

NONCONFORMANCE REPORT

Project No. 20-01402-571

NCR No. 2002-08

PART 1: DESCRIPTION OF NONCONFORMANCE:

One of the Alloy 22 weld qualification specimens CNWRA Drawing 20-01402-571-025 machined by Texas Toolmakers was not machined correctly. A detailed description of the non conformance items is provided below:

- 1. All plates: The 1.00 inch dimension (plate thickness) was not machined. Thickness of machined specimens was left as the nominal plate thickness.
- 2. Plate S/N 003: The 0.250 inch dimension was not recorded on the dimensional inspection for plate S/N 003.
- 3. Plate S/N 006: Thermocouple bore was machined too deep and has nearly penetrated through the weld joint surface.

Initiated by: Darrell S. Dunn *[Signature]*

Date: 7/16/2002

PART 2: PROPOSED DISPOSITION AND CORRECTIVE ACTION

Disposition:

Accept specimens as is.

Basis of Disposition:

The missing dimensional inspection for the 0.250 inch dimension on plate S/N 003 (diameter of thermocouple hole) is an oversight during the dimensional inspection of this part. The nominal plate thickness which is slightly greater than 1.00 inch is acceptable for the weld procedure qualification specimens. Plate S/N 006 was rejected on the basis of the incorrectly machined thermocouple bore. Repair of weld procedure qualification specimen S/N 006 will be performed if needed and all dimensions will be reinspected and documented.

Action to Correct Nonconformance:

The three items listed in Part 1 were discussed with staff at Texas Toolmakers (Mike and Casey Ridgway).

Item #1: Plate thickness is not normally not machined for this type of specimen. Corrections to CNWRA Drawing 20-01402-571-25 are recommended. The 1.00 +/- 0.010 inch dimension for plate thickness should be changed to 1 inch nominal thickness.

Item #2: The 0.250" hole diameter will be verified by SwRI staff and documented on dimensional inspection for Plate S/N. 003. *7/17/2002*

Item #3: No corrective action will be taken at this time. Plate will be tagged indicating out of tolerance dimensions. If weld procedure qualification specimen S/N 006 is used, it will be repaired and re machined. All repair work will be performed at SwRI or a vendor on the SwRI Approved Supplier List and documented.

Target date for completion: *8/31* ~~7/17/2002~~ *7/19/2002* *after discussions with D. Dunn.*

Proposed by: Darrell S. Dunn

Date: 7/16/2002

PART 3: APPROVAL

Element Manager: *[Signature]* Date: 7/16/2002

Director of QA: *[Signature]* Date: 7/17/2002

Comments/Instructions:

PART 4: CLOSE OUT

Comments:

Verified by:

Date:

Distribution:

20/55
All Element Managers
D. Dunn
B. Sogor, H. Garcia
M. Ekstrom, S. Masato
Original To File folder

8/28/22
All P/plates Accepted AS is no corrective action required for nominal thickness of 1 inch ^{plate} and plate 51006 tagged as being out of tolerance and will require repair work prior to use. The 0.250" hole diameter verified by SWR1 QA staff see attached drawing.

all plates accepted as is with the exception of 006. ~~Matrix~~ If plate 006 is used it will require repair. If not used no further action is required. The hole for plate 003 was measured by the S&T inspector and found to be acceptable.



PURCHASE REQUISITION

5/11/02
57

SOUTHWEST RESEARCH INSTITUTE

PURCHASING

REQUISITION DATE 5/22/02	ORDER DATE	PURCHASE ORDER NUMBER	REQ. NO. 610121
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SUGGESTED OR PREVIOUS SUPPLIER Texas Toolmakers		DELIVER TO Darrell Dunn/bldg. 57		PURCHASING SELECTED SUPPLIER	
CITY, STATE San Antonio, TX		SHIP VIA			
ATTN: Mike Ridgway		F.O.B.		SUPPLIER CODE	
PHONE 494-3651		FAX 494-6139		PHONE	
		TERMS		FAX	

