CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES

NONCONFORMANCE REPORT

Project No. 20.06002.01.081 **NCR No.** 2004-07

PART 1: DESCRIPTION OF NONCONFORMANCE:
One of the Alloy 22 plates welded by Roben Manufacturing, Inc (P.O. 425825D) has an indication approximately 6 mm [0.25 in] in length that appears to be lack of fusion between weld passes. Three other plates welded by Roben Manufacturing were acceptable.

Initiated by: Darrell S. Dunn **Date:** 6/4/2004

PART 2: PROPOSED DISPOSITION AND CORRECTIVE ACTION

Disposition:
Accept specimens as is. Area with indication will not be used in mechanical property or corrosion tests.

Basis of Disposition:
The indication is discrete and can easily be located and avoided in the machining of test specimens. Radiographic testing has shown that the remaining portion of this plate is free of rejectable indications.

Action to Correct Nonconformance:
The vendor, Roben Manufacturing, Inc. will be notified and provided with a copy of the radiographic film showing the lack of fusion indication.

Target date for completion: 6/11/2004

Proposed by: Darrell S. Dunn **Date:** 6/4/2004

PART 3: APPROVAL

Element Manager: **Date:** 6/4/2004

Director of QA: **Date:** 6/4/2004

Comments/Instructions:

PART 4: CLOSE OUT

Comments: A copy of the radiograph showing the flaw, a copy of the reader sheet, and a copy of the exposure technique sheet has been sent to Roben.

Verified by: Mark R. Ehnston **Date:** 6/14/04

No further action is required

Distribution: D. Dunn
V. Jain
B. Sagar

ISwT RADIOGRAPHIC EXAMINATION RECORD

PROJECT No. :	SITE :	DATE : (DAY - MONTH - YEAR)	SHEET No:
04-0356	SwRI	1-Jun-04	01010604-1

MATERIAL THICKNESS:	MATERIAL DIAMETER:	MATERIAL TYPE:	WELD CROWN HEIGHT:	WELD TYPE:	PROCEDURE:	REV: 0	CHG: 0	ICN: ☑ N/A
1.0"	Plate	S.S	1/16	Butt	SWR-NN-RT1			

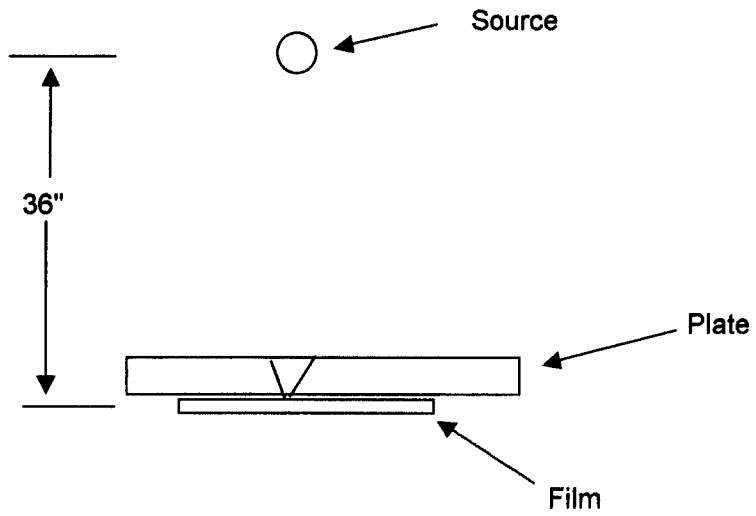
ISOTOPE:	DIA. X LENGTH:	CURIES:	DISTANCE:	TIME:	EFFECTIVE SHARPNESS:	FILM BRAND:	FILM SIZE:	FILM TECHNIQUE:
n/a	n/a	n/a	n/a	n/a		Kodak T	4.5 X 17"	☑ SINGLE WALL ☐ DOUBLE WALL

X-RAY:	Kv:	MA:	DISTANCE:	TIME:	FOCAL SPOT SIZE:	EXAMINER:	SNT LEVEL:
Sperry	290	10	39"	12min	.19"	Duncan J Maclean	II

QUALITY LEVEL:	PENETRAMETER ID:	FILM PROCESSING:	SHIM MATERIAL:	SHIM THICKNESS:
2T	20 ASTM	Manual	N/A	N/A

1. No. of Views 1
2. Location of Radiation
   Source and Beam Angle 90
3. Location Markers 1-2
4. Screen Typ Lead
5. Thickness (in.) Front: 0.01 Back: 0.01
6. Signal Load ☐ Double Load ☑
7. No. of Film 2

SHOOTING SKETCH



COMPONENT ID : Plate , alloy 22

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ISwT Form RT -01 (Rev. 06/00)

ISwT RADIOGRAPHIC INTERPRETATION RECORD

PROJECT No. :	SITE :	DATE : (DAY - MONTH - YEAR)	SHEET No:
04-0356	SWRI	1-Jun-04	01010604-4

COMPONENT IDENTIFICATION:	FILM INTERPRETATION BY:	SNT LEVEL:	ACCEPTANCE STANDARD:
Plate, ALLOY 22	Duncan J Maclean	II	ASME Sec. III

