

CENTER FOR NUCLEAR WASTE REGULATORY ANALYSES

NONCONFORMANCE REPORT

Project No. 20.06002.01.081

NCR No. 2004-07

2 *APB 2/17/04*

MSE
2/24/04

PART 1: DESCRIPTION OF NONCONFORMANCE:

Alloy 22 weld specimens CNWRA Drawing 20-06002-01-081-001 welded by Roben Manufacturing required modification in order to be welded. The weld joint geometry was modified by Roben Manufacturing by machining (milling). The 6 degree taper was increased to ~~15~~ ²⁰ degrees to produce a weld joint with a ~~20~~ ⁴² degree included angle. The modification was necessary to allow sufficient clearance of the welding torch/gun.

Initiated by: Darrell S. Dunn

Date: 2/17/2004

PART 2: PROPOSED DISPOSITION AND CORRECTIVE ACTION

Disposition:

Accept specimens as is.

Basis of Disposition:

The change in the weld joint geometry was necessary to permit welding. After machining, the specimens were welded by Roben Manufacturing. The integrity of the weld joint was evaluated by Roben Manufacturing using penetrant testing (root and final pass) and radiographic testing. After receipt, the welds were inspected using radiographic testing performed by IHI Southwest. The nondestructive examinations revealed that the welds were acceptable.

Action to Correct Nonconformance:

CNWRA Drawing 20-06002-01-081-001 has been revised.

Target date for completion: 3/2/2004

Proposed by: Darrell S. Dunn

Date: 2/17/2004

PART 3: APPROVAL

Element Manager: *[Signature]*

Date: 2/17/04

Director of QA: *[Signature]*

Date: 2/17/04

Comments/Instructions:

PART 4: CLOSE OUT

Comments: *Drawing 20-06002-01-081-001 Revision 2 correctly shows the weld joint taper at 21° ± .5°. No further action is required*

Distribution:

Verified by: *[Signature]*

Date: 3/2/04