LN.	QTY.	UNIT	DESCRIPTION	ORG	PROJECT	ACCT	%	DATE REQUIRED	EST. UNIT PRICE
A	6	EA	C22 weld procedure qualification specimens CWRA drawing 20-01402-571-025	20	01402	571	100	6/12/02	749.00
<p>Quality & Technical Requirements: Specimens as per CWRA drawing 20-01402-571-025. Dimensional inspection per dimensions and tolerances identified in CWRA drawing 20-01402-571-025 is required.</p>									

INTERNAL NOTES TO BUYER	SPECIAL INSTRUCTIONS TO SUPPLIER	TOTAL
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1. Government Project? YES NO

IF YES, CHECK THE APPROPRIATE PROPERTY TYPE (SEE BACK FOR EXPLANATION OF PROPERTY TYPES)

a G-1 CONSUMABLE

b G-2 DELIVERABLE

c G-3 ACCOUNTABLE / REPORTABLE

d IS GOVT. PROPERTY BEING SENT TO SUPPLIER?

YES

NO

2. QUALITY ASSURANCE? YES NO

a ASL REQUIRED? YES NO

b QA CODES: **Q11**

c INSPECTION CRITERIA
PI. Inspect upon receipt.

d QA APPROVAL (IF REQUIRED) DATE
Mark R. Esherton 5/22/02

3. SOURCING NOTES

IF YOU HAVE SELECTED A BRAND NAME OR PARTICULAR MANUFACTURER, WOULD AN EQUIVALENT BRAND OR PRODUCT ALSO SATISFY YOUR NEED? YES NO

IF YOU HAVE SUGGESTED A SUPPLIER, AND NO OTHER SUPPLIER WILL MEET YOUR NEEDS, PLEASE ATTACH A MEMO OF EXPLANATION.

REQUESTOR'S SIGNATURE
Darrell Dunn

EXT. NO.
6090

DEPT. / DIVISION APPROVAL
[Signature]

DATE
5/27/02

ADMIN. APPROVAL
[Signature]

