

Audit Review and Evaluations of JEMISON METALS

**914 Maero St. NW
Trinity, AL 35673**

Dates of Audit: 10/25/24
Date of Submittal: 10/31/24

Auditors: Rick Rowland – SR VP QA & Engineering

1.0 Summary

This internal audit review provided an evaluation of Jemison's current level of conformance to the ISO 9001:2015, against the current internal audit schedule. The audit measured how effectively the quality management system is implemented in conformance with the applicable requirements and standards. **Based upon our review, the QMS is effectively implemented.**

Audit Detail/Observations/Findings

7.5 – Documented Information

The following forms and documents were verified during the audit: GAD009 9.18.17 Rev Level 2 in Receiving, DEC-BB1-CTL 6.26.17 Rev Level 4 at the operator's platform, JDM-VA-0018.31.10 Rev level 0 at operator's platform and at packaging computer. JDM200 Quality Policy 7.21.18 Rev-1 posted at bulletin board.

7 Support

Employees appeared competent and well trained. Adequate resources (gauges, safety equipment, operating equipment, and environment) were observed during the audit.

7.2 Competence

Interviewed Greg Chandler (Receiving), Leroy Fikes (Operator) and Blake Key (Shipping). All 3 were able to locate the Jemison Quality Intranet, Quality Policy, and Procedures. Leroy was able to elaborate on how he contributes to the quality policy by performing his required quality checks.

Additional employees talked to: Sarah Stoeckinger (Inside Sales), Whitney Windsor (Maintenance), Cade Tittle (Purchasing/Materials Mgmt), Justin Pate (Plant Manager)

Reviewed Training Status Matrix, which had employees clearly identified, Greg, Blake and Leroy showing competent and fully trained.

8.2 Requirements for products and services

Contract Review/Order Acknowledgement: Wabtec TX ordered material on 9/23/24 on PO 173812090 for 44,247 lbs of part 3072-B8A3A 0773S (A1011 HRPO Sheets CS Type B Temp Passed, 72 x 120"). Sarah Stoeckinger (Inside Sales for this customer) acknowledged the request via email the same day and entered sales order GAD-150691 the same day. Work order GAD 193383 was created also created on 9/23/24.

Purchasing: Tag ND82607 on receiver GAD 68514-001 for BTB was reviewed with purchasing. Tag ND82607 was applied to BTB part number 61H03-375-60X120 and was purchased on PO GAD 025482-001. This part number had requirements of: 3/8" (.365" min), HSLAS Grade 50 Class 1: Yield 50ksi min, 65ksi min, 20% min elongation. Actuals: Yield: 66 ksi, Tensile 74.6 ksi, 33.5% elongation. 40,000-48000 lbs on PO,

actual was 44,460lbs. PO requirements to the mill matched the received coil requirements (.375" Thick, 59.875" Wide, Yield/Tensile/Elongation etc).

8.4 Control of externally provided processes, products and services

Receiving: Receiver GAD 68514-001 was received by Greg Chandler. Mill Coil 5128540.000, from Nucor Decatur was weighed at 44,460lbs. Receiving Inbound Inspection report GAD009 9/18/2017, Rev 2 was filled out completely and all checks met the requirements of PO GAD 025482-001.

8.5-Production & Service Provisions

Production: Work order 193383, customer Wabtec TX. Production of 11ga CS Type B Temper Passed 72" x 120" sheets. Gauge (.112-.128", .114" Actual). Width (Cut Edge 72" -72.3125", Actual 72.062"), Length (120" -0 + .375", Actual 120.125"). Tags 966529-966536 + Tag 969945 were cut. All checks were within tolerance and documented on the production report (DEC-BB1-CTL 6/26/17 Rev 4).

Production Planning: Reviewed Work order 193383 on production above with Production Planner Steven White. Steven showed me the planning board as well as the green items listing to determine what jobs to schedule.

Shipping: BOL GAD 141567 was observed in shipping. This was a transfer order to Jemison Metals Gadsden. Material was pre-staged and identified with colored flags. Items were visually verified against the loading order and 5 tags total were loaded totaling 44,705lbs. Blake Key, shipping supervisor was interviewed.

