

# **Audit Review and Evaluations of JEMISON METALS**

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

Dates of Audit: 11/8/23  
Date of Submittal: 11/16/23

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. Greg was able to elaborate on how he contributes to the quality policy by performing his required quality checks.

Additional employees talked to: Walter Miles (Inside Sales), Whitney Windsor (Maintenance), Cade Tittle (Purchasing/Materials Mgmt)

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: Feralloy requested a toll process request on 11/6/23 (email dated 11/6/23 from Liz Holmes). Walter Miles (Inside Sales for Toll) acknowledged the request the same day and entered sales order GAD-14063 the same day. Work order GAD 178905 was created on 11/6/23.

Purchasing: Tag 914238 on Loading Order GAD129318 for BTB was reviewed with purchasing. Tag 914238 was applied to BTB part number 61H34-375-48x105. This part number had requirements of: 3/8" (.365" min), HSLAS Grade 60 Class 1: Yield 60ksi min, 75ksi min, 16% min elongation.

Tag 914238, came from Master Tag ND79795 (45,940 lbs) and was purchased from Nucor Decatur on PO GAD 24160-001. Actuals: Yield: 81 ksi, Tensile 91.4 ksi, 28.8% elongation. 40,800-48000 lbs on PO, actual was 45,940lbs. PO requirements to the mill

matched the received coil requirements (.375" Thick, 48" Wide, Yield/Tensile/Elongation etc).

#### 8.4 Control of externally provided processes, products and services

Receiving: BOL H577986 was received by Greg Chandler. Mill Coil 4755357 was weighed at 39,380lbs. Receiving Inbound Inspection report GAD009 9/18/2017, Rev 2 was filled out completely. Material was customer owned by Eddie Kane Steel.

#### 8.5-Production & Service Provisions

Production: Work Order 178905, customer Feralloy. Production of 12ga HSLA Grade 50, 60" x 120" sheets. Gauge (.102-.122", .101" Actual, Production stopped and approval received from the customer via sales to continue and documented on the work order). Width (Mill Edge, Actual was 60.562"). Length (-0, +0.5", Actual 120.187"). Tags FE14638-48 were cut from coil 78909 (78909 was the correct coil as shown on "material to be used" on the work order). All checks, other than gauge listed above, were within tolerance and documented on the production report (DEC-BB1-CTL 6/26/17 Rev 4).

Shipping: BTD (Dawsonville GA) Sales Order GAD 140237-1 lines 2-4 was staged on loading order GAD 129318. Material was pre-staged and identified with colored flags (WELL DONE!). Items were visually verified against the loading order and everything matched. Line 4 was 3/8 48"x105 HRPO Grade 60, Tag 914238 (4,824 lbs) and was pre-staged in B3. Line 2 was 1 bundle pre-staged in B8. Line 3 was 5 bundles.

#### 7.1.3 Infrastructure

Preventive Maintenance: Whitney Windsor provided the following PM evidence:

- 3 overhead crane inspections (performed by external organization) were reviewed, new inspections due in December 2023. The 15T crane had no high priority items noted and 1 medium priority item awaiting budgetary approval. The 35T crane had 1 high priority item (main hoist wire rope had excessive broken wires) and was replaced on 12/9/22. The 50T crane had no high priority items reported.
- 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. [Observation #1: PM sheets have old dates. Whitney has been hand adjusting dates to provide record. Should get updated sheets made \(Target Q1 2024\).](#)

#### 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 8/3/24.

Tape Measure serial#: T201 calibration due 2/21/24.

Receiving Scale serial#: 12916, calibration due 11/23/23.

BB1 CTL:

Micrometer serial#: 015 calibration due 4/12/24.

Tape Measure serial#: T217 calibration due 8/28/24.

Step Gauge serial#: ST10 calibration due 8/3/24.

### 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 896069R .1345” x 48x96”, 26 pcs, 4,570 lbs was reviewed. It had the tag remark “Hunter Reject Shape”. Tag was verified as being in DRJ (Decatur Reject Warehouse).

Tag 900635 .4975” x 59.875 x 120”, 3 pcs, 3,041 lbs was reviewed. It had the tag remark “Scale mill claim”. Tag was verified as being in DMC (Decatur Mill Claim Warehouse).

### 10.2 Nonconformity and Corrective Action

CA 25395, Hunter Engineering, verified, Closed during this audit.

CA 25490, Hunter Engineering, verified, Closed during this audit.

CA 25508, Hunter Engineering, verified, still open.

### 10. Improvement

Machine data review and operator scorecard feedback has been implemented.

## 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	Walter Miles-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"><li><b>4 Context of the Organization</b><ul style="list-style-type: none"><li>4.4 Quality Management System and its processes</li></ul></li><li><b>5 Leadership</b><ul style="list-style-type: none"><li>5.1 Leadership and commitment<ul style="list-style-type: none"><li>5.1.2 Customer Focus</li></ul></li><li>5.2 Policy</li><li>5.6 Management review</li></ul></li><li><b>6 Planning</b></li><li><b>7 Support</b><ul style="list-style-type: none"><li>7.1.1 General</li><li>7.2 Competence<ul style="list-style-type: none"><li>7.1.3 Infrastructure</li><li>7.1.4 Environment for the operation of processes</li><li>7.1.5 Monitoring and measuring resources</li></ul></li><li>7.5 Documented information</li></ul></li></ul>	<ul style="list-style-type: none"><li><b>8 Operation</b><ul style="list-style-type: none"><li>8.1 Operational planning and control</li><li>8.2 Requirements for products and services</li><li>8.3 Design and development of products and services (N/A)</li><li>8.4 Control of externally provided processes, products and services</li><li>8.5 Production and service provision</li><li>8.7 Control of nonconforming outputs</li></ul></li><li><b>9 Performance evaluation</b><ul style="list-style-type: none"><li>9.1 Monitoring, measurement, analysis and evaluation<ul style="list-style-type: none"><li>9.1.1 General</li><li>9.1.3 Analysis and evaluation</li></ul></li></ul></li><li><b>10 Improvement</b><ul style="list-style-type: none"><li>10.2 Nonconformity and corrective action</li></ul></li></ul>
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## 2.3 APPROVAL/SIGN-OFF

