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R1164

GE Nuclear Energy

GERIS 2000 Examination Summary Sheet

Project: TVA, Browns Ferry Nuclear Plant, Unit 3
System: Reactor Pressure Vessel
Weld ID: V-3-B **ASME Code Category:** B-A
Calibration Sheets: C-004, C-115, C-116 and C-117
Supporting Data: Examination Data Sheets E-10-00 thru E-10-04, Indication Data Sheets 10-001 thru 10-006, Indication Evaluation Data Sheets, Screen Prints, Exam Patch Location Map, Exam Coverage Plots, GERIS 2000 Setup Records and Manual Examination Data Sheets D-032, D-033, D-039 and D-043.

Examination Summary

The ultrasonic examination of weld V-3-B resulted in no recorded indications that exceed the allowable standards of IWB-3500, ASME Section XI, 1986 Edition, No Addenda.

The ASME Section XI required examination volume was examined with the GERIS 2000 System from the RPV inside surface utilizing Procedure No. GE-UT-700, Rev. 2. This examination was limited due to the feedwater sparger, core spray downcomer and N11-B Nozzle at 220°. Areas that could not be examined using the GERIS 2000 and accessible from the outside surface were examined by the manual technique utilizing Procedure No. GE-UT-300, Rev. 6, FRR-004. The total examination coverage was calculated to be 99%.

The GERIS 2000 utilizes an array of search units arranged to effectively examine the weld and adjacent base material parallel and perpendicular to the weld axis in two directions. The transducer package consisted of 0° longitudinal, 45° and 60° shear wave, and 70° refracted longitudinal (RL) wave search units.

The GERIS 2000 recorded indications with the 70°RL scans and the 45° and 60° shear wave scans that were evaluated and found to be acceptable per the referencing Code section.

The manual technique utilized 0° longitudinal, 45° and 60° shear wave search units both parallel and perpendicular to the weld axis in two directions to effectively examine the weld and adjacent base material.

No indications were recorded with the manual technique.

Fabrication records and previous examination results were reviewed prior to the completion of this examination summary.

GERIS Analyst: [signature] LEVEL: III DATE: 12/15/93	GE Reviewer: Teresa Kimball LEVEL: III DATE: 12-15-93
UTILITY Review: [signature] TITLE: II DATE: 1/26/94	ANII Review: TITLE: Albert Todd DATE: 7/13/94

00090

R1164

GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Exam Data Sheet: E-10-00

Procedure No.: GE-UT-700
Revision No.: 2
FRR No.: N/A

Patch	Data Sh.	Date	Start	Stop	Min X	Max X	Min Y	Max Y	Disk No.	Examiner
BF-054	E-10-02	10/15/93	1048	1059	494.50	511.00	151.25	525.75	51A	ROF
BF-055	E-10-03	10/15/93	1025	1040	483.25	511.00	526.00	535.50	51A	ROF
BF-056R	E-10-04	10/21/93	1019	1132	483.25	511.00	424.00	469.50	67B	ROF
BF-057	E-10-01	10/27/93	0449	0611	478.25	516.00	383.75	426.00	103B	JCG
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Comments: N/A

Limitations: Examination limited due to Feedwater Sparger, Core Spray Downcomer and Nozzle N11-B @ 220°.

Analyst: [signature]
Level: III Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

R1164

GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-01
Patch ID: BF-057
Ind. Data Sheet Series: 10-XXX

Channel	Angle	Direction	Ind.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sheet
1	0 WM	N/A	NRI	~	~	~	~	~
2	0 WM	N/A	NRI	~	~	~	~	~
3	70 RL	0 UP	1	10-001	~	~	~	~
4	70 RL	90 CW	NRI	~	~	~	~	~
5	70 RL	180 DN	NRI	~	~	~	~	~
6	70 RL	270 CCW	NRI	~	~	~	~	~
7	45 RS	0 UP	NRI	~	~	~	~	~
8	45 RS	90 CW	NRI	~	~	~	~	~
9	45 RS	180 DN	NRI	~	~	~	~	~
10	45 RS	270 CCW	NRI	~	~	~	~	~
11	60 RS	0 UP	NRI	~	~	~	~	~
12	60 RS	90 CW	NRI	~	~	~	~	~
13	60 RS	180 DN	NRI	~	~	~	~	~
14	60 RS	270 CCW	NRI	~	~	~	~	~
15	0 BM	N/A	NRI	~	~	~	~	~
16	0 BM	N/A	NRI	~	~	~	~	~
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Comments: N/A

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number
Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: [signature]
Level: II Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

R1164

GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-02
Patch ID: BF-054
Ind. Data Sheet Series: 10-XXX

Channel	Angle	Direction	Ind.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sheet
1	0 WM	N/A	NRI	~	~	~	~	~
2	0 WM	N/A	NRI	~	~	~	~	~
3	70 RL	0 UP	NRI	~	~	~	~	~
4	70 RL	90 CW	NRI	~	~	~	~	~
5	70 RL	180 DN	NRI	~	~	~	~	~
6	70 RL	270 CCW	NRI	~	~	~	~	~
7	45 RS	0 UP	NRI	~	~	~	~	~
8	45 RS	90 CW	NRI	~	~	~	~	~
9	45 RS	180 DN	NRI	~	~	~	~	~
10	45 RS	270 CCW	NRI	~	~	~	~	~
11	60 RS	0 UP	1	10-002	~	~	~	~
12	60 RS	90 CW	NRI	~	~	~	~	~
13	60 RS	180 DN	NRI	~	~	~	~	~
14	60 RS	270 CCW	NRI	~	~	~	~	~
15	0 BM	N/A	NRI	~	~	~	~	~
16	0 BM	N/A	NRI	~	~	~	~	~
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Comments: N/A

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number
Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: [signature]
Level: III
Date: 12/12/93

Reviewed By: [signature]
Level: II
Date: 12/13/93

GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-03
Patch ID: BF-055
Ind. Data Sheet Series: 10-XXX

Channel	Angle	Direction	Ind.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sheet
1	0 WM	N/A	NO EXAM	~	~	~	~	~
2	0 WM	N/A	NRI	~	~	~	~	~
3	70 RL	0 UP	NRI	~	~	~	~	~
4	70 RL	90 CW	NRI	~	~	~	~	~
5	70 RL	180 DN	NRI	~	~	~	~	~
6	70 RL	270 CCW	NO EXAM	~	~	~	~	~
7	45 RS	0 UP	1	10-003	~	~	~	~
8	45 RS	90 CW	NRI	~	~	~	~	~
9	45 RS	180 DN	1	10-004	~	~	~	~
10	45 RS	270 CCW	NRI	~	~	~	~	~
11	60 RS	0 UP	NRI	~	~	~	~	~
12	60 RS	90 CW	NRI	~	~	~	~	~
13	60 RS	180 DN	1, 2	10-005	10-006	~	~	~
14	60 RS	270 CCW	NRI	~	~	~	~	~
15	0 BM	N/A	NRI	~	~	~	~	~
16	0 BM	N/A	NRI	~	~	~	~	~
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Comments: No exam channels 1 and 6 due to scan limitations.

