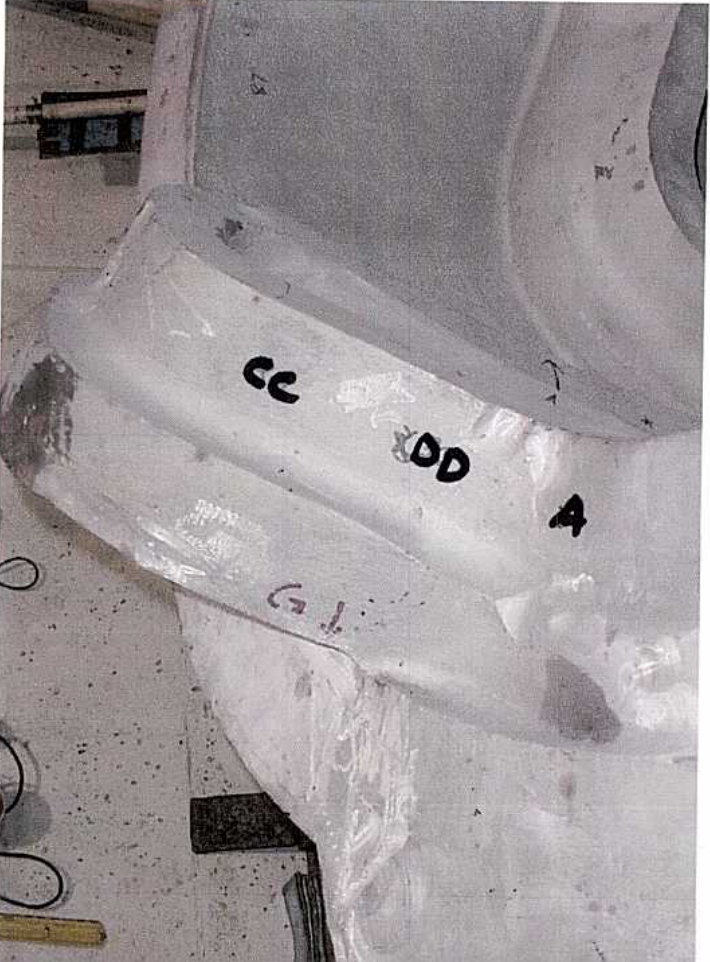


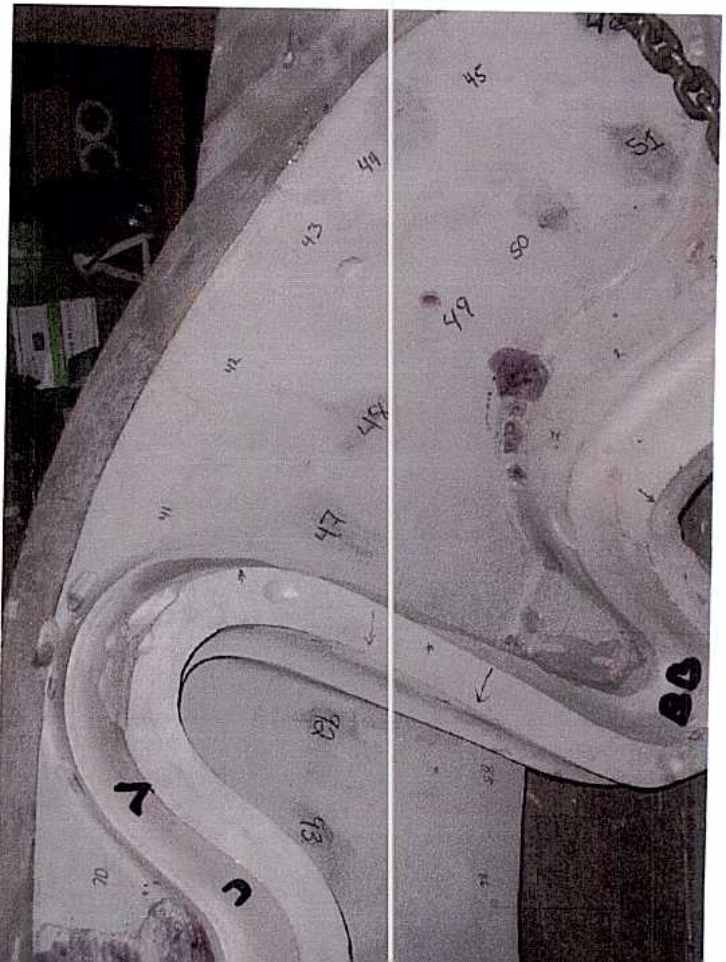
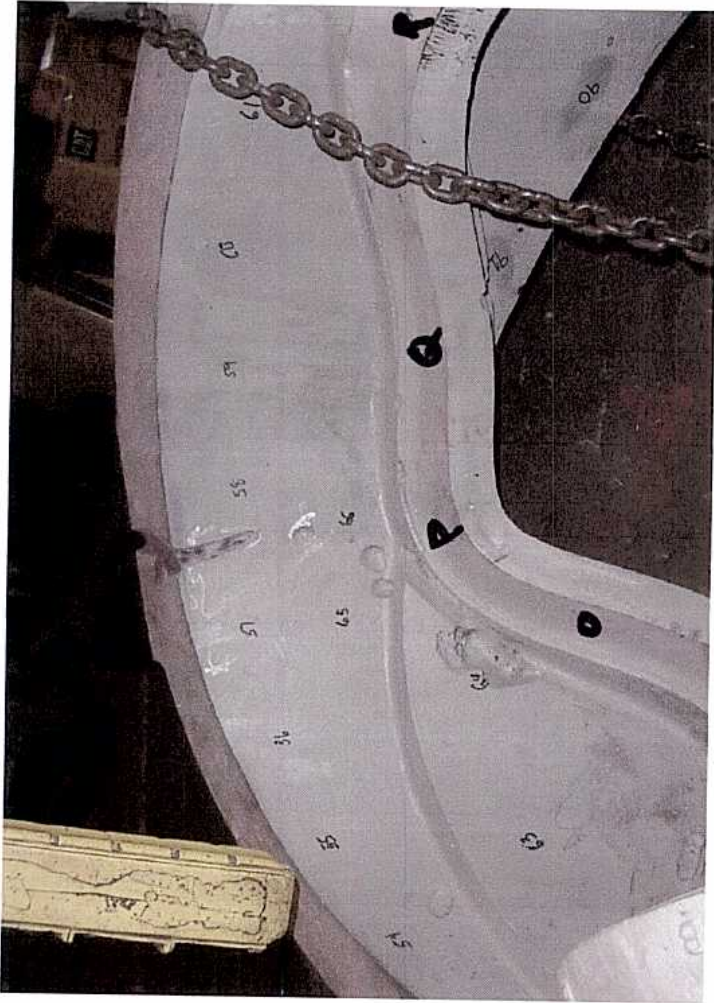