7.1.3 Infrastructure

Preventive Maintenance: Whitney Windsor provided the following PM evidence:

- 3 overhead crane inspections (performed by external organization on 10/1/24) were reviewed. The 15T and 30T cranes had no high priority items noted. The 50T crane had 2 high priority items (Bridge Bumpers need replaced & Main Hoist wire needs replaced). Parts are on order and will be replaced by the Crane Company.
- Stretch Leveling Line maintenance is organized by timeframes. 1, 2, 4, 6, 10, 13, 19 and 25 week intervals were reviewed. Most recent dates for each of these timeframes is in the audit notes and met the scheduled requirements of the preventive maintenance plan.

7.1.5 Monitoring and Measuring Resources

The following gauges were verified to be calibrated in compliance with calibration records via Gagetrak:

Receiving:

Micrometer serial#: 011 calibration due 9/12/25.

Tape Measure serial#: T201 calibration due 2/22/25.

Receiving Scale serial#: 12916, calibration due 12/26/24.

BB1 CTL:

Micrometer serial#: 015 calibration due 4/24/25.

Tape Measure serial#: T232 calibration due 1/4/25.

Step Gauge serial#: ST10 calibration due 9/26/25.

8.7 Control of Nonconforming Product

The nonconforming area was neat and identified with tags that had descriptions in the comments about the issue. The nonconforming area is at the opposite end of the plant is clearly delineated.

Tag 959025 .1965” x 60x120”, 2 pcs, 775 lbs was reviewed. It had the tag remark “Suspect Bowing”, dated 10/18/24. Tag was verified as being in DRJ (Decatur Reject Warehouse).

Tag 967348, .239” x 42 x 93.5”, 5 pcs, 1,380 lbs was reviewed. It had the tag remark “Pits and Scratches MC-27324”, dated 10/22/24. Tag was verified as being in DMC (Decatur Mill Claim Warehouse).

10.2 Nonconformity and Corrective Action

No Open Corrective Actions to Review.

10. Improvement

Machine data review and operator scorecard feedback was implemented in 2023; however, we added color codes to the scorecards, in May 2024, for visual feedback to the operators.

Addition of Beverly Clem, Quality Technician, at Decatur facility in August 2024.

2.0 Overview

2.1 Personnel Interviewed (Audit evidence found in the Audit Worksheets)

Leroy Fikes – BB1 CTL Operator Blake Key - Shipping Greg Chandler - Receiver Steven White-Prod Planner	Sarah Stoeckinger-Inside sales Justin Pate - Plant Manager Whitney Windsor - Maintenance Cade Tittle - Purchasing
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2.2 Audited Requirements

<ul style="list-style-type: none">4 Context of the Organization<ul style="list-style-type: none">4.4 Quality Management System and its processes5 Leadership<ul style="list-style-type: none">5.1 Leadership and commitment5.1.2 Customer Focus5.2 Policy5.6 Management review6 Planning7 Support<ul style="list-style-type: none">7.1.1 General7.2 Competence7.1.3 Infrastructure7.1.4 Environment for the operation of processes7.1.5 Monitoring and measuring resources7.5 Documented information	<ul style="list-style-type: none">8 Operation<ul style="list-style-type: none">8.1 Operational planning and control8.2 Requirements for products and services8.3 Design and development of products and services (N/A)8.4 Control of externally provided processes, products and services8.5 Production and service provision8.7 Control of nonconforming outputs9 Performance evaluation<ul style="list-style-type: none">9.1 Monitoring, measurement, analysis and evaluation<ul style="list-style-type: none">9.1.1 General9.1.3 Analysis and evaluation10 Improvement<ul style="list-style-type: none">10.2 Nonconformity and corrective action
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2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Date 10/31/24

Nonconforming Corrective Action Report (CAR) for Jemison
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
n/a	10.0	OFI: the organization should consider transitioning the scorecard reporting to QA personnel with the addition of the quality technician role in Decatur.	X		