DATE

4. REPAIRS

a IS THIS REQ. FOR A REPAIR? YES NO

b IS THE REPAIR ON OR OFF CAMPUS? ON OFF

c IF OFF CAMPUS PROVIDE SHIPPING TICKET

NO. **2155**

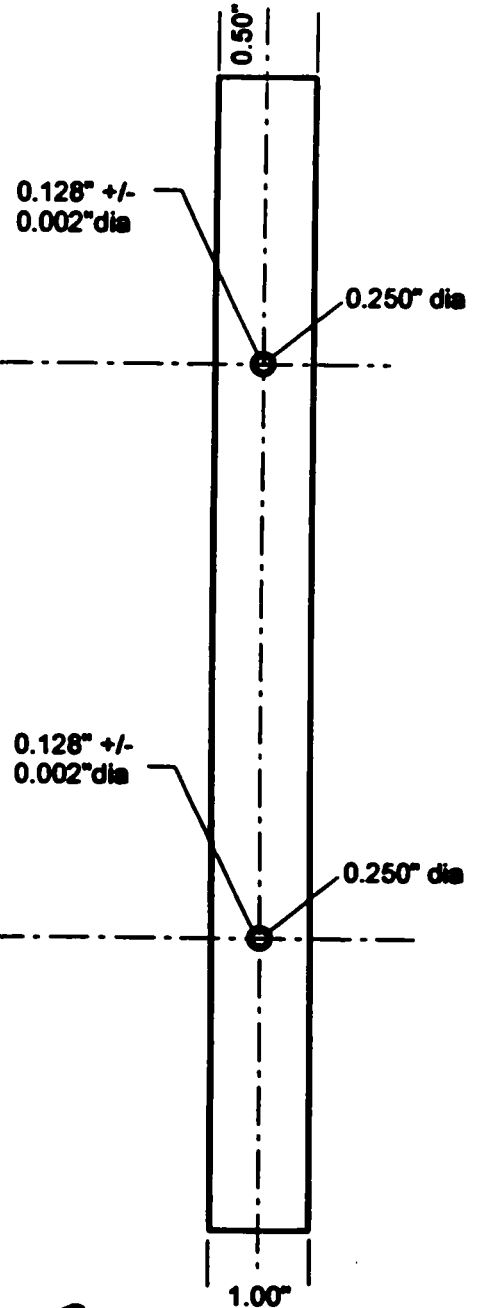
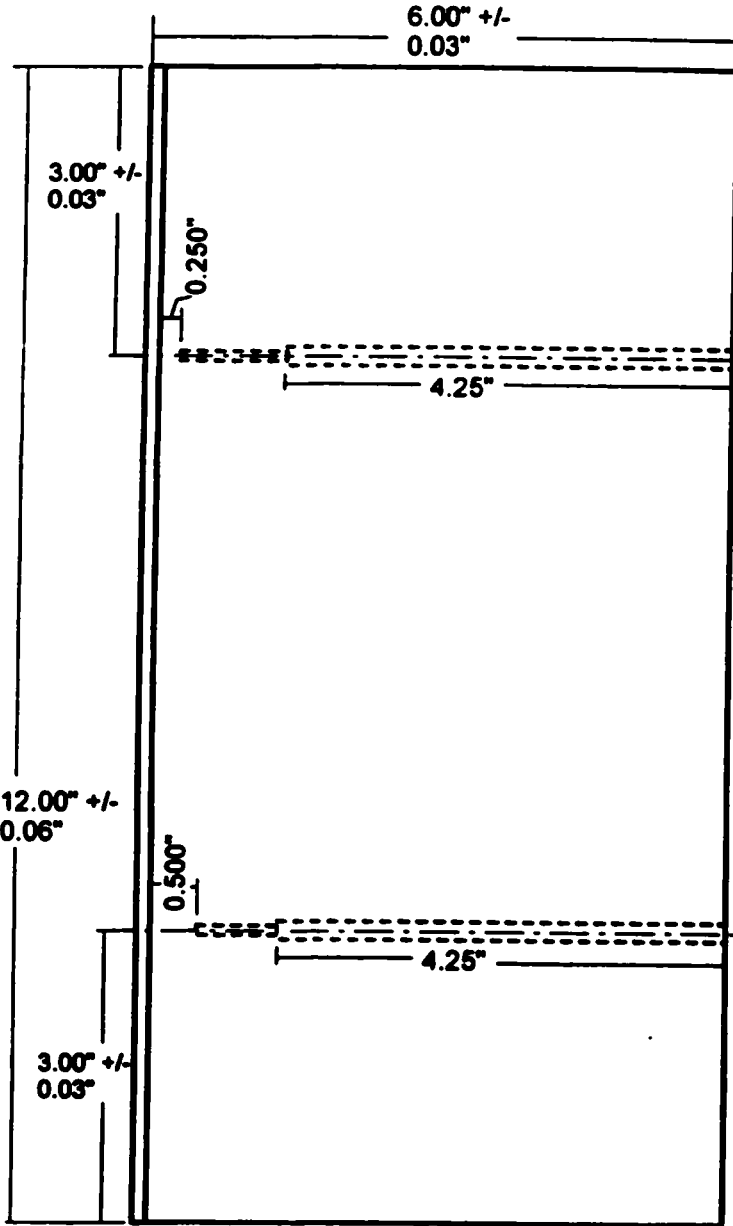
CONTRACT REVIEW APPROVAL _____ BUYER SIGNATURE _____ DATE _____ SEE INSTRUCTIONS ON REVERSE SIDE

Darrell S. Dunn
SwRI-CNWRA
Phone: (210) 522-6090
Fax: (210) 522-5184
e-mail: ddunn@swri.org