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number
Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: [signature]
Level: III
Date: 12/12/93

Reviewed By: [signature]
Level: II
Date: 12/13/93

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GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-04
Patch ID: BF-056R
Ind. Data Sheet Series: 10-XXX

Channel	Angle	Direction	Ind.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sh.	Ind. Data Sheet
1	0 WM	N/A	NRI	~	~	~	~	~
2	0 WM	N/A	NRI	~	~	~	~	~
3	70 RL	0 UP	NRI	~	~	~	~	~
4	70 RL	90 CW	NRI	~	~	~	~	~
5	70 RL	180 DN	NRI	~	~	~	~	~
6	70 RL	270 CCW	NRI	~	~	~	~	~
7	45 RS	0 UP	NRI	~	~	~	~	~
8	45 RS	90 CW	NRI	~	~	~	~	~
9	45 RS	180 DN	NRI	~	~	~	~	~
10	45 RS	270 CCW	NRI	~	~	~	~	~
11	60 RS	0 UP	NRI	~	~	~	~	~
12	60 RS	90 CW	NRI	~	~	~	~	~
13	60 RS	180 DN	NRI	~	~	~	~	~
14	60 RS	270 CCW	NRI	~	~	~	~	~
15	0 BM	N/A	NRI	~	~	~	~	~
16	0 BM	N/A	NRI	~	~	~	~	~
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Comments: N/A

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number
Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: [signature]
Level: II Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-01
Patch ID: BF-057
Ind. Data Sheet No.: 10-001

Indication: 10-001 **Channel:** 3 **Angle:** 70 **Direction:** 0

Amp.	X	20% Min Y	TOF	50% Min Y	TOF	@ Max Y	TOF	50% Max Y	TOF	20% Max Y	TOF	Remarks
25.2%	499.50	~	~	~	~	389.70	26.48	~	~	~	~	~
19.6%	499.75	~	~	~	~	389.70	26.40	~	~	~	~	~
16.3%	500.00	~	~	~	~	389.45	28.48	~	~	~	~	~
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Comments: No apparent tip signals.
Indication has no determinable thruwall dimension and is acceptable to IWB-3510-1.

Analyst: [signature] Level: III Date: 12/12/93

Reviewed By: [signature] Level: II Date: 12/13/93

R1164

GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-02
Patch ID: BF-054
Ind. Data Sheet No.: 10-002

Indication: 10-002 **Channel:** 11 **Angle:** 60 **Direction:** 0

Amp.	X	20% Min Y	MP	50% Min Y	MP	@ Max Y	MP	50% Max Y	MP	20% Max Y	MP	Remarks
211.8%	502.35	516.55	9.78	517.55	9.22	520.55	6.39	End of scan line		~	~	SPOT
225.7%	502.60	516.80	9.63	517.55	9.26	520.55	6.39	~	~	~	~	~
136.8%	502.85	517.05	9.40	517.55	9.22	520.55	6.43	~	~	~	~	~
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Comments: Thruwall size was determined by the SPOT technique.

TW =.32 L = .5 S = 3.035 w/clad

Analyst: [signature]
Level: III Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

GE Nuclear Energy

GERIS 2000 Indication Evaluation Sheet

Project: TVA, Browns Ferry Unit 3
Weld ID: V-3-B
Patch: BF-054

Exam Data Sheet No.: E-10-02
Ind. Data Sheet No.: 10-002
Indication: 10-002

Flaw Thruwall Dimension =	0.32
Flaw Length "l" =	0.50
Separation with clad "S" =	3.03
Surface Separation "S" =	2.84

T nominal =	6.38
Clad T nominal =	0.19

Flaw is acceptable by Table IWB-3510-1

ASME Section XI, 1986 Edition
TABLE IWB-3510-1 for 4" to 12"

a/l	Surface %	Subsurface %	Surface %	Subsurface %
0.00	1.90	2	~	~
0.05	2.00	2.2	~	~
0.10	2.20	2.5	~	~
0.15	2.50	2.9	~	~
0.20	2.80	3.3	~	~
0.25	3.30	3.8	~	~
0.30	3.80	4.4	4.04	4.68 Y
0.35	4.40	5.1	~	~
0.40	5.00	5.8	~	~
0.45	5.10	6.7	~	~
0.50	5.20	7.6	~	~
			Allowed	Allowed
			4.04	4.68

a =	0.160
a/l value =	0.320
Y =	1.000

Flaw is Subsurface

Allowed a/t =	4.68%
a/t =	2.51%

Comments:

GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-03
Patch ID: BF-055
Ind. Data Sheet No.: 10-003

Indication: 10-003 **Channel:** 7 **Angle:** 45 **Direction:** 0

Amp.	X	20% Min Y	MP	50% Min Y	MP	@ Max Y	MP	50% Max Y	MP	20% Max Y	MP	Remarks
32.4%	501.71	~	~	~	~	522.55	7.74	~	~	~	~	~
32.4%	501.96	~	~	~	~	522.55	4.72	~	~	~	~	~
41.6%	502.21	~	~	~	~	522.55	4.72	~	~	~	~	SPOT
44.3%	502.49	~	~	~	~	522.80	4.56	~	~	~	~	~
53.5%	502.71	~	~	~	~	522.80	4.56	~	~	~	~	~
28.6%	502.96	~	~	~	~	522.80	4.58	~	~	~	~	~
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Comments: Thruwall size was determined by the SPOT technique.

TW = .198 L = 1.25 S = 3.125 w/clad

Analyst: [signature] Level: II Date: 12/12/93

Reviewed By: [signature] Level: II Date: 12/13/93

R1164

GE Nuclear Energy

GERIS 2000 Indication Evaluation Sheet

Project: TVA, Browns Ferry Unit 3
Weld ID: V-3-B
Patch: BF-055

Exam Data Sheet No.: E-10-03
Ind. Data Sheet No.: 10-003
Indication: 10-003

Flaw Thruwall Dimension = 0.20
Flaw Length "l" = 1.25
Separation with clad "S" = 3.12
Surface Separation "S" = 2.93

T nominal = 6.38
Clad T nominal = 0.19

Flaw is acceptable by Table IWB-3510-1

ASME Section XI, 1986 Edition
TABLE IWB-3510-1 for 4" to 12"

a/l	Surface %	Subsurface %	Surface %	Subsurface %
0.00	1.90	2	~	~
0.05	2.00	2.2	2.12	2.38 Y
0.10	2.20	2.5	~	~
0.15	2.50	2.9	~	~
0.20	2.80	3.3	~	~
0.25	3.30	3.8	~	~
0.30	3.80	4.4	~	~
0.35	4.40	5.1	~	~
0.40	5.00	5.8	~	~
0.45	5.10	6.7	~	~
0.50	5.20	7.6	~	~
			Allowed	Allowed
			2.12	2.38

a = 0.099
a/l value = 0.079
Y = 1.000

Flaw is Subsurface

Allowed a/t = 2.38%
a/t = 1.55%

Comments:

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GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-03
Patch ID: BF-055
Ind. Data Sheet No.: 10-004

Indication: 10-004 **Channel:** 9 **Angle:** 45 **Direction:** 180

Amp.	X	20% Min Y	MP	50% Min Y	MP	@ Max Y	MP	50% Max Y	MP	20% Max Y	MP	Remarks
39.1%	501.65	~	~	~	~	529.25	4.93	~	~	~	~	~
39.1%	501.90	~	~	~	~	529.25	4.93	~	~	~	~	~
34.5%	502.15	~	~	~	~	529.25	4.93	~	~	~	~	~
18.5%	502.40	~	~	~	~	529.25	5.01	~	~	~	~	~
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Comments: No apparent tip signals.
Recorded @ less than ASME required DAC level for reference only.