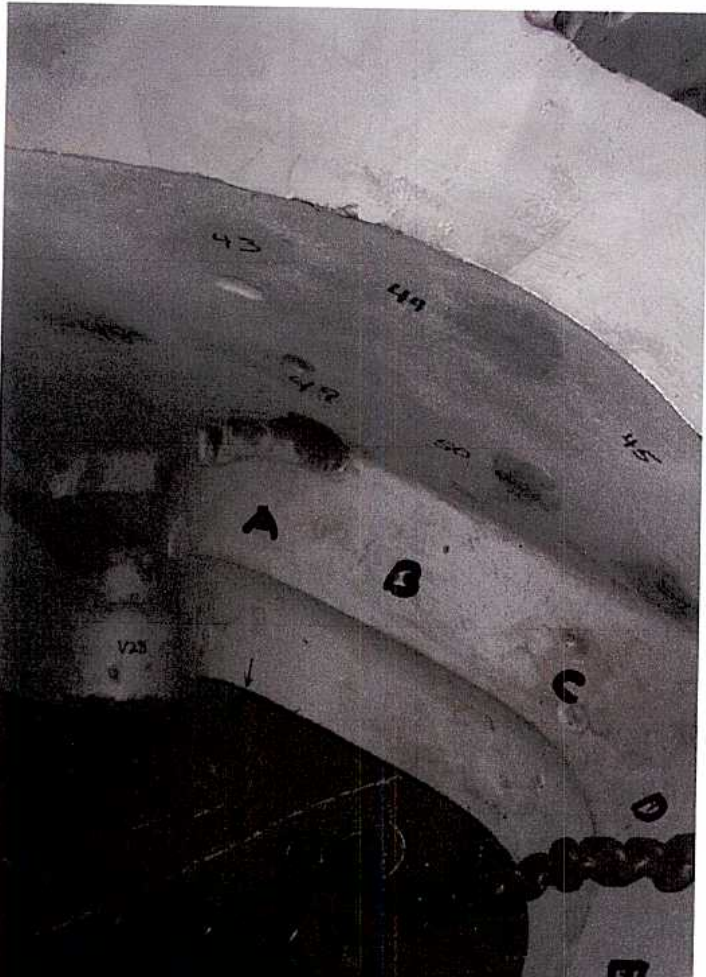
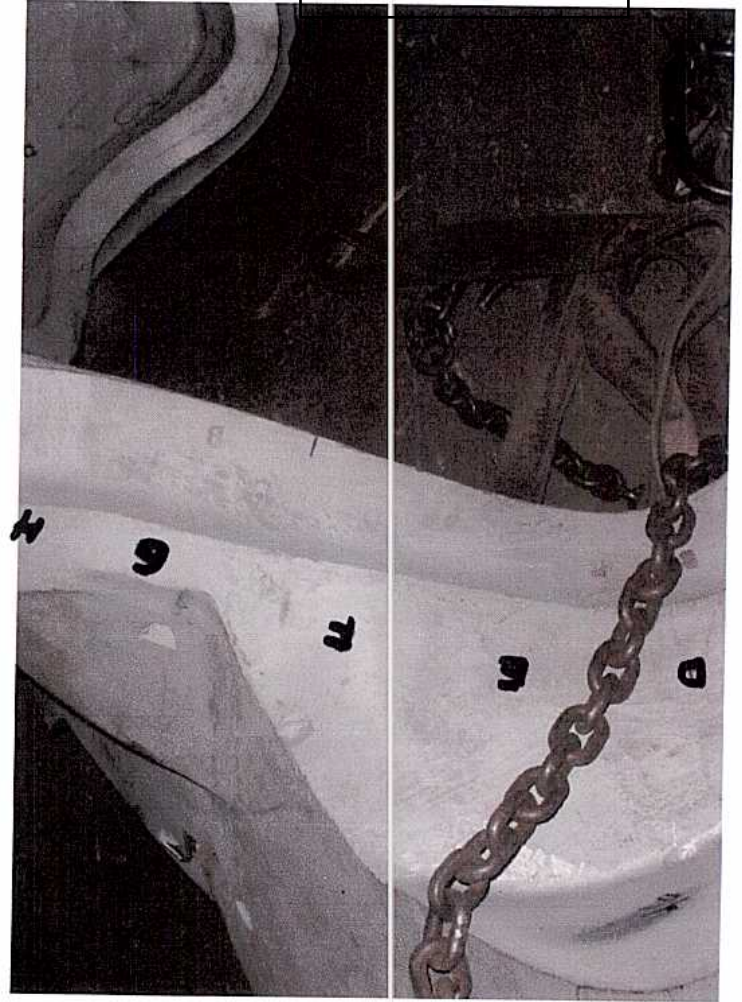


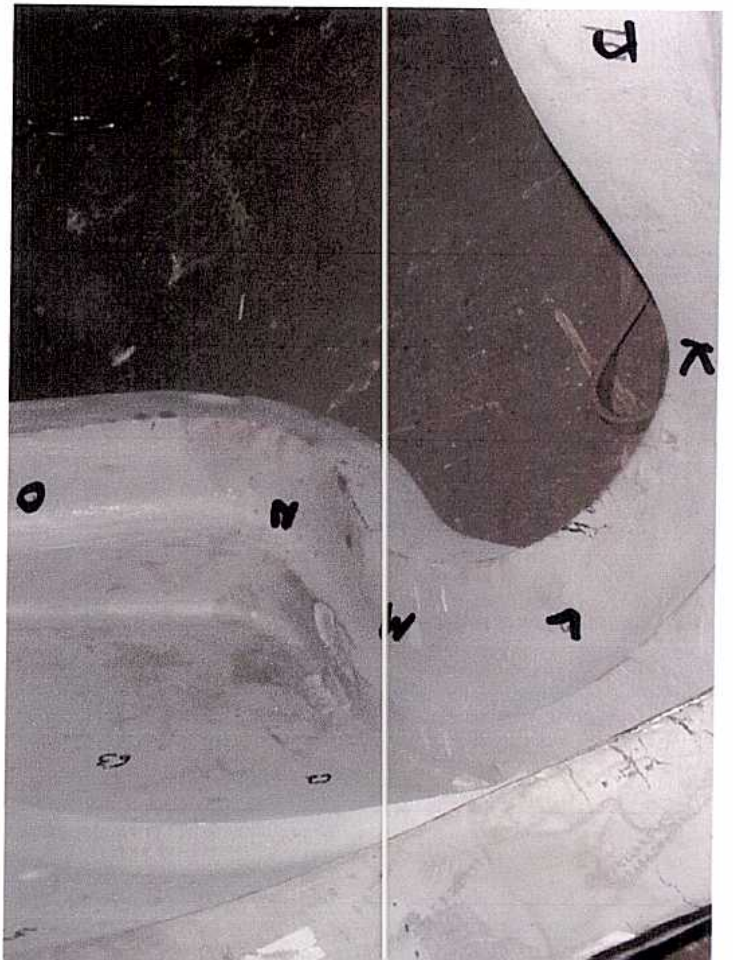
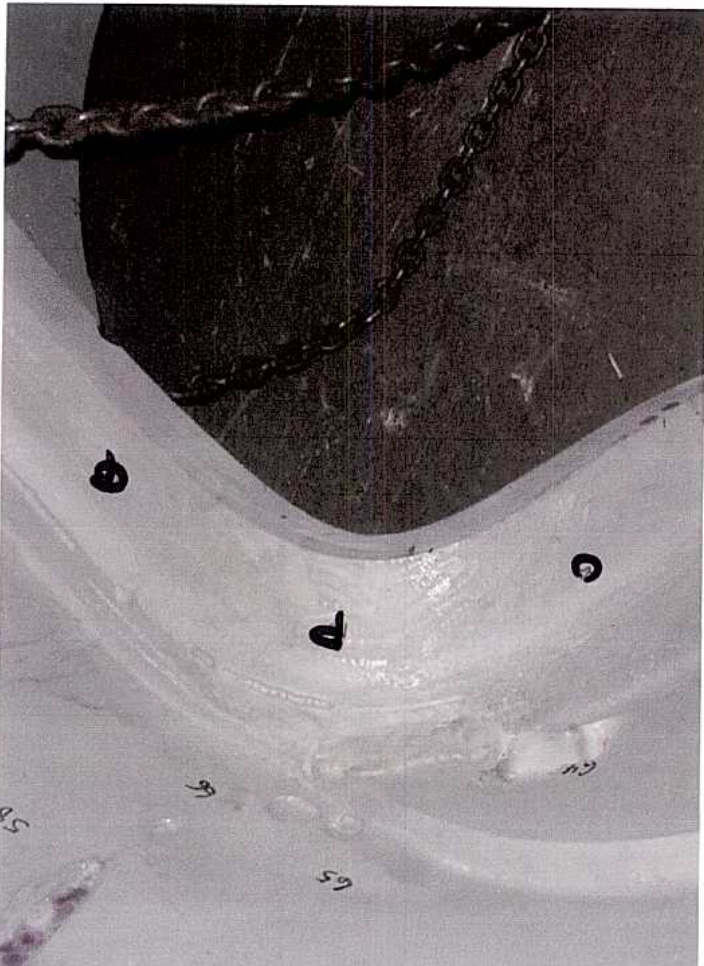
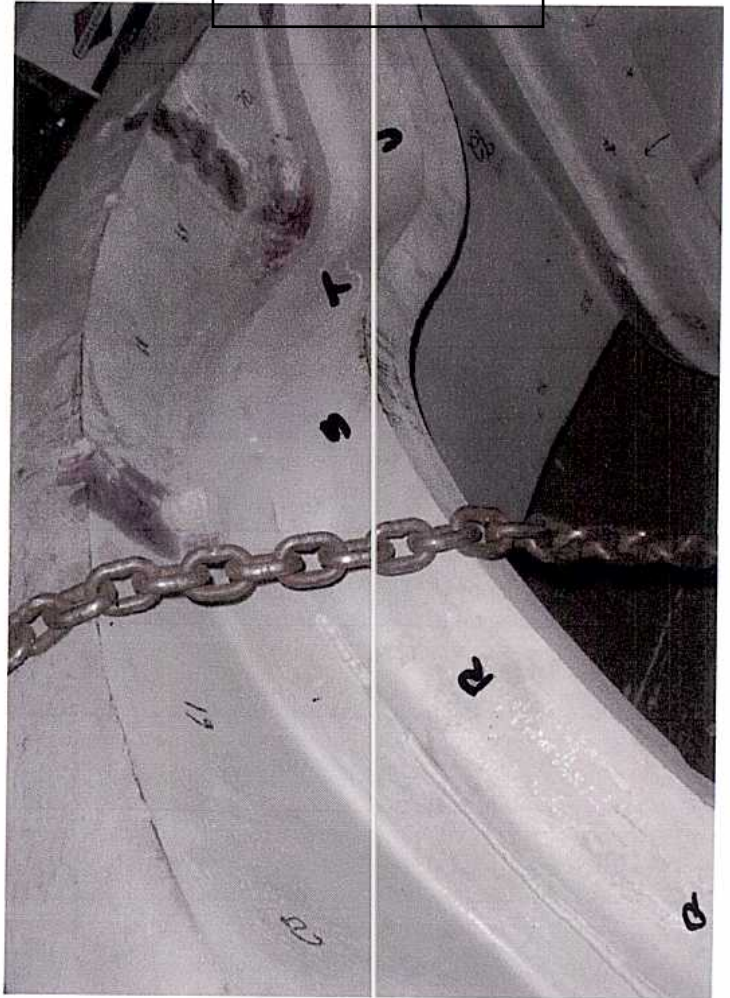