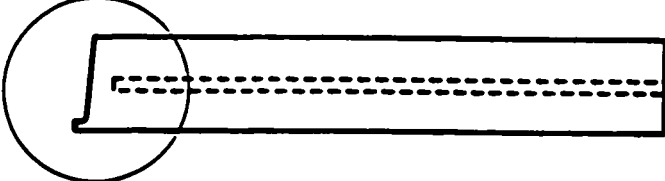
Alloy 22 Rod Specimen
CNWRA Drawing 20-01402-571-25
All Dimensions $\pm 0.010"$
unless otherwise specified
Note: Detail A on Page 2

Page 1 of 2

TC completed at time of order. 22/55
Material: ALLOY 22
Heat: 2277-1-3164
Specimen Orientation:
Other:



Detail A



Darrell Dunn 5/22/02
Initiated by D. Dunn Date

V. Jain 5/22/02
Reviewed by V. Jain Date

B. Mabrito 5/22/02
QA Approval B. Mabrito Date

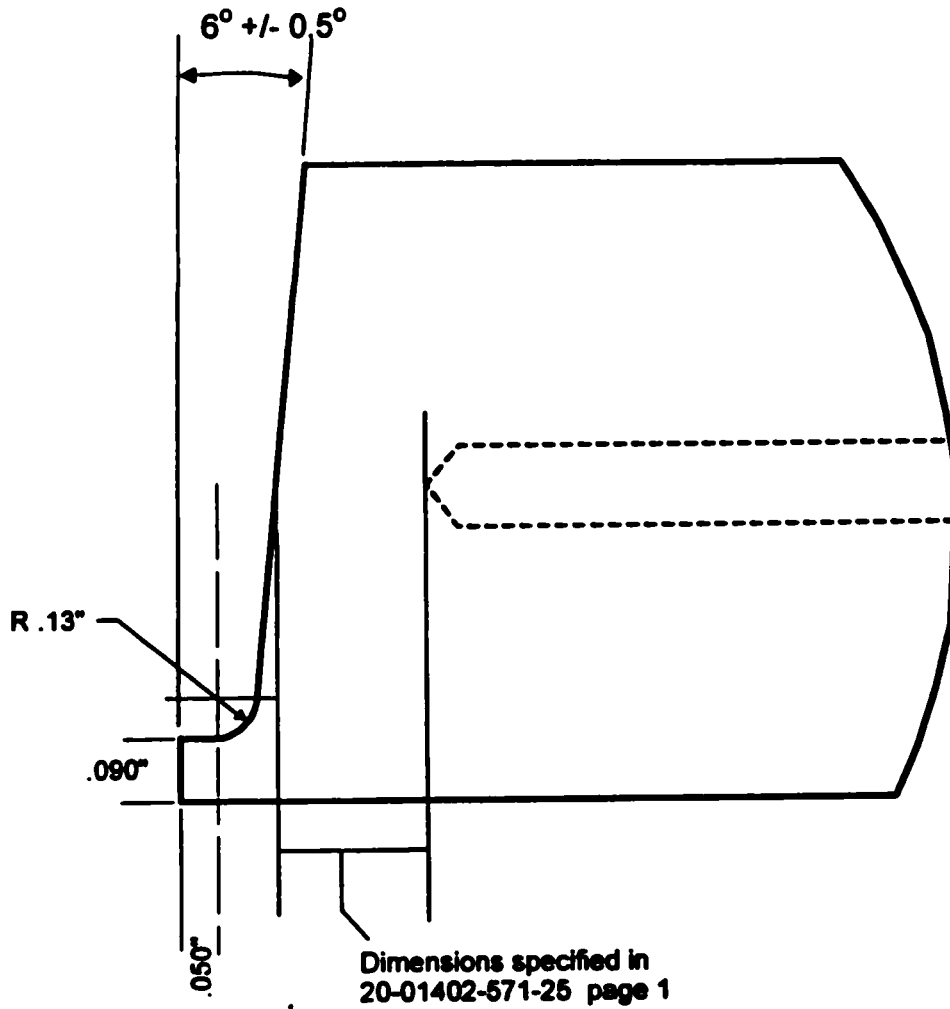
Darrell S. Dunn
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e-mail: ddunn@swri.org

