CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES

NONCONFORMANCE REPORT

Project No. 20.06002.01.081	NCR No. 2003-01
Industrial Mechanical was bowed. Part of the bow was remove surfaces. A detailed description of the non conformance items 1. Thickness of machined specimens was reduced by	drawing were necessary because the Alloy 22 plate supplied to ved by pressing and part was removed by machining the plate is is provided below: y 0.005 to 0.030" to remove bow in plate. Final thickness after vided by Industrial Mechanical. (all 4 specimens) to to 0.097"
PART 2: PROPOSED DISPOSITION AND CORRECTIVE	VE ACTION
Disposition: Accept specimens as is. Basis of Disposition: The variation in the thickness of the land will not affect weld:	ability of the plate. Integrity of the weld joint will be assessed by
non destructive examination including penetrant testing of the Action to Correct Nonconformance: None.	e root pass and radiographic testing of the completed weld
	Target date for completion: 2/28/2003
Proposed by: Darrell S. Dunn PART 3: APPROVAL Element Manager: Date: Director of QA: Mala & Date:	1/-0/-
Comments/Instructions:	
PART 4: CLOSE OUT Comments: No further action require	Distribution:
Verified by Mark D. Shusting Date: 3/6/0	, 23

IMC Machine Shop (210)662-1690
IMC Machine Shop Manager (210)662-1696
IMC Machine Shop Superintendent (210)662-4596

COMPONENT INSPECTION REPORT

	Name	•	Part Num	nber	Dwg.	No.
ALL	COY 22 WELD SPEC	IMEN		A	20-6	06002-01-081-001
Heat	No. 2277-1-3/69 P.O. No	<u>_</u>		IMC Job No.	Inspection	n Date
27-	No. 2277-1-3/64 P.O. No. 58-575-98-No.022 341417-01 380	18945		1173	1-1	5-03
No.	Feature	Qty. Accepted	Qty. Rejected	Actuals	Meas. Tool I.D.#	Remarks
1	24.00" ± .06"		0	24.048"	1MC 200-048	• 1
2	3.00"±.03"	/	0	3.018"	146 200-007	
3	"NOMINAL THICKNE	22	Ô	SEE MODIFICATION	ns shee	7
4	1050" + .005	" /	0	.054"	IMC 200-052	
5	,090" +.005	". V	0	.094/.087	1MC 200-052	
کم	R.13" ±.00	5" /	0	oK	Radius Guage	
7	6°±0°30"	/	0	OK	noticated Machine	
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	en e					•

CHECKED BY: LESUS TORRES

DATE: 1-15-03

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IMC Machine Shop Superintendent (210)662-4596

COMPONENT INSPECTION REPORT

	Name		art Num	per	low	g. No.
ALL	OY 22 WELD SPECIM	EN		В	20	1-06002-01-081-001
ASME	No.2277-1-3164 P.O. No. 58-575-98-NO60 22 341417-01 3828	945		IMC Job No.		ion Date 15 - 03
~ /			1	1	<u> </u>	
No.	Feature	Qty. Accepted	Qty. Rejected	Actuals	Meas. Tool I.D.#	Remarks
1	24.00°±.06"	/	0	24.046"	1ME 200-048	
2	3.00° ± .03"	V	0	3-015"	1MC 200-007	
3	I NOMINAL THICKNESS		0 51	E MODIFICATIONS	SHEET	;
4	.050" +.005	~	0	,053"	IMC 200.062	
5	.090" ± .005	/	0	.088'/.095"	14 C 200-052	
6	R.13" ±,005"	V	0	OK	Radius	
7	6° ± 0° 30°		0	OK	ndilated Machine	
					-	
<u> </u>					¹ 25	
				•		
,						
	••					
CHE	CKED BY: JESUS TORRES		DA	TE: <u>/-/5-03</u>	P	AGE OF

IMC Machine Shop (210)662-1690
IMC Machine Shop Mar ar (210)662-1696
IMC Machine Shop Superintendent (210)662-4596