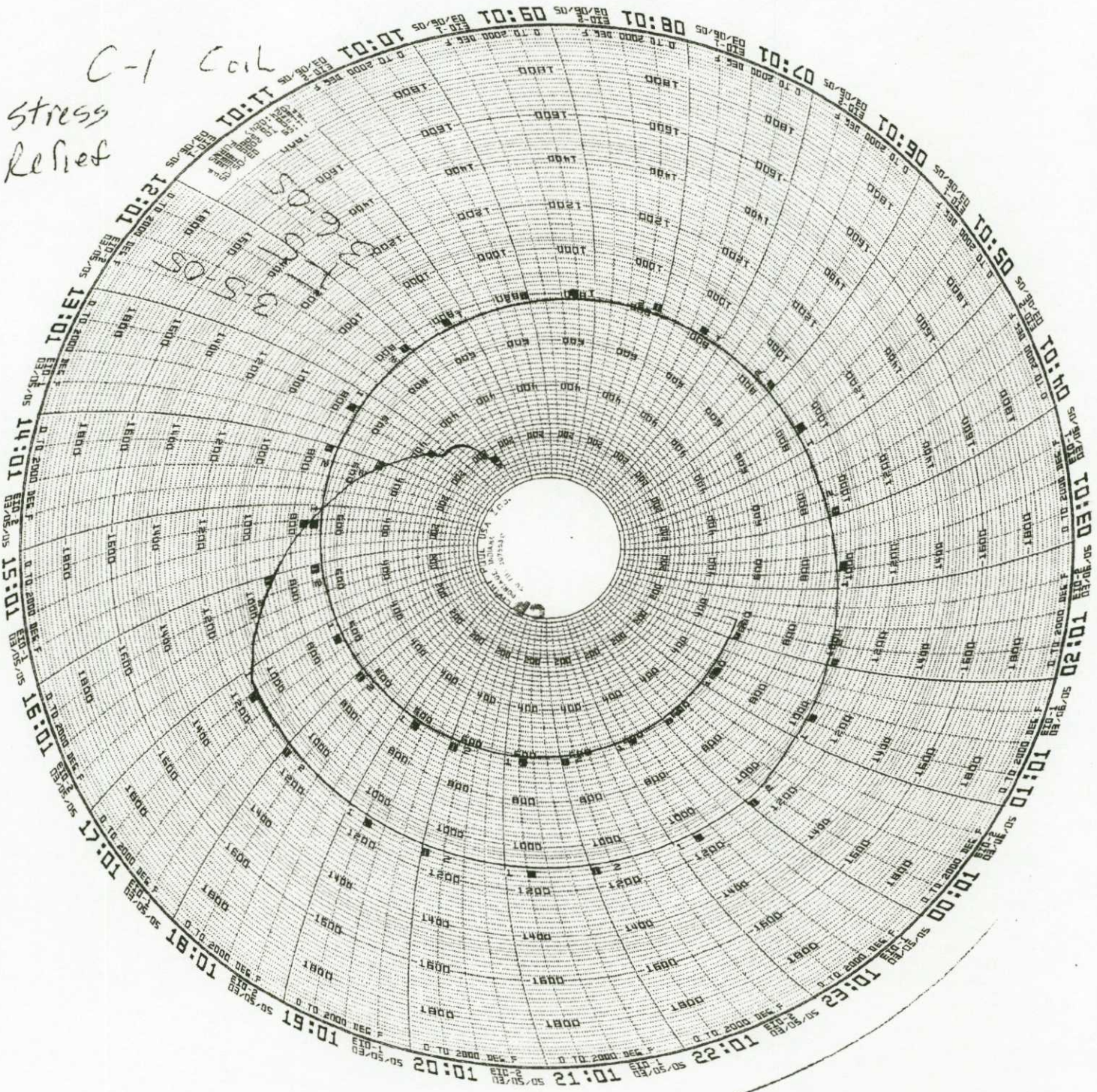






C-1 coil
stress
relief

50
150
200
300
400
500
600
700
800
900
1000
1100
1200
1300
1400
1500
1600
1700
1800
1900
2000



MetalTek

Carondelet Division - CA / PA / RGA Database

Corrective Action

1219

Corrective Action Type FOR CASTING DISCONTINUITIES

Date 2/18/2005

CA Originator Ruud

Pattern Number: C-1 Coil

Description of Defect / Non-Conformance

96 major weld defects found in the C-1 RT1 coil casting. Two defects were on opposite sides of a wall and after excavation resulted in a through wall defect requiring repair. See CA 1226.

Root Cause : Incorrect parameter used during solidification modeling at ESI Group. They used 75% fraction solid cutoff as a feeding criterion. This made the simulation result look like the casting fed correctly with the rigging that was used.

Corrective Action: Weld upgrade C1 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 used the xray information from the C1 casting to re-simulate the solidification using different fraction solid cutoff numbers. A good correlation between the C1 xray results and a 50% fraction solid cutoff number was found. As of 2-18-05, we are revising the rigging to give good simulated results with a 50%fraction solid cutoff.