Alloy: Weld Specimen
CNWRA Drawing 20-01402-571-25
All Dimensions $\pm 0.005"$
unless otherwise specified
Detail A identified on Page 1

Page 2 of 2

To: Completed at time of order. 23/5
Material: ALLOY 22
Heat: 2277-1-3164
Specimen Orientation: _____
Other: _____

Detail A



Darrell Dunn 5/22/2002
Initiated by: D. Dunn Date

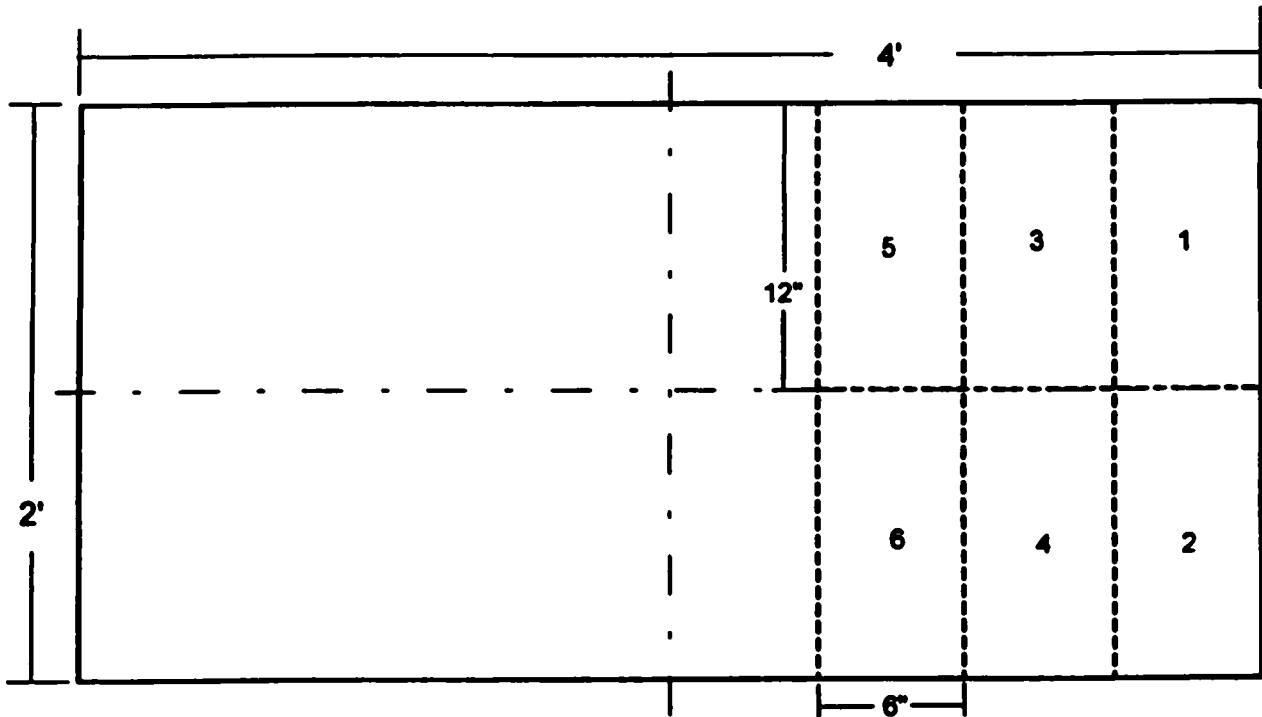
V. Jain 5/22/02
Reviewed by V. Jain Date

B. Mabrito 5/22/2002
QA Approval B. Mabrito Date

Darrell S. Dunn
SwRI-CNwRA
Phone: (210) 522-6090
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e-mail: ddunn@swri.org

Ref: drawing for weld procedure
qualification specimens
CNwRA Drawing 20-01402-571-026
No dimensional tolerances

 completed at time of order. 24/5
Material: Alloy 22
Heat: 2277-1-3164
Specimen Orientation: As Shown
Other:



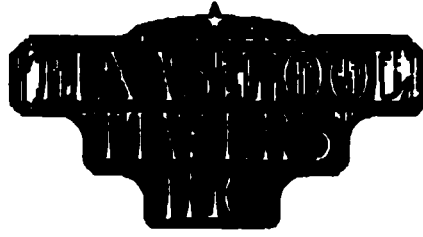
Darrell Dunn 5/22/2002
Initiated by: D. Dunn Date

V. Jain 5/22/2002
Reviewed by V. Jain Date

B. Mabrito 5/22/2002
QA Approval B. Mabrito Date

26/55

11411 East Coker Loop
San Antonio, Texas 78216
(210) 494-3651 * Fax (210) 494-6139
www.texasoolmakers.com



CERTIFICATE OF CONFORMANCE

TO: Southwest Research Institute
6220 Culebra Road
San Antonio, Tx. 78238-5166

CUSTOMER P.O. 2857166

TTI JOB #: 33484

DESCRIPTION 5 EA. P/N 20-01402-571-25 ALLOY 22 WELD SPECIMEN


WE CERTIFY THAT THE ITEM(S) ON THE ABOVE REFERENCED PURCHASE ORDER HAVE BEEN PROCESSED AND/OR MANUFACTURED IN ACCORDANCE WITH:

Drawings

RECORDS ARE ON FILE AT THIS FACILITY, WHICH VERIFY OUR PROCESS CONTROLS, AND AVAILABLE FOR REVIEW UPON REQUEST. TEST RESULTS ARE AS FOLLOWS:

ACCEPTED

TEXAS TOOLMAKERS,

BY :  (Steven Espinoza)
TITLE: Q.C. Inspector
DATE: 7/16/02

CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES

33/55

MEMORANDUM

August 30, 2002

TO: Nonconformance Report (NCR) 2002-08 File

FROM: Bruce Mabrito, Director of CNWRA QA



SUBJECT: Status/Extension on NCR 2002-08

This memorandum to the NCR 2002-08 file is an explanation of the progress to date on closing out this NCR and provides for an extension in the target dates for completion.

NCR 2002-08 describes Alloy 22 specimen preparation shortcomings to be used in the CNWRA weld qualification process.

The subject target date for completion of NCR 2002-08 was first extended to August 31, 2002. Item No. 3 on this NCR will have to be further extended until a decision is reached on whether specimen SN 006 is going to be utilized in the CNWRA process. If used, further repair and machining is required.

Item No. 2 on the NCR, examination of a 0.250-inch hole, has been performed and is acceptable. Item No. 1, drawing revision has not been performed but is not a quality-affecting hold point for close out of NCR 2002-08 .

Based on this information and the currently anticipated activity in the CNWRA, I am extending the formal target date for completion of NCR 2002-08 to September 13, 2002.

