

		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 DIMENSIONAL STEPS. EIO NOTIFIED ON <u>1/14/05</u> DCMA NOTIFIED ON <u>1/14/05</u>	Q ENG OR QA MGR	<u>CHC</u>
180	HOLD POINT	HOLD FOR APPROVAL OF XRAY PROCEDURES RECEIVE APPROVAL FROM EIO ON <u>1/11/05</u> <u>for 2-D</u>	QA MGR	<u>CHC</u>
190	X-RAY AT MQS MQS PROCEDURE 20.H.010 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	<u>CHC</u> <u>FO</u> <u>MDS</u> <u>1-12-05</u>
200	LAYOUT Lawton's procedure	INSPECT CASTING TO VERIFY DIMENSIONS. THIS MAY BE PERFORMED BEFORE OR AFTER STEP 190. DIMENSIONED <u>1/10-11/05</u> DATE <u>by 3DS</u> <u>SCALE</u> RELEASED _____ (ENGINEER ONLY)	RT - LEVEL II	
210	X-RAY COP 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	<u>CHC</u> <u>1-19-05</u>
220	WELD SOP 0100 REV 7			
230	L.P. EXCAVATION COP-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	<u>CC</u> <u>2-17-05</u>
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 _____ REPORT SENT BY <u>R. Suria</u> DATE <u>2/18/05</u> DEFECTS < 10% _____ SIGN BY QA ENG. <u>CHC</u>	Q ENG OR QA MGR	<u>CHC</u> <u>1/11/05</u>
NOTICE	WITNESS NOTIFICATION	PROVIDE NOTICE TO EIO AND DCMA AT LEAST FIVE DAYS IN ADVANCE OF WELD STEP. EIO NOTIFIED ON <u>1/11/05</u> DCMA NOTIFIED ON <u>1/11/05</u>	Q ENG OR QA MGR	<u>CHC</u> <u>1/11/05</u>
260	QA APPROVAL HOLD POINT	QA TO APPROVE ELECTRODE PRIOR TO USE. C.F. & M. M. mod level PROCEDURE USED: <u>15-GMAW</u> MATERIAL USED: _____ QUALITY ENG. Name: <u>Pedro Sures</u> DATE: <u>2/18/05</u>	Q ENG OR QA MGR	<u>CHC</u> <u>2/18/05</u>

2080
S. 11/11/05
1/14/05
1/25/05
1/25/05