Verification Of Preventative Action: Radiograph C-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

Corrective Action 1219

Concur:

P. Heitzenroeder, PPPL Tech. Rep.

B. Nelson, RLM

cc: F. Malinowski, PPPL QA

MetalTek

Carondelet Division - CA / PA / RGA Database

Corrective Action

1226

Corrective Action Type FOR CASTING DISCONTINUITIES

Date 2/18/2005

CA Originator Ruud

Pattern Number: C-1 Coil

Description of Defect / Non-Conformance

Two defects were on opposite sides of a wall and after excavation resulted in a through wall defect requiring repair.

Root Cause : Incorrect parameter used during solidification modeling at ESI Group. They used 75% fraction solid cutoff as a feeding criterion. This made the simulation result look like the casting fed correctly with the rigging that was used.

Corrective Action: Weld upgrade C1 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. Copper backing plates will used.

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

Preventive Action: We used the xray information from the C1 casting to re-simulate the solidification using different fraction solid cutoff numbers. A good correlation between the C1 xray results and a 50% fraction solid cutoff number was found. As of 2-18-05, we are revising the rigging to give good simulated results with a 50%fraction solid cutoff.

Verification Of Preventative Action: Radiograph C-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

Corrective Action 1226

C-1 Doc Package
Document # 21

Concur:

P. Heitzenroeder, PPPL Tech. Rep.

B. Nelson, RLM

cc: F. Malinowski, PPPL QA

MetalTek

Carondelet Division - CA / PA / RGA Database

Corrective Action

1251

Corrective Action Type FOR CASTING DISCONTINUITIES

Date 3/22/2005

CA Originator Ruud

Pattern Number: C-1 Coil

Description of Defect / Non-Conformance

Two major weld defects found following verification of weld repairs. Lack of fusion was found. These are repairs of existing weld deposits.

Root Cause

Defective weld.

Corrective Action

Excavate and repair.

Verification of Corrective Action

Radiography indicated part was properly repaired.

Actual Completion and File Date: 3-22-05

Signed: CA Ruud



CC: Barry Craig, Dean Berger, E.J. Kubick, R Suria, File

CONCUR: 

 3/26/05

C-1 Doc Package
Document # 22a

MetalTek

Grandelet Division - CA / PA / RGA Database

Corrective Action

1252

Corrective Action Type FOR CASTING DISCONTINUITIES

Date 3/24/2005

CA Originator Ruud

Pattern Number: C-1 Coil

Description of Defect / Non-Conformance

Major defects were observed during final Penetrant inspection.

Root Cause

Inherent casting discontinuities.

Corrective Action

Excavate discontinuities and weld repair.

Verification of Corrective Action


Penetrant Inspection of weld repairs.

Actual Completion and File Date: 3-24-05

Signed: CA Ruud



CC: Barry Craig, Dean Berger, E.J. Kubick, R Suria, File

APPROVED: 

25 MARCH 2005



28 March 05



C-1 Doc Package
Document # 22b

Corrective Action 1320
Carondelet Division - CA / PA / RGA Database
Corrective Action Type NCR
Date 7/5/2005
CA Originator C. Ruud
Pattern Number: C 1, C2 and A1 Coil castings

Description of Defect / Non-Conformance

Lack of test material in violation of paragraph 4.2.2.4 Additional Test Material.

Root Cause

Specification was not communicated to Pattern shop personnel.

Corrective Action

Test coupons were added to pattern and will be cast on all future coils.

Verification of Corrective Action

Pattern was inspected prior to molding C-4 casting.

Preventive Action

Create Inspection and Test Plan summarizing all requirements.

Actual Completion Date

Complete.

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

Signed: C. Ruud

CC: Roger Broman, Barry Craig, Joe Edwards, E.J. Kubick

PPPL and EIO agree that additional test material is not available for the C1, C2, and A1 castings, but will be provided for the remaining castings.

This NCR is approved based on EIO's corrective action and the above agreement.

Brad Nelson, NCSX Core Systems Engineering Manager

Phil Heitzenroeder, NCSX MCWF Subcontract Tech. Rep.



Corrective Action 1300
Carondelet Division - CA / PA / RGA Database
Corrective Action Type NCR
Date 5/29/2005
CA Originator C. Ruud
Pattern Number: C-1 Coil

Description of Defect / Non-Conformance

Failed to differentiate test material on pattern/casting per the requirement of NCSX-CSPEC-141-03-07, SECTION 4.2.2.

Root Cause

Failed to communicate specification to Pattern Shop to add location identifiers to cast on test material specimens.

Corrective Action

Add location identifiers to pattern and track through testing.

Verification of Corrective Action

Verified on Coil C-2 those identifiers were present.

Preventive Action

Create Inspection and Test Plan summarizing all requirements.

Estimated Completion Date

Identifiers will be added prior to making C-2. Inspection plan by 6/15/05

Actual Completion Date

Identifiers were added 4-15-05.

Signed: C. Ruud

CC: Roger Broman, Barry Craig, Joe Edwards, E.J. Kubick

Accepted. CA for future castings. 6-6-05
Accept ~~the~~ as is for C1. Plan



Corrective Action 1301
Carondelet Division - CA / PA / RGA Database
Corrective Action Type NCR
Date 5/29/2005
CA Originator C. Ruud
Pattern Number: C-1 Coil

Description of Defect / Non-Conformance

Failed to differentiate two directions of test material on pattern/casting per the requirement of NCSX-CSPEC-141-03-07, SECTION 4.2.2.

Root Cause

Failed to communicate specification to Pattern Shop to add cast on test material specimens in the transverse direction.

Corrective Action

Will request a deviation to eliminate requirement.

Verification of Corrective Action

N/A

Preventive Action

Create Inspection and Test Plan summarizing all requirements.

Estimated Completion Date

6/15/05

Actual Completion Date

Signed: C. Ruud

CC: Roger Broman, Barry Craig, Joe Edwards, E.J. Kubick

*Accept As-Is. NCSX-CSPEC-141-03-07
is being revised to eliminate the requirement
to test in 2 directions. 6-6-05 PRM*

Corrective Action 1323
Carondelet Division - CA / PA / RGA Database
Corrective Action Type NCR
Date 7/27/2005
CA Originator C. Ruud
Applies to: Coil castings C-1, C-2, C-3, C-4 and A-1 and C 1 shim and four C coil and six A coil shims

Description of Defect / Non-Conformance

Phosphorus levels in material produced to date exceed specification limits. Both phosphorus and sulfur readings reported erroneously in certifications.

Certification reports have shown phosphorus and sulfur levels in the <.01% range. Independent laboratory data confirmed phosphorus in the .018 to .033% range and sulfur in the .005 to .022% range. Actual levels of some tests are above those in PPPL Specification NCSX-CSPEC-141-03-07 Rev 7.

Nonconformance was first suspected as a result of analysis of zoned attached test specimens volunteered by MetalTek International as response to PPPL questions on weighted average chemical analysis and quality of blending in the gating system. Nonconformance was verified on the bars used in the study and has been extended to evaluation of previously poured products.

Root Cause

Specification limits were set below the levels achievable through use of available raw materials. Spectrometer did not properly calibrate for phosphorus and sulfur at levels of specification due to equipment malfunction.

The chemical specification of EIO heats uses alloy CF8MNMn-Mod which incorporates a type standard calibration with a certified reference material (CRM) BS180. This enables the operator of the spectrometer to match the elemental concentrations of this alloy with corrective factors. These factors are determined by analyzing the CRM and having them compared with the calibration curves for each element. The phosphorus and sulfur content have very low measured intensities due to low concentrations. Intermittent failure of the spectrometer intensity measuring card caused higher intensity readings for phosphorus and sulfur. Subsequent checks with the CRM resulted in low corrective factors that were not detected. This in turn resulted in low reported concentrations for the EIO samples. All the major elements, which are measured on other intensity cards, have been closely monitored and matched very well with the CRM and thus were reported correctly.