Analyst: [signature]
Level: III Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

R1164

GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-03
Patch ID: BF-055
Ind. Data Sheet No.: 10-005

Indication: 10-005 **Channel:** 13 **Angle:** 60 **Direction:** 180

Amp.	X	20% Min Y	MP	50% Min Y	MP	@ Max Y	MP	50% Max Y	MP	20% Max Y	MP	Remarks
52.8%	502.54	~	~	~	~	531.20	6.68	~	~	~	~	~
~	~	~	~	~	~	~	~	~	~	~	~	~
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Comments: No apparent tip signals.
Indication has no determinable thruwall dimension and is acceptable to IWB-3510-1.

Analyst: [signature]
Level: III Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

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GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-3-B
Cal. ID: C-004

Exam Data Sheet No.: E-10-03
Patch ID: BF-055
Ind. Data Sheet No.: 10-006

Indication: 10-006 **Channel:** 13 **Angle:** 60 **Direction:** 180

Amp.	X	20% Min Y	MP	50% Min Y	MP	@ Max Y	MP	50% Max Y	MP	20% Max Y	MP	Remarks
47.2%	501.79	~	~	~	~	533.95	11.21	~	~	~	~	-4.89 N
73.1%	502.04	~	~	533.70	10.88	534.20	11.32	524.45	11.54	~	~	-1.09 N
88.2%	502.29	~	~	533.45	10.76	534.20	11.32	534.45	11.54	~	~	+0.54 N
128.4%	502.54	~	~	533.95	11.14	534.20	11.32	534.45	11.50	~	~	-0.54 N
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Comments: No apparent tip signals.
OD surface, evaluated to notch sensitivity.
.54dB above notch response.

TW = 0.127 L = 0.75 S = 0

Analyst: [signature]
Level: III Date: 12/12/93

Reviewed By: [signature]
Level: II Date: 12/13/93

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GE Nuclear Energy

GERIS 2000 Indication Evaluation Sheet

Project: TVA, Browns Ferry Unit 3
Weld ID: V-3-B
Patch: BF-055

Exam Data Sheet No.: E-10-03
Ind. Data Sheet No.: 10-006
Indication: 10-006

Flaw Thruwall Dimension =	0.127
Flaw Length "l" =	0.75
Separation with clad "S" =	N/A
Surface Separation "S" =	0.00

T nominal =	6.38
Clad T nominal =	0.19

Flaw is acceptable by Table IWB-3510-1

ASME Section XI, 1986 Edition
TABLE IWB-3510-1 for 4" to 12"

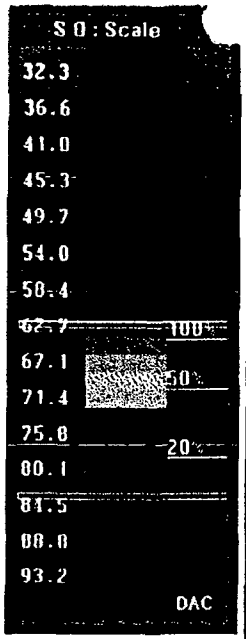
a/l	Surface %	Subsurface %	Surface %	Subsurface %
0.00	1.90	2	~	~
0.05	2.00	2.2	~	~
0.10	2.20	2.5	~	~
0.15	2.50	2.9	2.62	3.05 Y
0.20	2.80	3.3	~	~
0.25	3.30	3.8	~	~
0.30	3.80	4.4	~	~
0.35	4.40	5.1	~	~
0.40	5.00	5.8	~	~
0.45	5.10	6.7	~	~
0.50	5.20	7.6	~	~
			Allowed	Allowed
			2.62	0.00