Report Prepared by Rick Rowland

Date 11/16/23

Nonconforming Corrective Action Report (CAR) for Jemison  
Metals

CAR #	ISO 9001: 2015 Clause / Sub-Clause	Findings/Requirements	Observation	Minor	Major
n/a	7.1.3	Observation #1: PM sheets have old dates. Whitney has been hand adjusting dates to provide record. Should get updated sheets made (Target Q1 2024).	X		





# JEMISON METALS

DATE: 11/8/23

TO: Decatur Internal Audit.  
Page 1

FROM:

Production

Leroy  
Operator

w/o  
GAD  
Created

178905

0-1" Mic 015 due 4/12/24 ✓  
ST10 step gauge due 8/3/24 ✓  
T217 Tape Measure due 8/28/24 ✓

POS 12L HS50-1 60 x 120 ✓ Wave/Bow/Flatness 0.75 max

✓ Gauge .102 - .122 .101" & .101" ✓ 19 sheets / Bundle

✓ Width Mill Edge 60.562" Actual 4x4's with Forkside Unload

✓ Length -0, +0.50" 120.187 Actual ✓ 78909 - Material to be used

✓ Approval From Sales given & documented on work order. ✓ DEC-BBI-CTL 6/26/17 Rev 4

Tags FE 14638-48

Receiving - Greg Chandler

Mill Coil 4755357

✓ Mic: 011 due 8/3/24

Scale 12916 due 11/23 Shows 39,380 lbs

✓ Tape: T201 due 2/21/24

↳ Verified due Nov. 2023  
Birmingham Toledo.

Receiving Inbound Insp. Report GAD009 9/18/2017 Rev. 2 ✓

✓ Customer Owned: Eddie Kane B/L H577986

Nonconforming Area: Clear Separation From FG's

✓ Tag 896069 R .1345 x 48 x 96 26 pcs 4,570 lbs

Remark: "Hunter Reject Shape" Verified Tag is in DRJ

✓ Tag 900635 .4975 x 59.875 x 120 3 pcs 3041 lbs.

Scale Mill Claim 25564 Verified Tag is in Mill claim DMC  
on Claim 25564





# JEMISON METALS

DATE: 11/8/23

TO: DEC Internal Audit

Page 2

FROM:

Open C.A.'s

25395 - Hunter Eng. Bow

25490 - Hunter Eng. uneven Side or End Walls

25508 - Hunter Eng. Residual Stress

Hunter Eng. W/O: GAD 178581 Part 3591/543301 POS 12 CSBTP 48x96

Preventive Maintenance:  
Whitney Windsor

PM organized by time

Weekly, 2wk, 4, 6wk  
10wk, 13wk, 19, 25  
38, 50, 126 wks

OBS #1

PM sheets have old dates, Whitney has been hand adjusting Dates to Provide Record. Should get updated Sheets made.

Weekly Current thro 11-7-23 on schedule

38 week Complete 9-18-23 on schedule

19 week Complete 5-29-23 " "

Last Crane Inspections ~ 12/1/22, New ones in Dec. 2023

15T, 35T, 50T

- ✓ 15T: 1 Med Priority Runway/Support Awaiting Budget Approval No High Priority
- ✓ 35T: 1 High Priority: Main Hoist wire Rope - Excessive Broken Wires (Replaced 12-9-22)
- ✓ 50T: No High Priority

Forklift Inspections Internal + External (Wheeler with Handling, Madison AL)





# JEMISON METALS

DATE: 11/8/23

TO: DEC Internal Audit  
page 3

FROM:

Shipping Blake key

L/O GAD129318 BTD Dawsonville GA.

Customer PO 665531-6

Line 1 <sup>4</sup> Bundles 45,670 lbs. 140237-1 S/O

3/8" 48" x 105" P & O Gr. 60.

914 238 9 pcs. 9 pcs 4,824 lbs.

Delivery hrs. M-F 24/7

Pre-staged in B3

Line 2 1 Bundle in B8

Line 3 5 Bundles

Sales Sales Order GAD-1406<sup>63</sup> applies to

Feralloy work order GAD 178905 observed during production.

Acknowledgement to customer via email 11/6/23,  
which is the same day the order was sent to Jemison  
and the same day the S/O was entered.

Walter Miles acknowledged to Liz Holmes (Customer)

Purchasing Cade Tittle

Tag 914 238 on Loading order GAD129318

914238, POS 375 HSGO 48x105 Yield str. 81.0 ksi Tensile: 91.4 ksi

Master Tag ND79795 from Nucor Decatur Elong: 28.8%

purchased on PO# GAD 24160-001

Customer Part: 61H34-375-48x105

PO Language: ASTM A1018 HSLAS Gr 60  
Class 1

✓ 40,800 - 48000 lbs.

3800 Colonnade Parkway • Suite 250 • Birmingham, AL 35243

Phone: 205-986-6600 Fax Administrative: 205-986-6601 Sales: 205-986-6604 Purchasing: 205-986-6606