Corrective Action

Modification to specification for phosphorus and sulfur will be requested. Limits will be set based on process capability and consistent with other stainless steel grades. Replacement of deficient card in spectrometer will be made upon delivery.

Subsequent immediate analysis of chemistry results, obtained by wet analysis, is attached and demonstrate top of specification for sulfur and over specification for phosphorus. The spectrometer manufacturer has performed an analysis to determine the cause of the malfunction and verified that the intensity card has an intermittent fault and must be replaced. The card has been ordered and scheduled for replacement on August 15, 2005.

Until the card is replaced we will be performing additional type standardizations to ensure accurate sulfur and phosphorus analysis. Additionally, for coils made until the card is replaced, an independent laboratory will perform a verification of the chemical analysis.

Verification of Corrective Action

Will be determined at a later date.

Preventive Action

In addition to spectrometer faults, we have identified that the specification ranges for sulfur and phosphorus is unattainable. Analysis and specifications for virgin charge materials predict sulfur at 0.040% maximum and phosphorus at 0.040% maximum. We have no way to remove phosphorus from the melt and do not intentionally add phosphorus. So, the confirmed coil analyses, along with analyses of virgin material heats, demonstrate sulfur in the range of 0.010% to 0.022% and phosphorus in the range of 0.018% to 0.033%. These results are consistent with our charge material analysis. We will request a deviation for phosphorus in the subject parts and also request a permanent specification change to 0.040% maximum for both phosphorus and sulfur, to allow us to provide non-discrepant material. This change will not affect, in any way, the physical properties or material performance because all coils and test material exhibited sulfur and phosphorus within the new ranges despite inaccurate reporting. Other actions: Specifications have been added to the BS 180 standard and the type standard will be measured against the criteria.

Estimated Completion Date

August 15, 2005

Actual Completion Date TBD

Signed: C. Ruud



CC: Jim Galaske, Barry Craig, Joe Edwards, E.J. Kubick

Guide to St Louis Testing Report Dated 7-26-05

Sample name	Sample origin
A1Z1	Cast on bar A-1 coil, zone 1
A1Z2	Cast on bar A-1 coil, zone 2
A1Z3	Cast on bar A-1 coil, zone 3
C1	Cast on bar C-1 coil
C2Z1	Cast on bar C-2 coil, zone 1
C2Z2	Cast on bar C-2 coil, zone 2
C2Z3	Cast on bar C-2 coil, zone 3
C3Z1	Cast on bar C-3 coil, zone 1
C3Z2	Cast on bar C-3 coil, zone 2
C3Z3	Cast on bar C-3 coil, zone 3
F1	Final analysis button from ladle for C-4 coil
F2	Final analysis button from ladle for C-4 coil
F3	Final analysis button from ladle for C-4 coil
P1	Preliminary analysis button from ladle for C-4 coil

Testing is underway of the heat used to pour the four C coil and six A coil shims.

C-1 Doc Package
Document # 24a

Founded 1929

St. Louis Testing Laboratories
INCORPORATED



Attachment to
CA 1323

Chemical, Metallurgical, Mechanical, Nondestructive, Environmental Testing, Analyses and Field Service.

July 26, 2005
Lab No. 05C-0608
Invoice No. 59891
P.O. No. 21324
Page 1 of 1

METALTEK INTERNATIONAL
8600 Commercial Blvd.
Pevely, MO 63070

Attention: Chuck Ruud

REPORT OF CHEMICAL ANALYSIS

SAMPLE ID: A1 Z1, A1 Z2, A1 Z3, C1, C2 Z1, C2 Z2, C2 Z3,
C3 Z1, C3 Z2, C3 Z3, F1, F2, F3, P1

RESULTS: %

ANALYTE	A1Z1	A1Z2	A1Z3
Sulfur	.013	.005	.010
Phosphorus	.025	.023	.018

ANALYTE	C1	C2Z1	C2Z2	C2Z3
Sulfur	.014	.022	.018	.015
Phosphorus	.018	.024	.021	.025

ANALYTE	C3Z1	C3Z2	C3Z3
Sulfur	.013	.014	.012
Phosphorus	.024	.025	.021

ANALYTE	F1	F2	F3	P1
Sulfur	.014	.015	.012	.010
Phosphorus	.029	.033	.028	.030

Sulfur Test Method: ASTM E1019-03

Phosphorous Test Method: Colormetric

Identification of tested specimen provided by the client.

Robin E. Sinn
Laboratory Director

RES/nmc

MEMBER
ACIL



Addendum to CA1323 8-17-05

Historical:

The proto type coil was poured on February 24, 2004. The chemistry specification at that time permitted a maximum of 0.04% for sulfur and phosphorus. The reported values for these elements were 0.01 and 0.02% respectively.

Prior to pouring the C-1 coil casting the specification was revised. MT failed to incorporate the revisions into our system. The contract review procedure did not detect the changes to the specification. Therefore normal change procedures were not implemented. This was reported in corrective action 1308 on June 13, 2005. The error was recognized when the material poured to cast C and A coil shims did not meet the revised specification.

An investigation was begun immediately to determine compliance of the C-1 and C-2 coils. It was determined that both the C-1 and C-2 met the revised chemistry, except for sulfur and phosphorus. To verify the analysis MT analyzed samples from the cast on bars taken from the coils. By this time the optical card had malfunctioned. This fact, in combination with the human error (believing that the type standard was also in the 0.002% range) led MT to believe that the sulfur and phosphorus were actually in the 0.002% range. As a result MT believed the coils to be compliant and no action was taken.

Current Activities:

Samples from A-1, C-4 and C-5 have been sent to Wisconsin Centrifugal, our parent company for independent analysis of all reported elements.

Repair to the spectrometer is scheduled for this week. In the mean time we continue our surveillance of the suspect elements during melt and chemistry analysis.

C. Ruud

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

CC: Jim Galaske, Barry Craig, Joe Edwards, E.J. Kubick

COIK

RTG

Energy Industries of Ohio

Manufacturing and Test Sequence (MTS) Serial Number C-1

Dated December 14, 2004 Revision: Original Page 1 of 8

Dated Issued: 12-14-04

C-1 Doc Package Document #25 10 pages

OPER. #	STATION	DESCRIPTION OF PROCESS	Name	Date
10	QUALITY RELEASE	REVIEW AND APPROVE MTS. RECEIVED APPROVAL FROM EIO ON 12/15/04 FROM <u>Pete</u> SIGNED QUALITY MANAGER.	<u>PHL</u>	12/15/04
15	PATTERN NPAT SOP 0100REV2	APPLY APPROPRIATE PART NUMBER, SERIAL NUMBER, FOUNDRY MARK, TO THE PATTERN. CAST ON BARS REQUIRED. <i>Cast on bars added - Marked "C1" - Part number, etc. with have to be stamped</i>	<u>[Signature]</u>	12/17/04
20	COREMAKE CORE SOP 0100 REV 6 CALIBRATION PER CORE SOP 0200R4/0300R6	MAKE CORES IN SAND MIXTURES AS DESCRIBED BY METALTEK ENGINEERING AND VERIFIED IN MODELING TRIALS. METALTEK CORE SOP 0100 REV 6) CORE WASH WITH ZIRCONIUM CORE WASH (CALIBRATION OF EQUIPMENT REQUIRED PER CORE SOP 0200, R4 / 0300, R6) VERIFY COUNT AND INSPECT.	<u>[Signature]</u>	12/17/04
30	MOLD MOLD SOP 0400 REV 8 CALIBRATION PER MOLD SOP 0900 REV 5 PREPARATION PER MOLD SOP 1100R2/1200R2/13 00R1 SAND TESTING PER MOLD SOP 1400R2/1500R3/16 00R2	MOLD PER WORK INSTRUCTIONS IN MAPICS ROUTING AND SOPS REFERENCED. ENGINEER OF RECORD - ROGER BROMAN, CONSULT ON MOLD-RELATED CONCERNS. MOLD MATERIALS REQUIRED PER MAPICS BOM. NOTIFY ENGINEER OF ANY SUBSTITUTIONS.	<u>[Signature]</u>	12/17/04
40	POUR MELT SOP 0100R5 MELT SOP 0700R2 MELT SOP 0600R2	METAL MUST BE AOD REFINED OR AOD INGOT. VIRGIN METAL ADDITIONS ALLOWED. RECORD POURING TEMPERATURE: <u>2750</u> CASTING POURED AT: <u>5:45</u> DATE: <u>12/21/04</u> HEAT #'S: <u>21128, 21729, 21730, 21731</u> ELAPSED POUR TIME: <u>105 SEC</u> KEEL BLOCKS POURED: <u>YES</u> Sample from ladle to be analyzed for final chemical analysis and reported on material certifications. Analyzed: <u>JG</u> Date: <u>12-19-04</u>	<u>[Signature]</u> <u>[Signature]</u>	12/19/04
50	MELT SOP 0800R2	SHAKEOUT	<u>[Signature]</u>	12-26-04