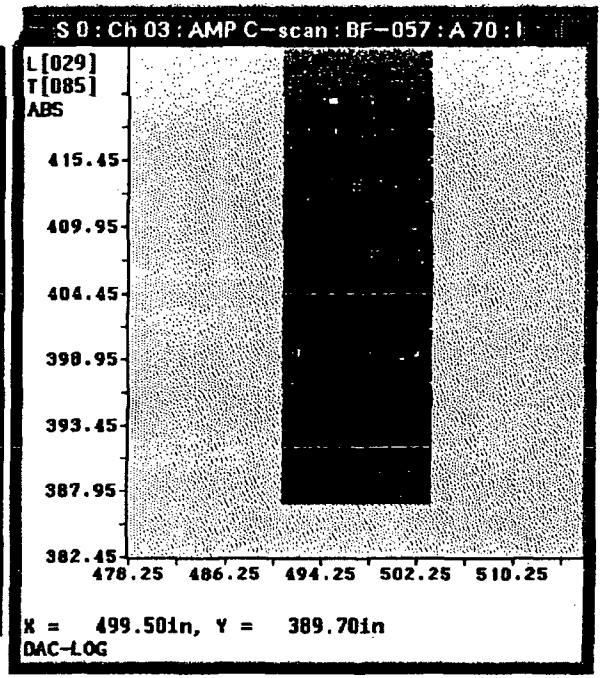
a =	0.127
a/l value =	0.169
Y =	0.000

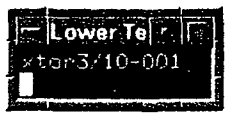
Flaw is Surface

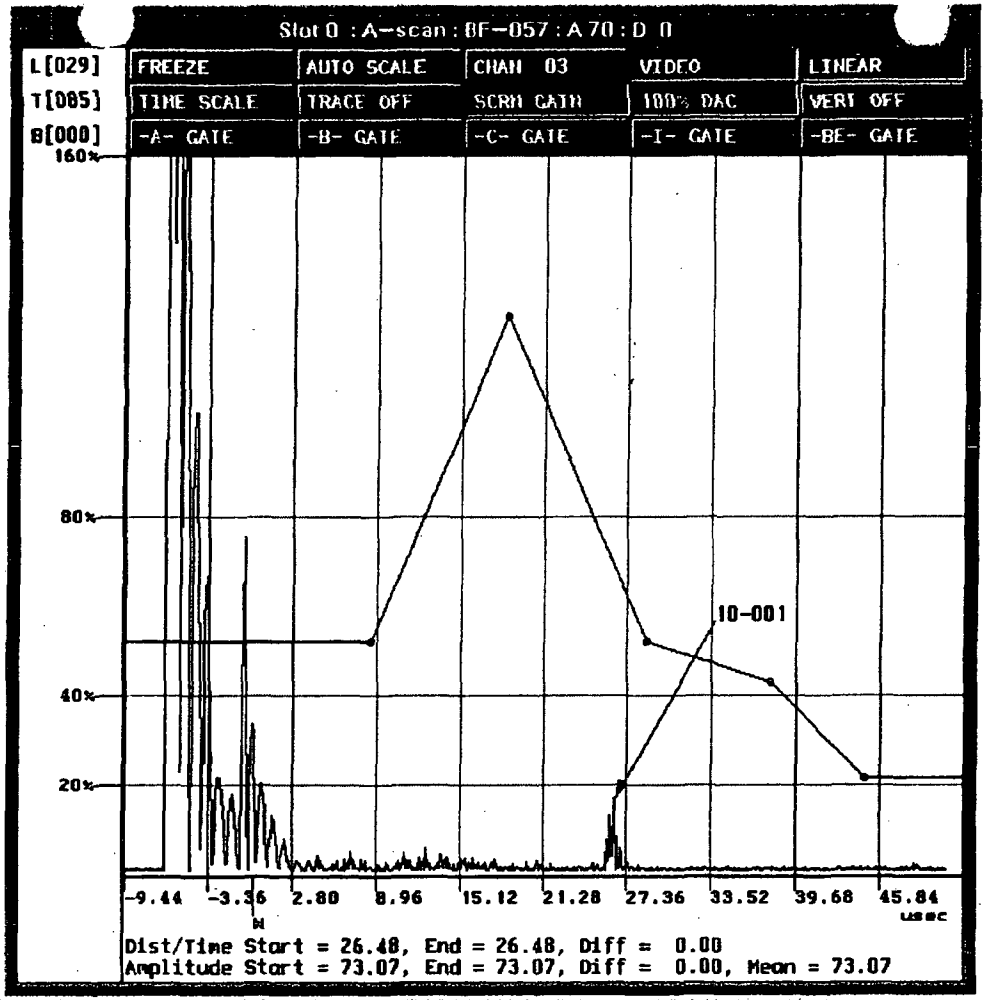
Allowed a/t =	2.62%
a/t =	1.99%

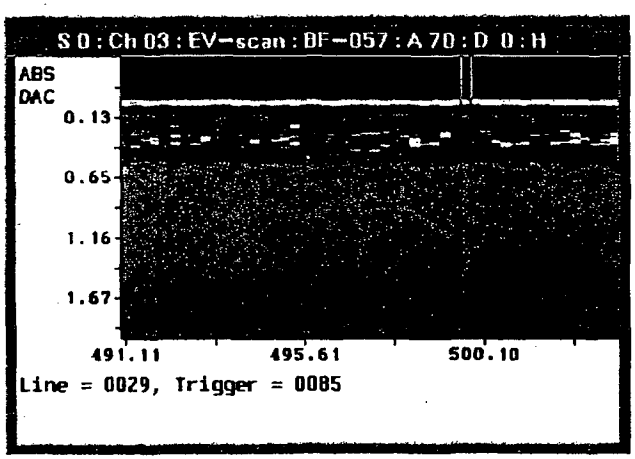
Comments: Evaluated to notch response, assigned thruwall dimension = 2% T.