COMPONENT INSPECTION REPORT

Part N			art Nun	nber][Dwg. No.
ALL	OY 22 WELD SPECIA	MEN		4 C		20-06002-01-081-001
Heat	No. 2277-1-3164 P.O. No.			IMC Job No.	Insp	ection Date
45ME 27	58-575-98-NOSOAA 341417-01	945	•	1173	1	- 15-03
No.	Featur e	Oty. Accepted	Qty. Rejected	Actuals	Mea Tool I.D.;	<u></u>
1	24.00" ± .06"	/	0	24.032"	176 200 04	
2	3.00" ± .03"	/	0	3.015"	IUC 200-0	
3	I NOMINAL THICKNESS		0 3	EE MODIFICATIONS	540	EET
4	.050" T.005	/	0	1054	14C 200-	052
5	.090" ±.005			.090 / .097	IMC 200-0	Specified on drawing Disturbed with D. Dunn
4	R.13" +.005"	`\	0	OK	Radii Guag	ue on phone @ 2:15 1/15/03;
7	6° ± 0° 30"	1	0	OK ch	dilat Mark	ad ine
		-			145	
		:			,	
				4		
	;					
		·				
CHE	CKED BY: JESUS TOMBE	_	DA	TE: <u>/-15-03</u>		PAGE / OF _/

CHECKED BY: Jesus Torres

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IMC Machine Shop Mar. 3r (210)662-1696
IMC Machine Shop Superintendent (210)662-4596

COMPONENT INSPECTION REPORT

	Name	1	art Num	iber	DW	g. No.
ALL	OY 22 WELD SPECIMA	EN		D	20	-06002-01-081-001
Heat	No.2277-1-3164 P.O. No.			IMC Job No.	Inspect	tion Date
•	341417-01 38	289 4	S	1173	/-/	15-03
No.	Feature	Qty.	Qty. Rejected	Actuals	Meas. Tool I.D.#	Remarks
1	24.00" ± .06"	1	0	24.035"	IMC 200-0 48	
2	3.00" + .03"	/	0	3.014"	146	
3	"NOMINAL THICKNESS	/	0 5	EE MODIFICATIONS	SHEE	7
4	.050" +.005"	/	0	.054"	1MC 200-052	
5	.090" ± .005"			1093"/100"	1MC 200-052	5 pelified on drawing, Discussed with D. Dunn
6	R13" +.005"	/	0	01	Grage	on plane @ 2:15 1/15/03.
7	6° ± 0° 30"		0	0K	litated Markine	
	<u> </u>					
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	Darrell S. Dunn SwRI-CNWRA Phone: (210) 522-6090 Fax: (210) 522-5184 e-mail: ddunn@swri.org	Alloy 22 Weld Specimen CNWRA wing 20-0600 Dimensional tolarances a Note: Detail A on Page 2	IWRA wing 20-06002-01-081-001 nensional tolarances as specified te: Detail A on Page 2 Heat:			d at time of order:		
	e-mail. dddim@swn.org	Page 1 of 2	•	Other:				
				Other:				
	. · · ·	3.00" +/- ②	•		· <u>*</u>			
	24.00" +/- 0.06"			nitiated by. D.	Dun	1" nominal thickness /8/7/2w7 Date		
)	7		Ĭ	Reviewed by W		10/7/2002 Date		
				Sunu M DA Approval B		0/2/2002 Date		

Alloy 22 Weld Specimen
CNWRA awing 20-06002-01-081-001 To be completed at time of order. Darrell S. Dunn SwRI-CNWRA Mat All Dime. ons ± 0.005" Phone: (210) 522-6090 unless otherwise specified Fax: (210) 522-5184 Heat: Detail A identified on Page 1 e-mail: ddunn@swri.org Specimen Orientation: Page 2 of 2 Other. Detail A 6° +/- 0,5° R .13" .090" HEAT NO: 2277-1-3164 ASME 58-575-98-NO6022 Initiated by. D. Dunn 27-341417-01

Date

QA Approval B. Mabrito

IMC

Fax: 210-662-4503, 661-6060

INDUSTRIAL MECHANICAL COMPANY A DIVISION OF CCC GROUP, INC. 5797 Dietrich Road San Antonio, Texas 78219 Phone: 210-662-1690, 662-4596

Modifications to (4ea.) Alloy 22 Plates

Amount of bow in plates prior to straighte	ening: A) , 096
(The bow is along the 24" length)	B), 060
(Plates are identified A thru D)	C), 030
	D), 020

Procedure used to straighten plates: Plates were straightened on a small hydraulic press (80-ton). As each plate was supported @ each end on press plates, pressure was applied to the center with a piece of aluminum under the push rod for no marring.

081

Amount of bow taken out after straightening:	A)	.001
	B)	,050
	C)	, 030
	D)	,020
Amount machined from bottom face for flatne	ss: A)_,	005015
	B)	010-1015
	C)_	,030
	D)_	.020
	,	
Final thickness after machining:	A) /. C	20-1.025
	B) . 9	93 - 1.030
		75 / 200

NOTE: This necessary work was not included in the quote. approval to proceed was given by Darrell Dunn via a phone conversation 1/10/03.

a. E. Lonny "Rogers L.