SIGNED WRONG BY CJA 12-26-04

Energy Industries of Ohio
Manufacturing and Test Sequence (MTS) Serial Number C-1
Dated December 14, 2004 Revision: Original

Page 2 of 8
 Dated Issued: 12-14-04

60	ARC RISE SOP 0100R1	REMOVE RISERS AS DIRECTED BY SUPERVISOR. SOLUTION ANNEAL. MAKE SURE TO BLOCK ALL FLANGES OF FORM AND RACETRACK TO MINIMIZE CREEP DISTORTION.	MW MW	1-3-05
70	HEAT TREAT HEAT SOP 0103R5	REMOVE RISERS AS DIRECTED BY SUPERVISOR. SOLUTION ANNEAL. MAKE SURE TO BLOCK ALL FLANGES OF FORM AND RACETRACK TO MINIMIZE CREEP DISTORTION.	DLS F5-1	12/28/04 12/28/04
75	PHYSICAL TESTING	OBTAIN TEST SPECIMENS AND SUBMIT FOR PHYSICAL TESTING. REPORT RESULTS AS PART OF STEP 510.	WA	12/28/04
80	GRIND GSA SOP 0100R3 GCHI SOP 0100R2	SWING GRIND TO REMOVE RISER REMAINS AND FLASH IF REQUIRED. CHIP AND HAD GRIND SURFACE OF PART AS REQUIRED FOR CONTOUR.	SA	1-2-05
90	SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.	MB TV	1-6-05 1-6-05
110	VISUAL INSPECTION CQP-500 REV 4	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.	WA	1-9-05
NOTICE	WITNESS NOTIFICATION	VISUALLY INSPECT 100% OF COMPONENT ACCORDING TO ASTM A802 LEVEL 3 ALL CONDITIONS. IF OK CHECK HERE <input checked="" type="checkbox"/> . MARK AND REPAIR AT STEP 120.	VT- LEVEL II PMA	1-7-05
115	100% I.P. CQP-300 REV 10	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF LP STEP. EIO NOTIFIED ON 12/15/05 DCMA NOTIFIED ON 1/3/05 + on 1/4/05 for our early ca 1/7/05	Q ENG OR QA MGR	ABC 17/04
120	WELD SOP 0100 REV 7	L.P. 100% OF COMPONENT. ACCEPTANCE PER ASTM 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"/> . MARK AND REPAIR AT STEP 120.	LP- LEVEL II KRA 1-7-05	1-12-05
130	L.P. EXCAVATION CQP-300 REV 10	EXCAVATE ANY DEFECTS FOUND DURING 100% VISUAL AND LP INSPECTION.	LP- LEVEL II	1-12-05
165	SAND BLAST BLAS SOP 0100R6	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA-LEVEL 1 FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE I.P. DRAWING.	LP- LEVEL II	1-12-05
170	WELD MAP	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE.	MW	1-12-05
		MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING. USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTOR, MAN OR THEIR DESIGNEE, FILE WITH QA. USE YELLOW MARKER.	built and after RT	1-12-05

Handwritten notes and stamps:
 - "ABC" signature
 - "17/04" date
 - "1-12-05" date
 - "deluged OK" note
 - "Perry" note
 - "KRA" note
 - "1-12-05" date
 - "built and after RT" note

180	NOTICE	WITNESS NOTIFICATION	MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES _____ REPORT SENT BY _____ DATE _____ DEFECTS < 10% _____ SIGN BY QA ENG.	WJA
190	WITNESS NOTIFICATION	HOLD POINT	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF XRAY AND DIMENSIONAL STEPS. EIO NOTIFIED ON 1/14/05 DCMA NOTIFIED ON 1/14/05	Q ENG OR QA MGR CABE 1/13/05
190	WITNESS NOTIFICATION	HOLD POINT	HOLD FOR APPROVAL OF XRAY PROCEDURES. RECEIVE APPROVAL FROM EIO ON 1/11/05 from R.D	QA MGR CABE
200	WITNESS NOTIFICATION	X-RAY AT MQS PROCEDURE 2011010 REV 0	X-RAY PER TECHNIQUE # 12726 USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. WHEN MARKING USE BLACK MARKERS. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT - LEVEL II Ruth out to MSS 1-12-05
200	WITNESS NOTIFICATION	LAYOUT Lawton's procedure	INSPECT CASTING TO VERIFY DIMENSIONS. THIS MAY BE PERFORMED BEFORE OR AFTER STEP 190. DIMENSIONED 1/10-11/05 DATE by 3D SCA RELEASED 5:05 PM 1/11/05 (ENGINEER ONLY)	1/11/05
210	WITNESS NOTIFICATION	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE _____ AND SEND TO STEP 370. REJECTED CHECK HERE _____ MARK UP DEFECTS AND SEND THE CASTING TO STEP 260. EXCAVATE ANY DEFECTS FOUND DURING RADIOGRAPHY.	RT - LEVEL II ABK 1-19-05 1/25/05
220	WITNESS NOTIFICATION	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING RADIOGRAPHY.	LP - LEVEL II CC 2-17-05
230	WITNESS NOTIFICATION	L.P. EXCAVATION CQP 300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA-LEVEL 1 FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING.	LP - LEVEL II CC 2-17-05
240	WITNESS NOTIFICATION	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTOGRAPHS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE, FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES _____ REPORT SENT BY R. Service DATE 2/18/05 DEFECTS < 10% _____ SIGN BY QA ENG. R. Service	Q ENG OR QA MGR CABE 1/11/05
260	WITNESS NOTIFICATION	QA APPROVAL HOLD POINT	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF WELD STEP. EIO NOTIFIED ON 1/11/05 DCMA NOTIFIED ON 1/11/05	QA TO APPROVE ELECTRODE PRIOR TO USE. C.F. 8 mm 1/11/05 REVL PROCEDURE USED: 15-6-2003-1/11/05 MATERIAL USED: _____ QUALITY ENG. Name: Rick Adams Date: 2/18/05