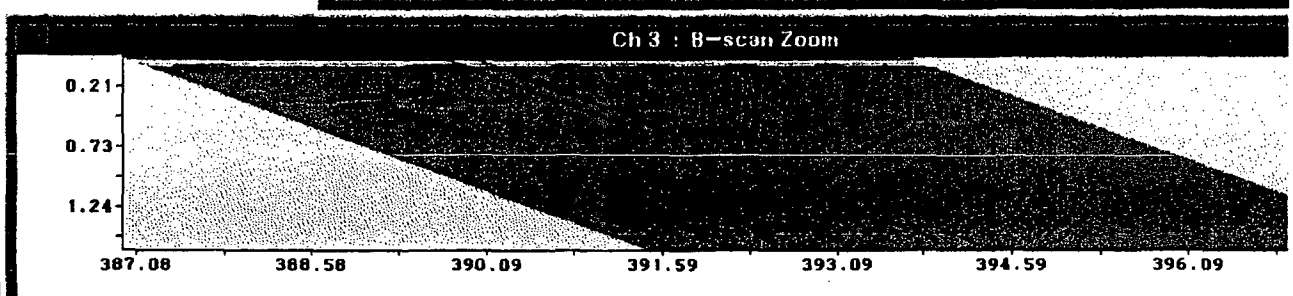


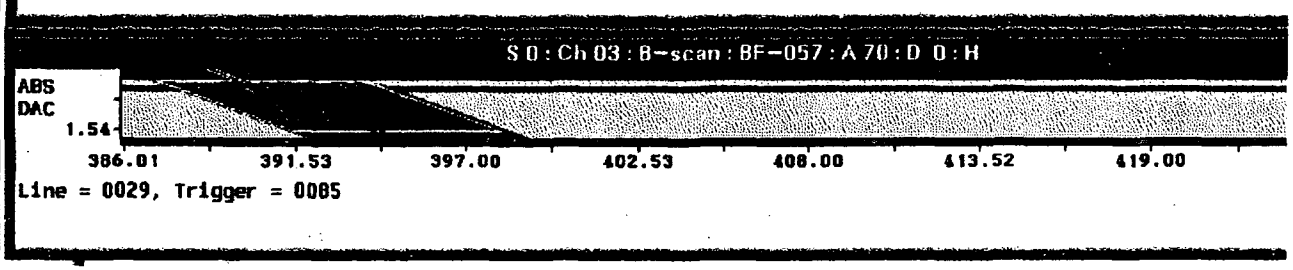


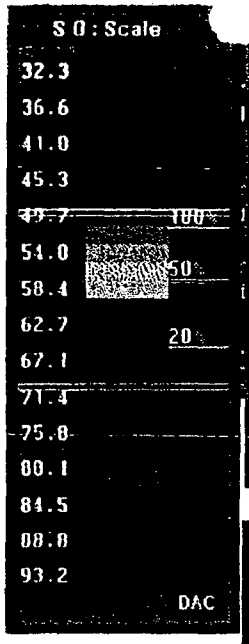


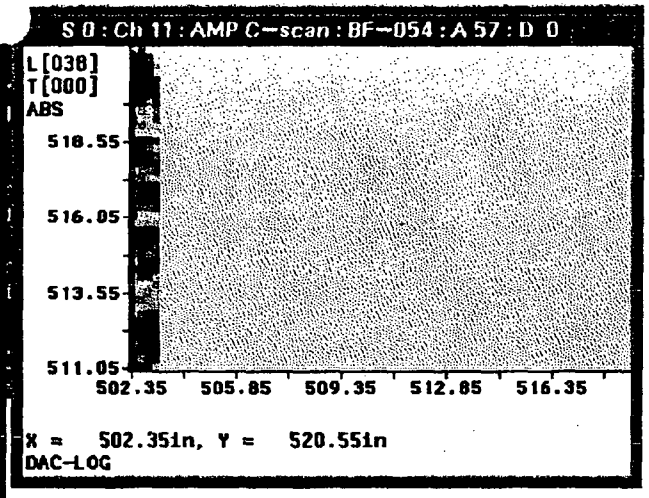


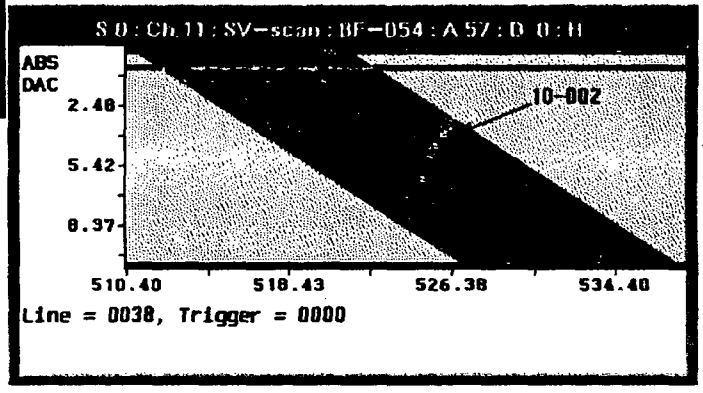


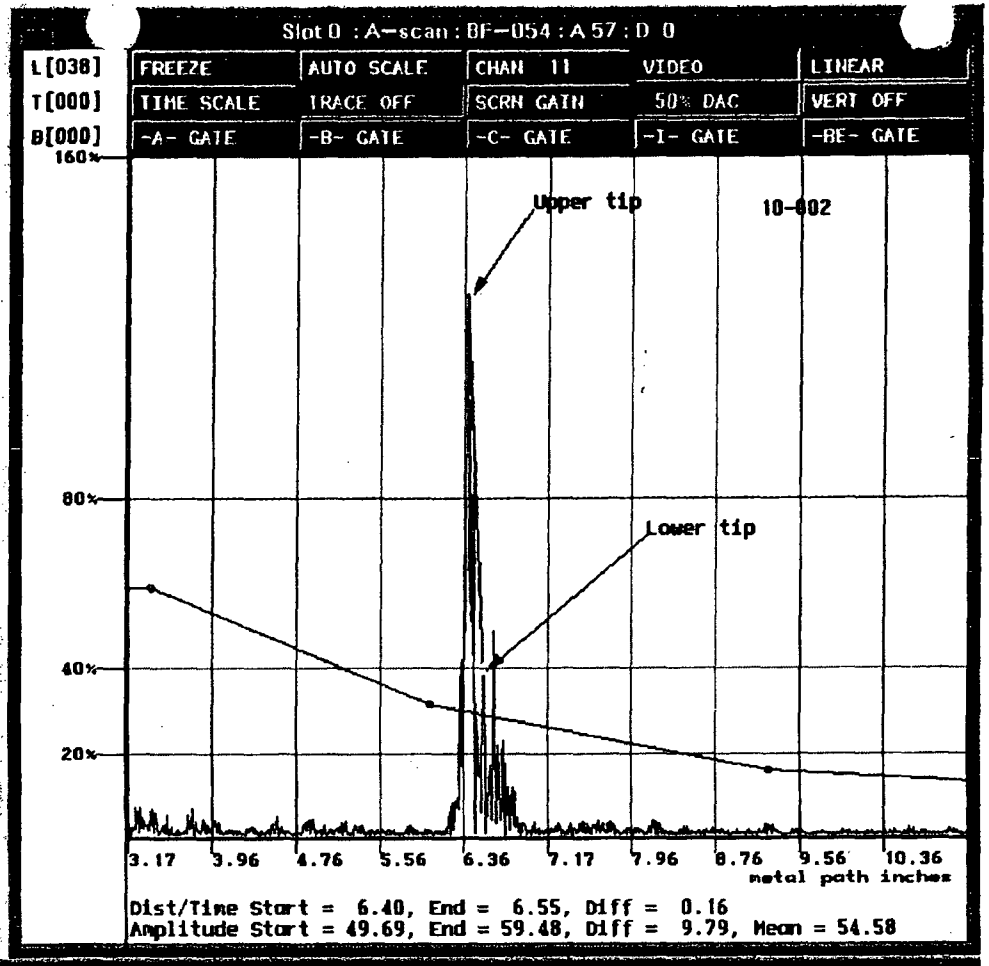


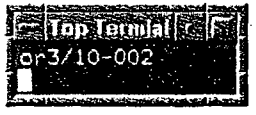


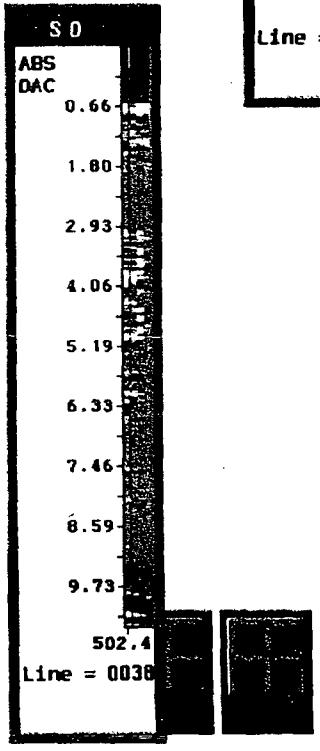


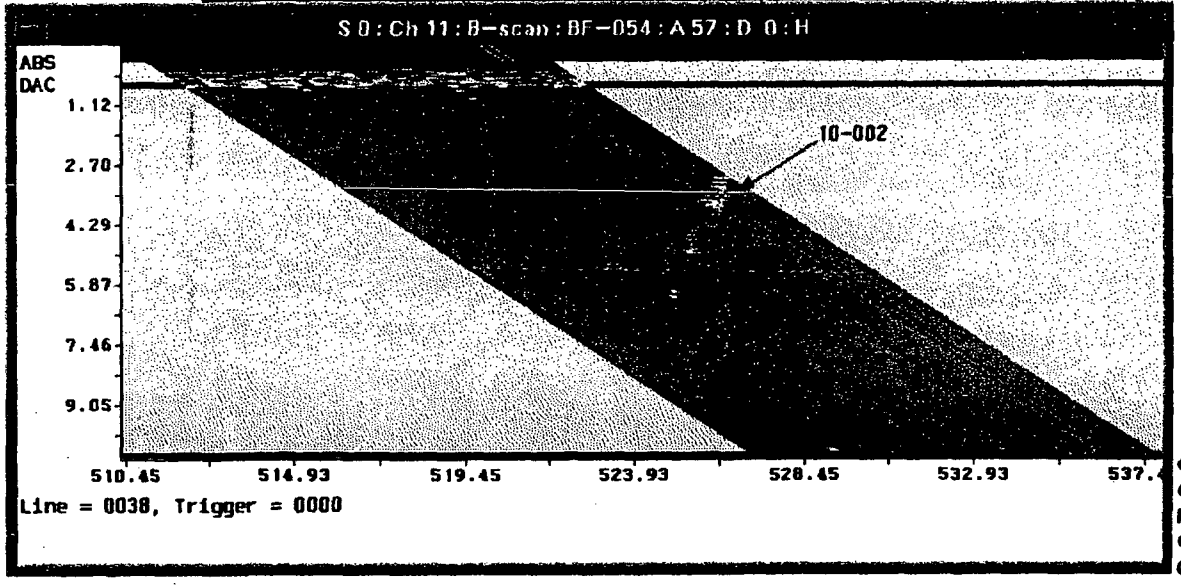