FILM, SEAM OR JOINT NUMBER	FILM INTERVAL NUMBER	PENETRAMETER SIZE AND CONDITION	ACCEPT	REJECT	SLAG	POROSITY	CRACK	LACK OF PENETRATION	LACK OF FUSION	UNDERCUT	SURFACE	SHRINK	HOT TEAR	SAND	CHAPLETS	DATE FILM EXPOSED	REPAIR No.	REMARKS
# 5 G	1-2	20 2T		✓					✓							6/1/04	n/a	1/4" LOF STILL PRESENT AFTER GRINDING. DS

REMARKS

NONE

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ISwT Form RT -02 (Rev. 06/00)

ISwT RADIOGRAPHIC EXAMINATION RECORD

PROJECT No. :	SITE :	DATE : (DAY - MONTH - YEAR)	SHEET No:
04-0356	SwRI	28-May-04	01280504-1

MATERIAL THICKNESS:	MATERIAL DIAMETER:	MATERIAL TYPE:	WELD CROWN HEIGHT:	WELD TYPE:	PROCEDURE: REV: 0 CHG: 0 ICN: ☑ N/A
1.0"	Plate	S.S	1/16	Butt	SWR-NN-RT1

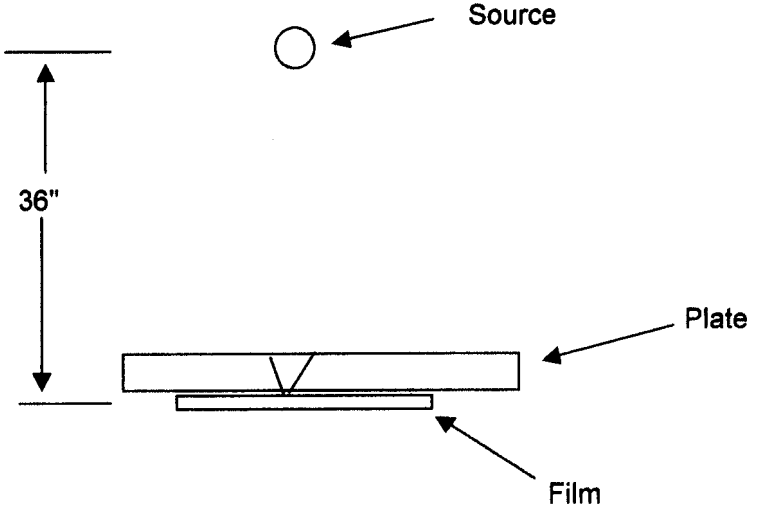
ISOTOPE:	DIA. X LENGTH:	CURIES:	DISTANCE:	TIME:	EFFECTIVE SHARPNESS:	FILM BRAND:	FILM SIZE:	FILM TECHNIQUE:
n/a	n/a	n/a	n/a	n/a		Kodak T	4.5 X 17"	☑ SINGLE WALL ☐ DOUBLE WALL

X-RAY:	Kv:	MA:	DISTANCE:	TIME:	FOCAL SPOT SIZE:	EXAMINER:	SNT LEVEL:
Sperry	290	10	39"	12min	.19"	Duncan J Maclean	II

QUALITY LEVEL:	PENETRAMETER ID:	FILM PROCESSING:	SHIM MATERIAL:	SHIM THICKNESS:
2T	20 ASTM	Manual	S.S.	.06"

1. No. of Views 1
2. Location of Radiation
   Source and Beam Angle 90
3. Location Markers 1-2, 2-3
4. Screen Typ Lead
5. Thickness (in.) Front: 0.01 Back: 0.01
6. Signal Load ☐ Double Load ☑
7. No. of Film 4

SHOOTING SKETCH



COMPONENT ID : Plate , alloy 22

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ISwT RADIOGRAPHIC INTERPRETATION RECORD

PROJECT No. :	SITE :	DATE : (DAY - MONTH - YEAR)	SHEET No:
04-0356	SWRI	28-May-04	01280504-4

COMPONENT IDENTIFICATION:	FILM INTERPRETATION BY:	SNT LEVEL:	ACCEPTANCE STANDARD:
Plate, ALLOY 22	Duncan J Maclean	II	ASME Sec. III

FILM, SEAM OR JOINT NUMBER	FILM INTERVAL NUMBER	PENETRAMETER SIZE AND CONDITION	ACCEPT	REJECT	SLAG	POROSITY	CRACK	LACK OF PENETRATION	LACK OF FUSION	UNDERCUT	SURFACE	SHRINK	HOT TEAR	SAND	CHAPLETS	DATE FILM EXPOSED	REPAIR No.	REMARKS
# 5	1-2	20 2T		✓					✓							5/28/04	n/a	1/4" LONG POSSIBLE WELD SPATTER
# 5	2-3	20 2T	✓													5/28/04	n/a	NONE

REMARKS

NONE

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