Energy Industries of Ohio

Manufacturing and Test Sequence (MTS) Serial Number C-1

CO# 40851, MS73140

Dated December 14, 2004 Revision: Original Page 4 of 8

Dated Issued: 12-14-04



270	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED. FOR WELDS <2" - WPS 10-SMAW-CF8MMNMN MOD REV 1 FOR WELDS <8" - WPS 15-GMAW-CF8MMNMN MOD REV 2			
280	GRIND GCHH SOP 0100R2	HAND GRIND WELDS.			
290	L.P. WELD CQP 0300 REV 10	L.P. WELD REPAIRS ACCEPTANCE PER ASTM 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"/> WASH AND SEND TO STEP 300. IF REJECTED CHECK HERE <input type="checkbox"/> AND RETURN TO STEP 220.	LP- LEVEL II Rlet 3/5/05		
295	REPEAT	REPEAT STEPS 220 TO 290 AS REQUIRED TILL CLEAR THROUGH VISUAL INSPECTION & PENETRANT INSPECTION. DOCUMENT REWORK ON A SUPPLEMENTAL MTS	QA N/A		
295	TEST MAG PERM SOP MAG PERM 100, REV 1	TEST MAG PERMEABILITY REPAIR AREAS RECORD ON WELD MAP LIST. TEST AT LEAST 5 POINTS PER WELD. ACCEPTANCE 1.02. IF OK CHECK HERE <input checked="" type="checkbox"/> AND GO TO STEP 430. IF REJECTED CHECK HERE <input type="checkbox"/>	QA N/A 3/5/05		
296	GRIND GCHH SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 295. REPEAT UNTILL COMPLIANCE IS ACHIEVED.	N/A		
300	X-RAY (NOTE)	IF RADIO GRAPHED AREAS ARE GREATER THAN FOUR TO FIVE INCHES THE CASTING WILL BE SENT TO MQS. SEND TO MQS CHECK HERE <input checked="" type="checkbox"/> RADIOGRAPH AT CAF CHECK HERE <input type="checkbox"/>	QA ENGINEER 3/7/05		
310 A	MQS X-RAY DEFECTS REPAIRED BY WELDING	X-RAY PER TECHNIQUE # 12726 USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	LEVEL II 1.101 3/20/05		
310 B	CAF X-RAY DEFECTS REPAIRED BY WELDING CQP 401 REV 5	X-RAY PER TECHNIQUE # 12726 USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT- LEVEL II U/A		
320	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE <input checked="" type="checkbox"/> AND SEND TO STEP 340. REJECTED CHECK HERE <input checked="" type="checkbox"/> MARK UP DEFECTS AND SEND THE CASTING TO STEP 220.	RT- LEVEL II RBK 3-21-05		

Energy Industries of Ohio

Manufacturing and Test Sequence (MTS) Serial Number C-1

Dated December 14, 2004 Revision: Original Page 5 of 8

Dated Issued: 12-14-04

REPEAT STEPS 220 TO 320 AS REQUIRED TILL WELDS CLEAR X-RAY. DOCUMENT REWORK ON QA ENG.

340	REPEAT SAND BLAST BLAS SOP 0100R6	SANDBLAST (REMOVE ALL BLAST MATERIAL FROM CASTING) SANDBLASTING WILL BE DONE USING RECYCLED SHARP ANGULAR AGGREGATE. <i>Supplemental supplied on 3/21/05</i>	3-22	<i>Ref</i>	
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF VISUAL AND LP STEPS. EIO NOTIFIED ON <i>3/16/05</i> DCMA NOTIFIED ON <i>3/16/05</i>		<i>QBR</i>	
350	FINAL VISUAL INSPECTION CQP-500 REV 4	VISUALLY INSPECT 100% OF COMPONENT ACCORDING TO ASTM A802 LEVEL 2 ALL CONDITIONS. IF OK CHECK HERE <input checked="" type="checkbox"/> <i>3/30/05 Final OK</i> IF REJECTED CHECK HERE <input type="checkbox"/> MARK AND REPAIR AT STEP 390. MUST BE PERFORMED BY LEVEL II in VT.			
360	FINAL L.P. CQP 0300 REV 10	FINAL L.P. 100% OF COMPONENT. ACCEPTANCE PER ASTM A903. ACCEPTANCE CRITERIA- LEVEL 1 FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING. <i>3/30/05 Final OK</i>			
380	WELD SOP 0100 REV 7	IF OK CHECK HERE <input checked="" type="checkbox"/> WASH AND SEND TO STEP 455. IF REJECTED CHECK HERE <input type="checkbox"/>			
390	L.P. EXCAVATION CQP-300 REV 10	EXCAVATE ANY DEFECTS FOUND DURING FINAL PENETRANT INSPECTION. LP. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903.			
400	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTO/MAPS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE. FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES REPORT SENT BY <i>RS</i> DATE <i>3/23/05</i> DEFECTS < 10% <i>RS</i> SIGN BY QA ENG.			
420	GRIND GCHI SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 410. REPEAT UNTILL COMPLIANCE IS ACHIEVED.			
430	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED. FOR WELDS < 2" - WPS 10-SMAW-CF8MMNMN MOD REV 1 FOR WELDS < 8" - WPS 15-GMAW-CF8MMNMN MOD REV 2			

3/22/05
3/24/05
3/22/05
3/22/05
3/23/05

Think LP

3-22

3-28-05

AL

CO# 40851, MS73140

Dated December 14, 2004 Revision: Original

PROCESS DOCUMENT TO PROGRAM MANAGER FOR COMPLIANCE AUDIT.

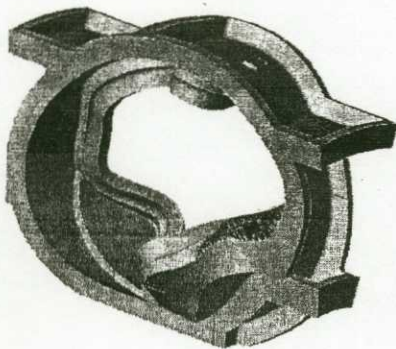
500	AUDIT REVIEW			3/31/05 <i>pat</i>
510	DOC. REVIEW	REVIEW DOCUMENTS AS REQUIRED IN CAF CHECKLIST, ALL DOCUMENTS NOTED TO BE ACCESSIBLE FOR AUDITING. (SHIPPER, C OF C, M.T.R., M.T.S., INSPECTION REPORT, X-RAY READER SHEETS AND HEAT TREAT CHARTS)		3/31/05 <i>pat</i>
NOTICE	RELEASE FROM EIO	PROVIDE DOCUMENTS TO EIO SENT ON 4/4/05 BY <i>pat</i> RECEIVED RELEASE FROM EIO ON 3/30/05		Q.ENG OR QA MGR
520	PACK AND SHIP	PACKAGE AND SHIP TO MAJOR TOOL.		3/31/05 CARUUD
1000	REVISION HISTORY	ORIGINAL 12-14-04. approved 12-14-04.		

Shipped



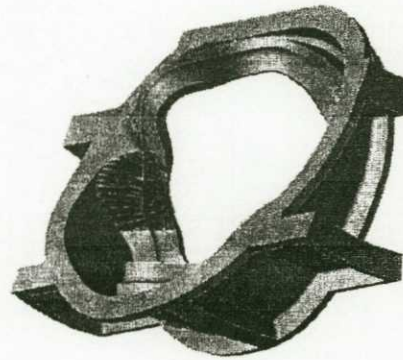
Page 8 of 8 Revised 1-26-05 to clarify and illustrate the critical areas (CLASS 1) of the C-1 Coil