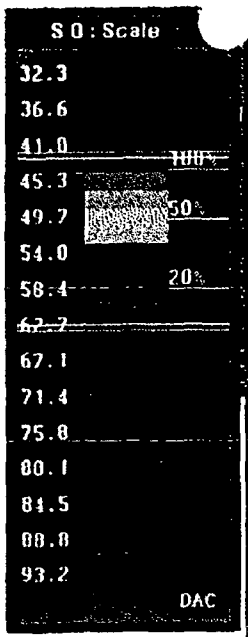


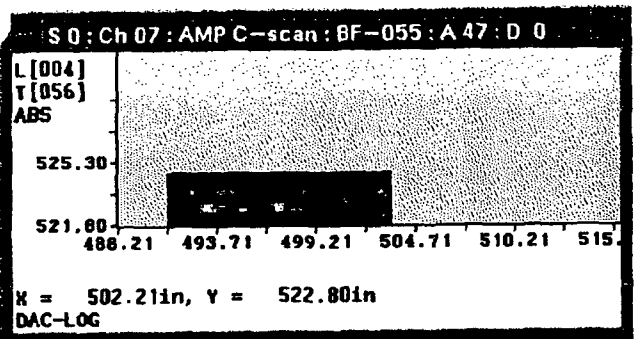


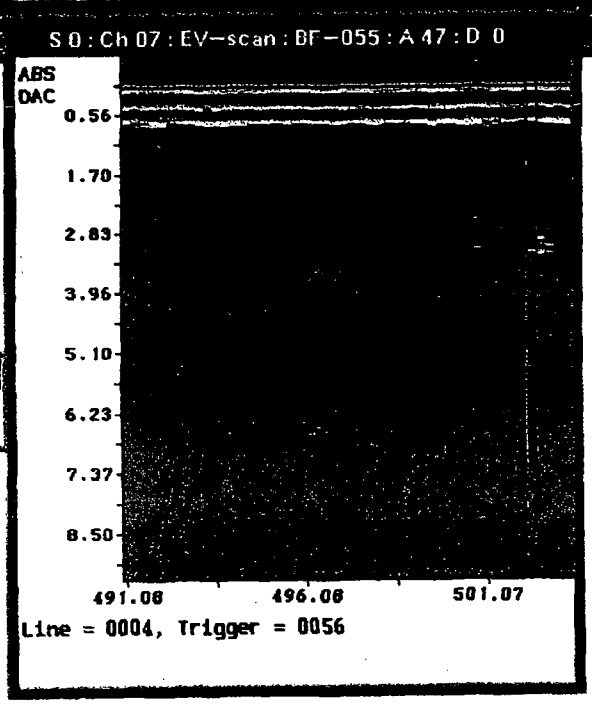


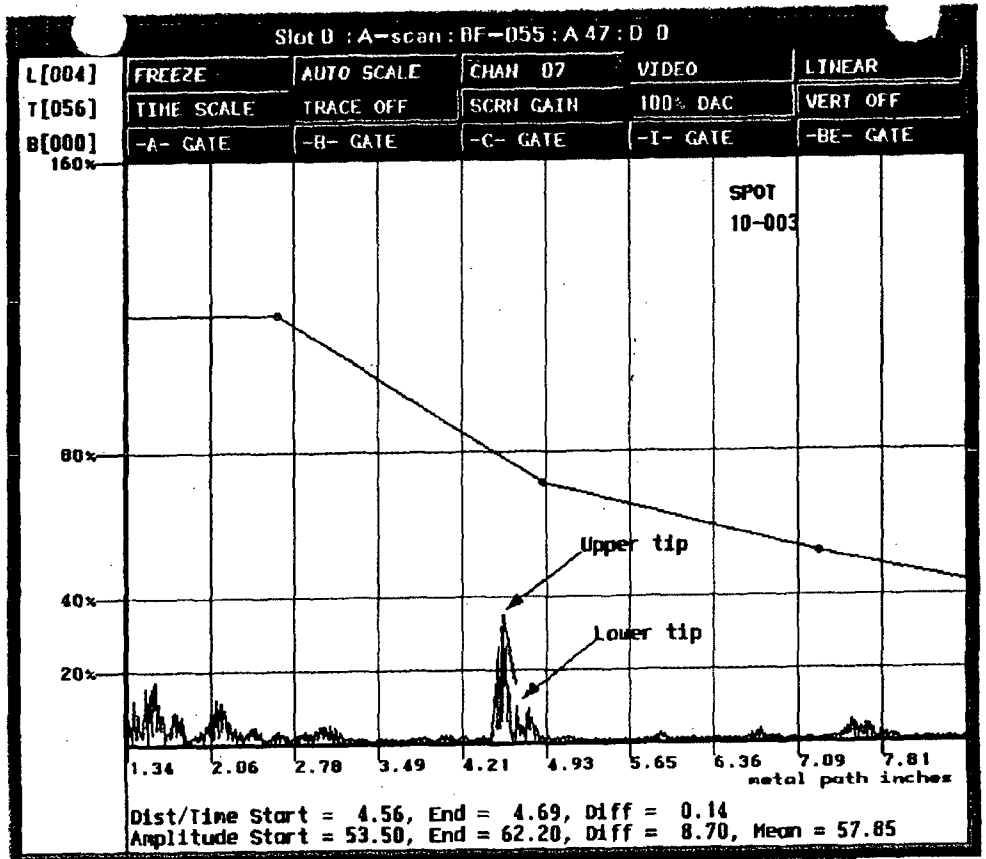


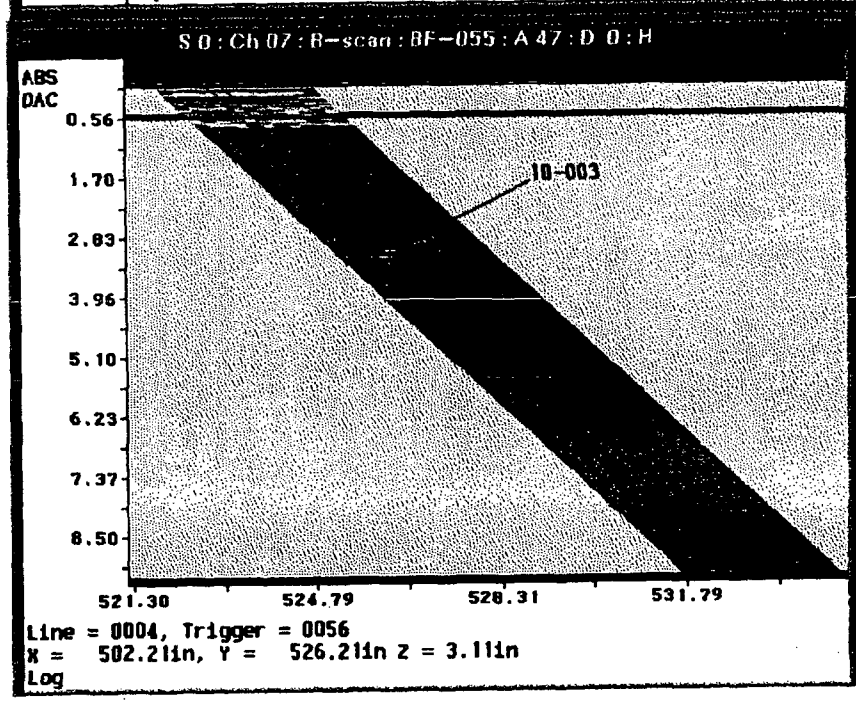


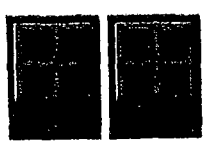












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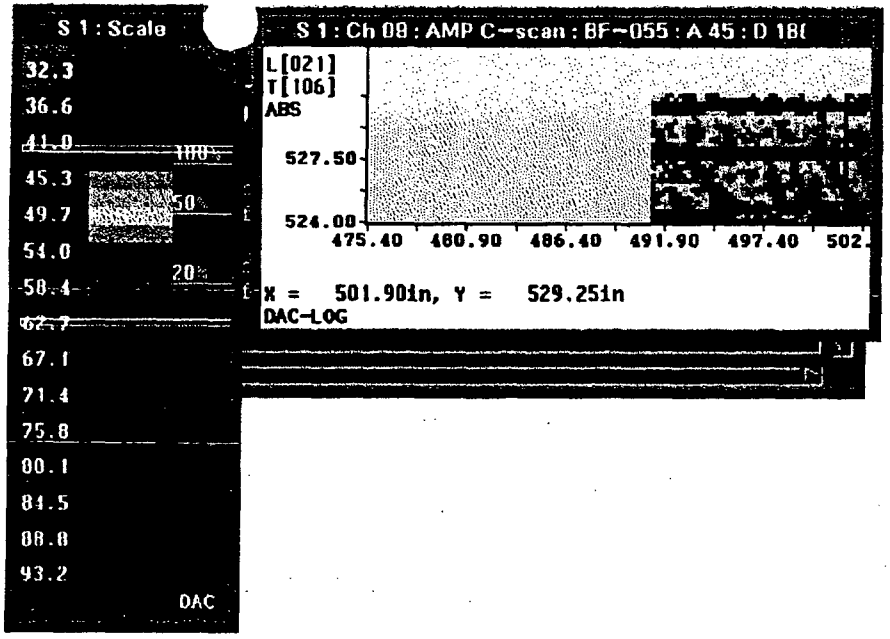

