

Princeton University

Plasma Physics Laboratory

James Forrestal Campus
P.O. Box CN17
Princeton, N.J. 08543

29 August 2005

Ms. Nancy Horton
Energy Industries of Ohio
6100 Oak Tree Boulevard, Suite 200
Independence, Ohio 44131

SUBJECT: Subcontract S005242-F
Corrective Action 1324

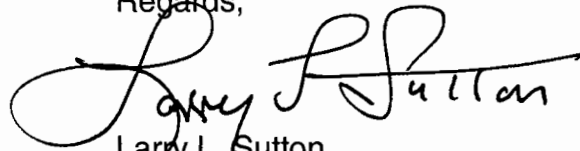
Dear Ms. Horton:

Attached is:

Corrective Action 1324 "For Casting Discontinuities," submitted 18 July 2005 by Mr. C. Rudd, MetalTek International, with The Princeton Technical Representative's and the NCSX Modular Coil Winding Form's Responsible Line Manager's approval, dated 25 August 2005 attached.

If there are any questions pertaining to this matter, I may be contacted at (609) 243-2441, telefax (609) 243-2021, or by e-mail lsutton@pppl.gov.

Regards,



Larry L. Sutton
Senior Subcontract Administrator

Attachment

cc: R. Sheppard
P. Djordjevich

Corrective Action Type FOR CASTING DISCONTINUITIES

Date 7/18/2005

CA Originator C. Ruud

Pattern Number: A-1 Coil

Description of Defect / Non-Conformance

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

Root Cause : Casting defects primarily due gas and shrink.

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

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

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

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

Estimated Implementation Date: Prior to shipment.

Signed: CA Ruud

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

Disposition for CA 1324: Perform weld upgrades per MTM procedures.

Approved:

Phil Heitzenroeder

Tech. Representative

2005.08.25 16:20:38 -04'00'

RLM **Brad
Nelson**

Digitally signed by Brad Nelson
DN: cn=Brad Nelson, c=US,
o=ORNL, ou=FED,
email=nelsonba@ornl.gov
Date: 2005.08.25 17:23:22 -04'00'