CLASS 2 ALL OVER

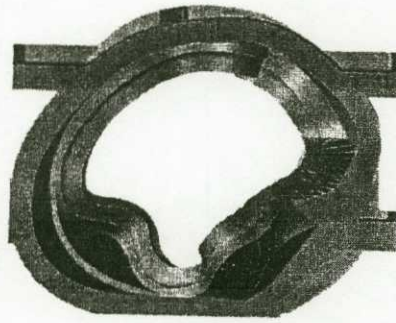


GENERAL ISOMETRIC
VIEW FROM TOP SIDE

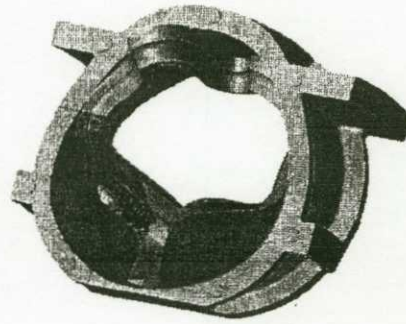
RED AREA INDICATES HIGH STRESSED AREA



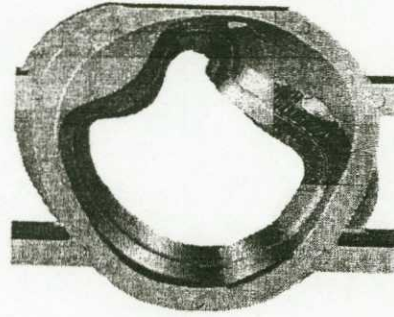
TOP SIDE ISOMETRIC



TOP SIDE VIEW



BOTTOM SIDE ISOMETRIC



BOTTOM SIDE VIEW

NOTES: Weld repair of C-1 Coil Casting

Date: 3-21-05

SUPPLEMENTAL ROUTING CARD

PART NUMBER: C-1 Coil		SERIAL NUMBER: C-1		AUTHORITY
OPER NUMBER	STATION			C Ruid
220	WELD SOP 0100 REV 7	EXCAVATE ANY DEFECTS FOUND DURING RADIOGRAPHY.		
230	L.P. EXCAVATION CQP-300 REV 10	L.P. ALL EXCAVATIONS PRIOR TO WELDING TO ENSURE REMOVAL OF DEFECT. ACCEPTANCE PER A903. ACCEPTANCE CRITERIA-LEVEL 1 FOR HIGH STRESSED AREAS, LEVEL 2 FOR ALL OTHER AREAS. SEE LP DRAWING.		LP- LEVEL II BB 3/21/05
240	WELD MAP	MAP ALL WELDS WITH DIGITAL PHOTOMAPS. SERIALIZE DEFECTS ON CASTING, USE SCALE IN PHOTOS AND DOCUMENT SIZE. THIS IS TO BE PERFORMED BY SUPERVISOR, INSPECTION LEAD MAN OR THEIR DESIGNEE, FILE WITH QA. MUST SEND REPORT ON ALL WELDS OVER 10% OF NOMINAL WALL THICKNESS TO CUSTOMER. DEFECTS > 10% YES <input checked="" type="checkbox"/> , REPORT SENT BY <u>R. Suris</u> DATE <u>3/27/05</u> DEFECTS < 10% SIGN BY QA ENG.		RS 3/22/05
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF WELD STEP. <u>WAVE & SURVE</u>		Q ENG OR QA MGR ChR
260	QA APPROVAL HOLD POINT	EIO NOTIFIED ON <u>3/21/05</u> DCMA NOTIFIED ON <u>3/21/05</u> QA TO APPROVE ELECTRODE PRIOR TO USE OF D PROCEDURE USED: <u>15-SMAW-C-F8MNMN</u> MATERIAL USED: <u>Lincolb L AN 44/55</u> QUALITY ENG. Name: <u>Picardo Suris</u> Date: <u>3/21/05</u>		<u>Sur</u>
270	WELD SOP 0100 REV 7	WELD REPAIR DEFECTS AS MARKED. FOR WELDS < 2" - WPS 10-SMAW-CF8MNMN MOD REV 1 FOR WELDS < 8" - WPS 15-GMAW-CF8MNMN MOD REV 2		
280	GRIND GCHI SOP 0100R2	HAND GRIND WELDS.		
290	L.P. WELD CQP 0300 REV 10	L.P. WELD REPAIRS ACCEPTANCE PER ASTM 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"/> WASH AND SEND TO STEP 300. IF REJECTED CHECK HERE _____ AND RETURN TO STEP 220.		LP- LEVEL II BB 3/21/05
	REPEAT	REPEAT STEPS 220 TO 290 AS REQUIRED TILL CLEAR THROUGH VISUAL INSPECTION & PENETRANT INSPECTION. DOCUMENT REWORK ON A SUPPLEMENTAL MTS		QA ENG NA

295	TEST MAG PERM SOP MAG PERM 100, REV 1	TEST MAG PERMEABILITY REPAIR AREAS RECORD ON WELD MAP LIST. TEST AT LEAST 5 POINTS PER WELD. ACCEPTANCE 1.02. IF OK CHECK HERE <input checked="" type="checkbox"/> AND GO TO STEP 430. IF REJECTED CHECK HERE _____.	OK 5/21	
296	GRIND GCHI SOP 0100R2	GRIND AREAS OF NON COMPLIANCE AND RETURN TO STEP 295. REPEAT UNTILL COMPLIANCE IS ACHIEVED.	N/A	
300	X-RAY (NOTE)	IF RADIO GRAPHED AREAS ARE GREATER THAN FOUR TO FIVE INCHES THE CASTING WILL BE SENT TO MQS. SEND TO MQS CHECK HERE _____ RADIOGRAPH AT CAF CHECK HERE <input checked="" type="checkbox"/> Y _____	QA ENGINEER DWA 3-21-05	
310 A	MQS X-RAY DEFECTS REPAIRED BY WELDING	X-RAY PER TECHNIQUE # 12726 USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	LEVEL II N/A	
310 B	CAF X-RAY DEFECTS REPAIRED BY WELDING CQP 401 REV 5	X-RAY PER TECHNIQUE # 12726 USE CALIBRATED DENSITOMETER FOR DENSITY VERIFICATION. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET.	RT - LEVEL II	DWA 3-21-05
320	X-RAY CQP 401 REV 5	X-RAY INTERPRETATION. ACCEPTANCE MSS SP 54. ATTACH TECHNIQUE, READER SHEET FOR ALL RADIOGRAPHS. MUST INDICATE RADIOGRAPHER AND ASNT CERTIFICATION LEVEL ON READER SHEET. IF OK CHECK HERE <input checked="" type="checkbox"/> AND SEND TO STEP 340. REJECTED CHECK HERE _____ MARK UP DEFECTS AND SEND THE CASTING TO STEP 220.	RT - LEVEL II	16

EIO
Energy Industries of Ohio
SUPPLIER QUALITY RELEASE

C-1 Doc Package
Document #26

Date: 3/30/05

I. General Information:

Project Name	Modular Coil Winding Form C1	+ Shim Ctg.	Row
PO No	NCSX SOW 141 02 01		
Supplier	MetalTech		
Procurement Agent	EIO		
Shipment:	<input checked="" type="checkbox"/> Partial	<input type="checkbox"/> Final	

II. Material Description:

Casting C1 Coil

III. Release Checklist:

Plan Requirements Complete?	<input type="checkbox"/> Yes	<input checked="" type="checkbox"/> No	<input type="checkbox"/> N/A (if identified "No" provide explanation in comments section below)
Variances?	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> N/A (if identified "No" provide explanation in comments section below)
Princeton Notified of Shipment?	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> N/A (if identified "No" provide explanation in comments section below)
DCMA Notified of Shipment?	<input checked="" type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> N/A (if identified "No" provide explanation in comments section below)
<input checked="" type="checkbox"/> Conditional	<input type="checkbox"/> Unconditional	Explain conditional releases in comments section.	

IV. Comments:

Metallurgical testing pending, unable to complete prior to shipment.
Final dimensional inspection waiver. (3D Scanner data utilized)
Conditional release (Casting may ship, but metallurgical data must be submitted in a reasonable time frame)
Casting has been accepted by EIO Quality with the above exceptions.

By signing below you acknowledge that the casting has met all applicable standards and contractual requirements

V. Supplier Quality Representative Sign Off

+ Charles Rued	x <i>Ch Rued</i>	3/30/05
Supplier Quality Representative (SQR) Print/Type Name	Supplier Quality Representative (SQR) Signature	Date

VI. Supplier Approval For Shipment

Procurement Agent Notified of Shipment	Date: 3/29/05
Required Vendor Data Ready for Shipment	Date: 3/30/05
Peter A. Djordjevic	<i>Peter A. Djordjevic</i>
Supplier's Representative Print/Type Name	Supplier's Signature
	3/30/05
	Date