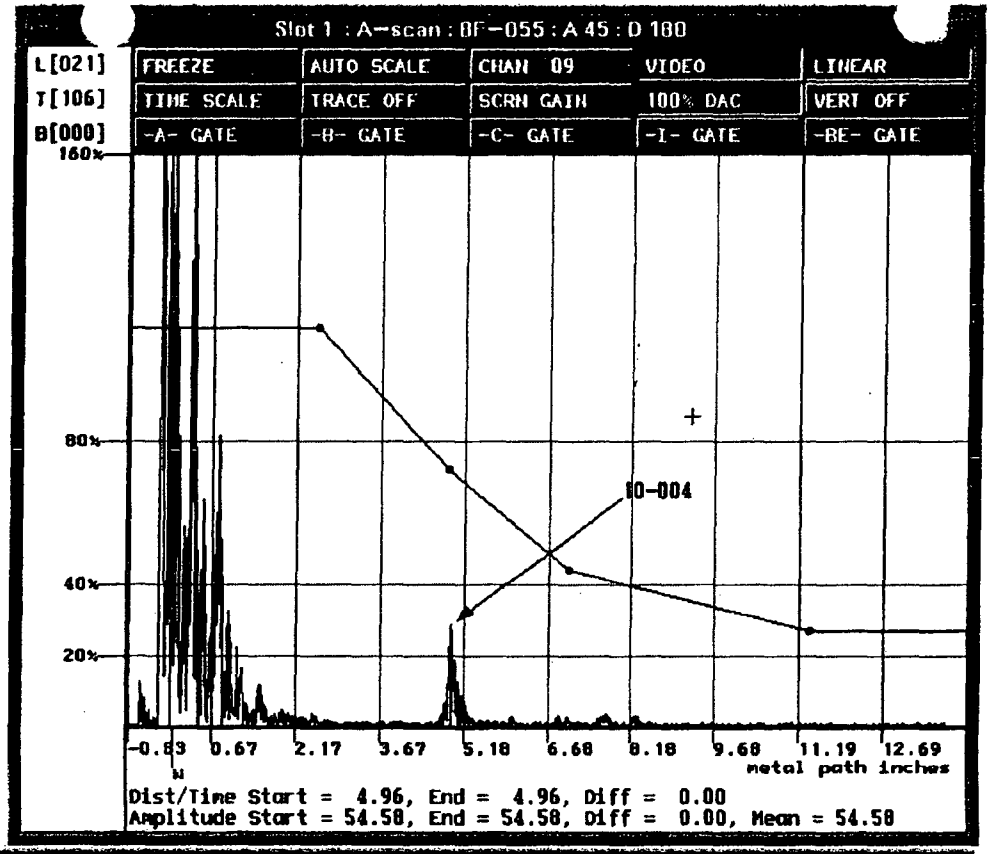

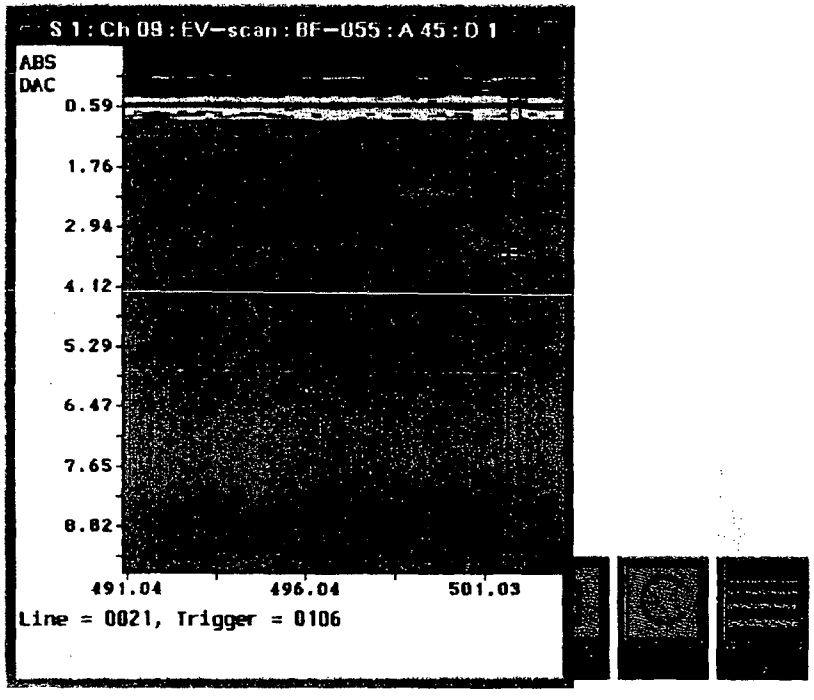

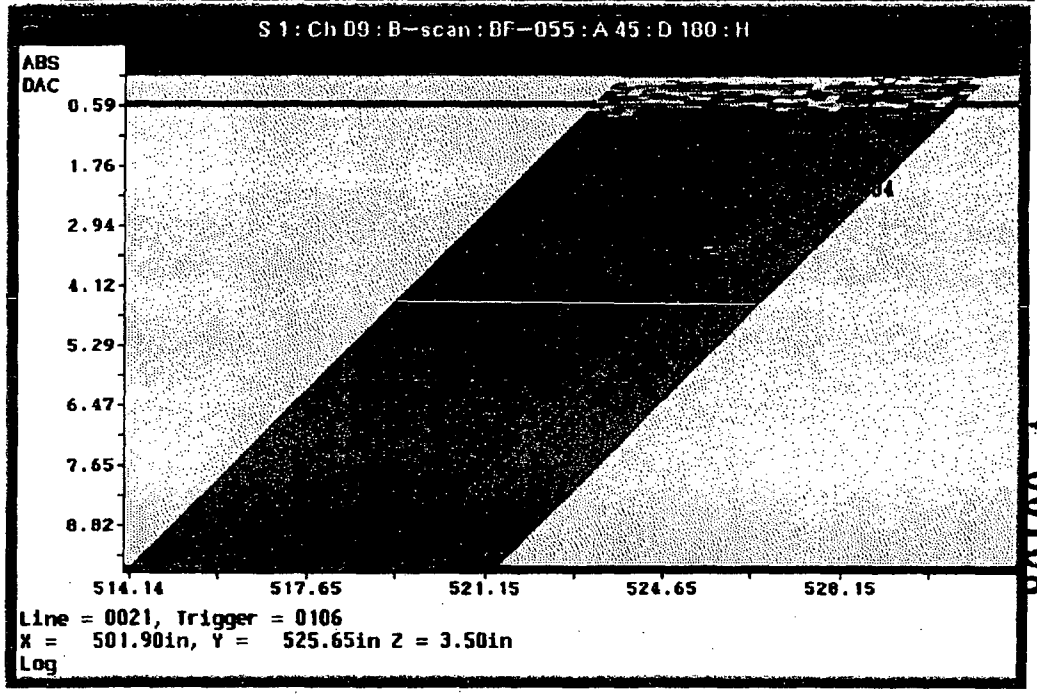

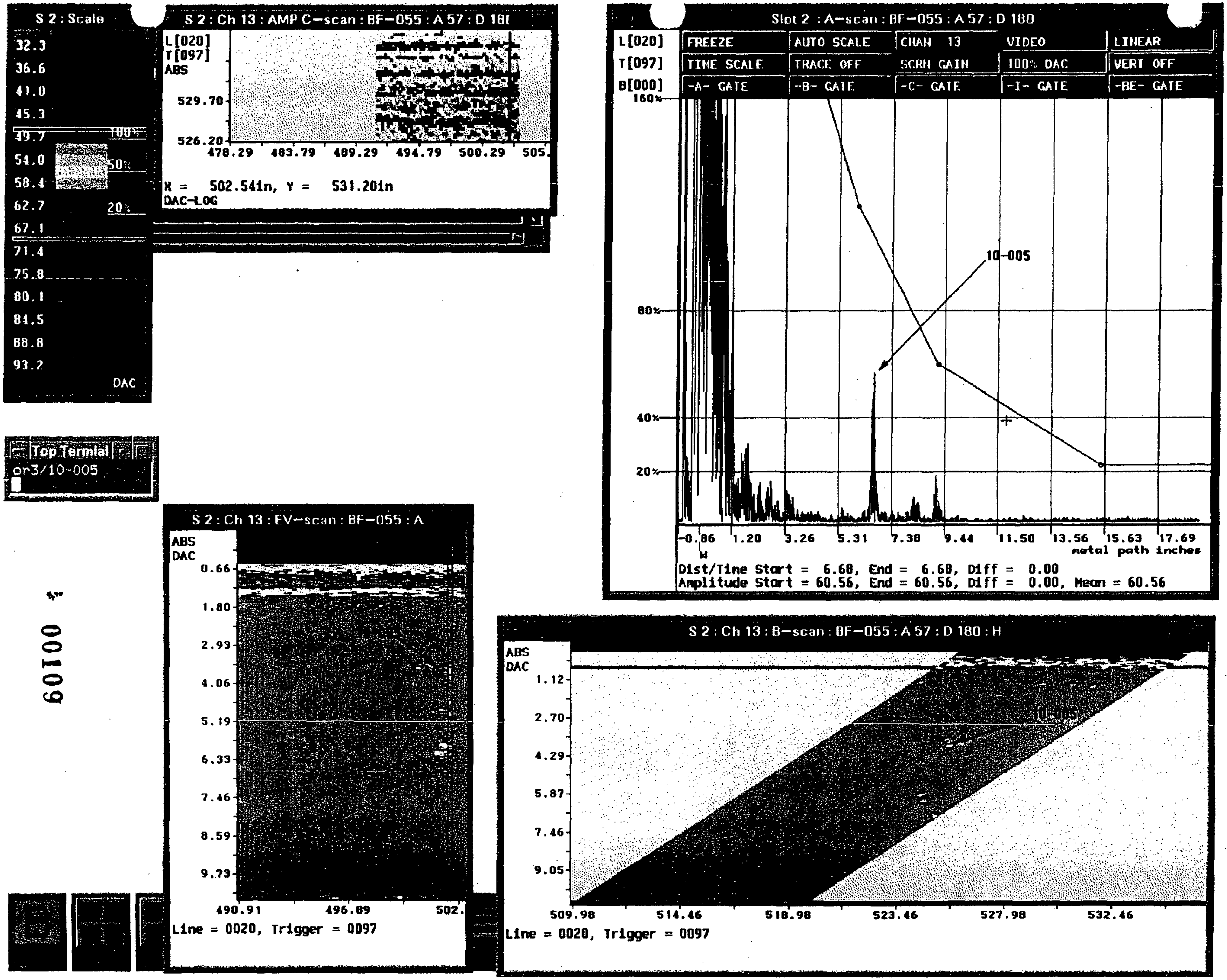

