



Corrective Action 1454
Carondelet Division - CA / PA / RGA Database
Corrective Action Type NCR
Date 11/18/2005
CA Originator C. Ruud
Applies to: C-5 Coil casting

Description of Defect / Non-Conformance

Zone 1 Tensile test at 77K failed elongation at 31% compared to the specification minimum of 32%. A retest also failed at 29%. All other properties exceeded the specification of NCSX-CSPEC-141-03-09. See attached summary of room temperature and cryogenic test results.

Root Cause

Zone 1 test samples have solidified with much less superheat than the other zones as a result of their relative orientation in the mold and mold filling. Zone 1 test bars are in the bottom of the drag, zone 2 and 3 are much higher in the mold. Zone 1 test bars are getting the first cold metal poured which explains the fine grain structure versus zones 2 and 3. Photomicrographs verify that zone 1 has much finer grain structure than the other zones, see St Louis Testing lab report 05M1167. To verify our thinking the zone 1 test bar was heat treated for 7 hours at 2050 F, the same as the coil casting. Photomicrographs indicate that the grain structure did not coarsen significantly, see St Louis Testing lab report 05M1182. Therefore we conclude the fine structure caused by cold metal entering the cavity is adversely affecting ductility at cryogenic temperatures. Photomicrographs taken at Westmoreland indicate there were no defects to cause the failure, see attached photos.

Corrective Action

Use as is.

Verification of Corrective Action

TBD

Preventive Action

Possibly relocate the cast on bars.

Estimated Completion Date

TBD

Actual Completion Date

TBD

Signed: C. Ruud

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

CC: Jim Galaske, Barry Craig, Joe Edwards, E.J. Kubick, Jerry Markham, Roger Broman

C-5 Coil

11/18/2005

77K (-320F)

293K (RT)

Casting	Test 1						Test 2					
	Required	C5-1Z	C5-2Z	C5-3Z	C5-1Z	C5-2Z	C5-3Z	Required	C5-1Z	C5-2Z	C5-3Z	
Property	21 Msi (144.8 Gpa)	33	31.8	28	34.5	28.2	25.9	20 Msi (137.9 Gpa)	28.4	27.7	25.9	
Elastic Modulus												
0.2% Yield Strength	72 ksi (496.4 Mpa)	112.6	98.3	95.5	111.2	102.5	95	30 ksi	41.5	37.7	37.1	
Tensile Strength	95 ksi (655 Mpa)	182.5	166.1	163.7	177.4	172.3	163.5	78 ksi (537.8 Mpa)	92.9	84.4	83.7	
Elongation	32%	31%	52%	59%	29%	41%	64%	36%	55%	52%	67%	
Charpy V-notch Energy	35 ft. lbs. (47.4 J)	81	73	87				50 ft-lbs (67.8 J)	130	131	156	