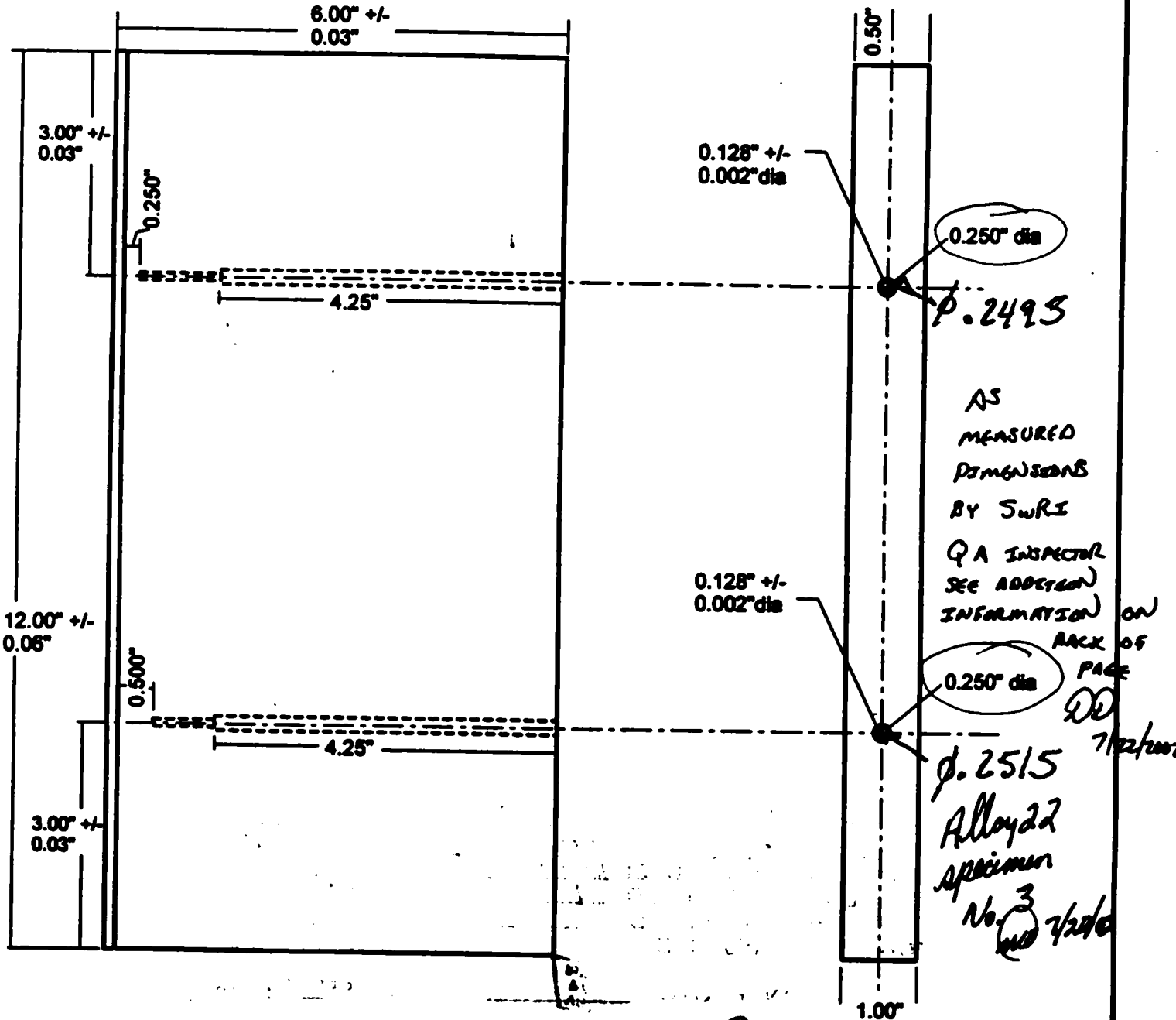
cc: B. Mabrito
D. Dunn
M. Ehnstrom/30
T. Mayces/30
M. Padilla/CNWRA QA

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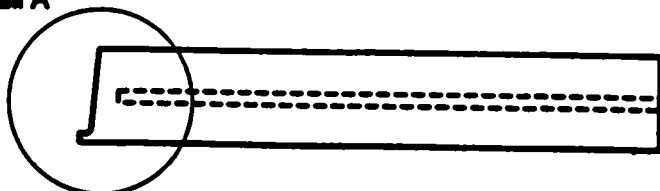
Alloy 22 Specimen
 CNwRA Drawing 20-01402-571-25
 All Dimensions $\pm 0.010"$
 unless otherwise specified
 Note: Detail A on Page 2

Page 1 of 2

To: Completed at time of order.
 Material: ALLOY 22 34/55
 Heat: 2277-1-3164
 Specimen Orientation: _____
 Other: _____



Detail A



Darrell Dunn SwRI
 Initiated by: D. Dunn Date

V. Jain 5/24/02
 Reviewed by: V. Jain Date

B. Mabrito 5/22/02
 QA Approval B. Mabrito Date

JUL 18 2002