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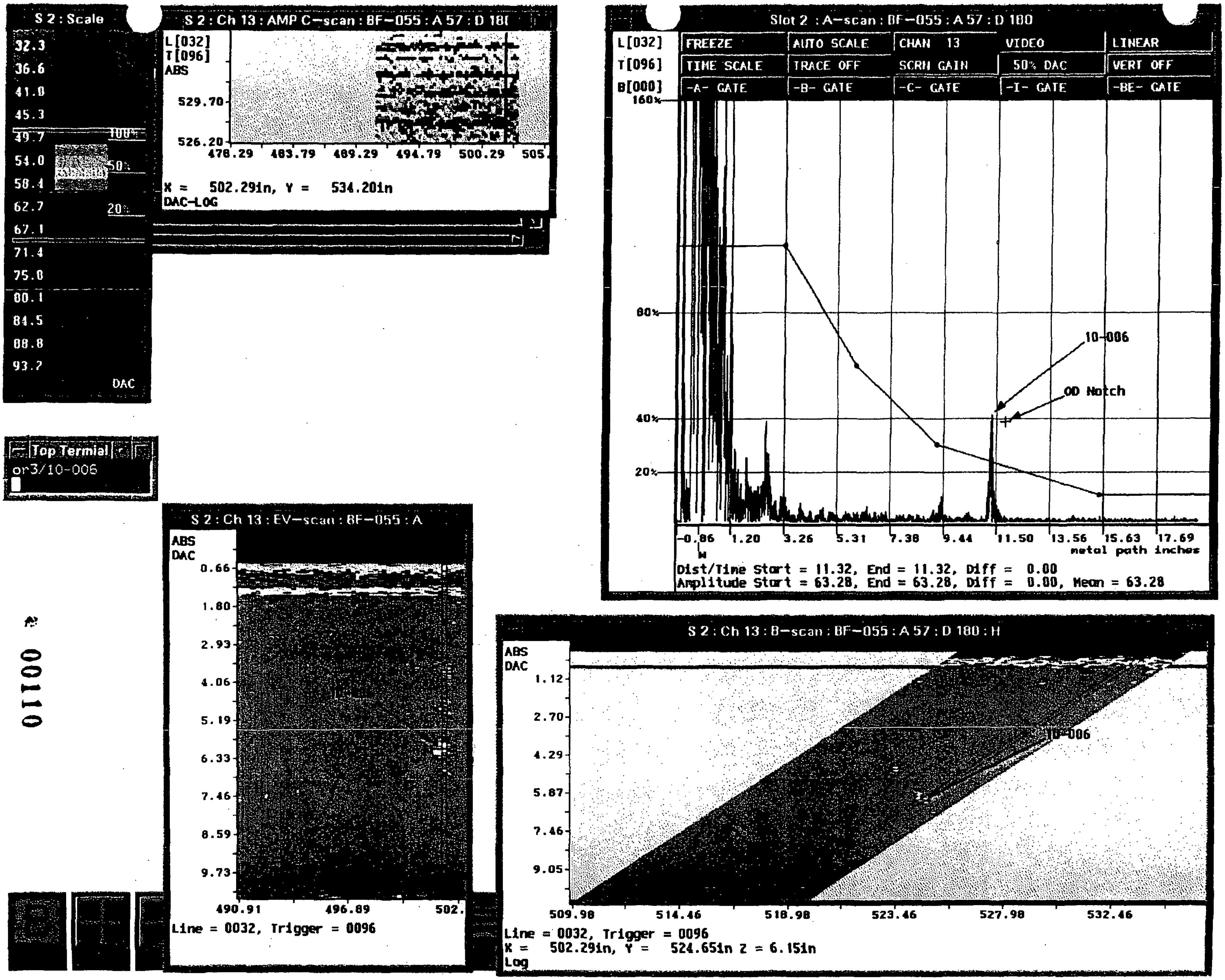

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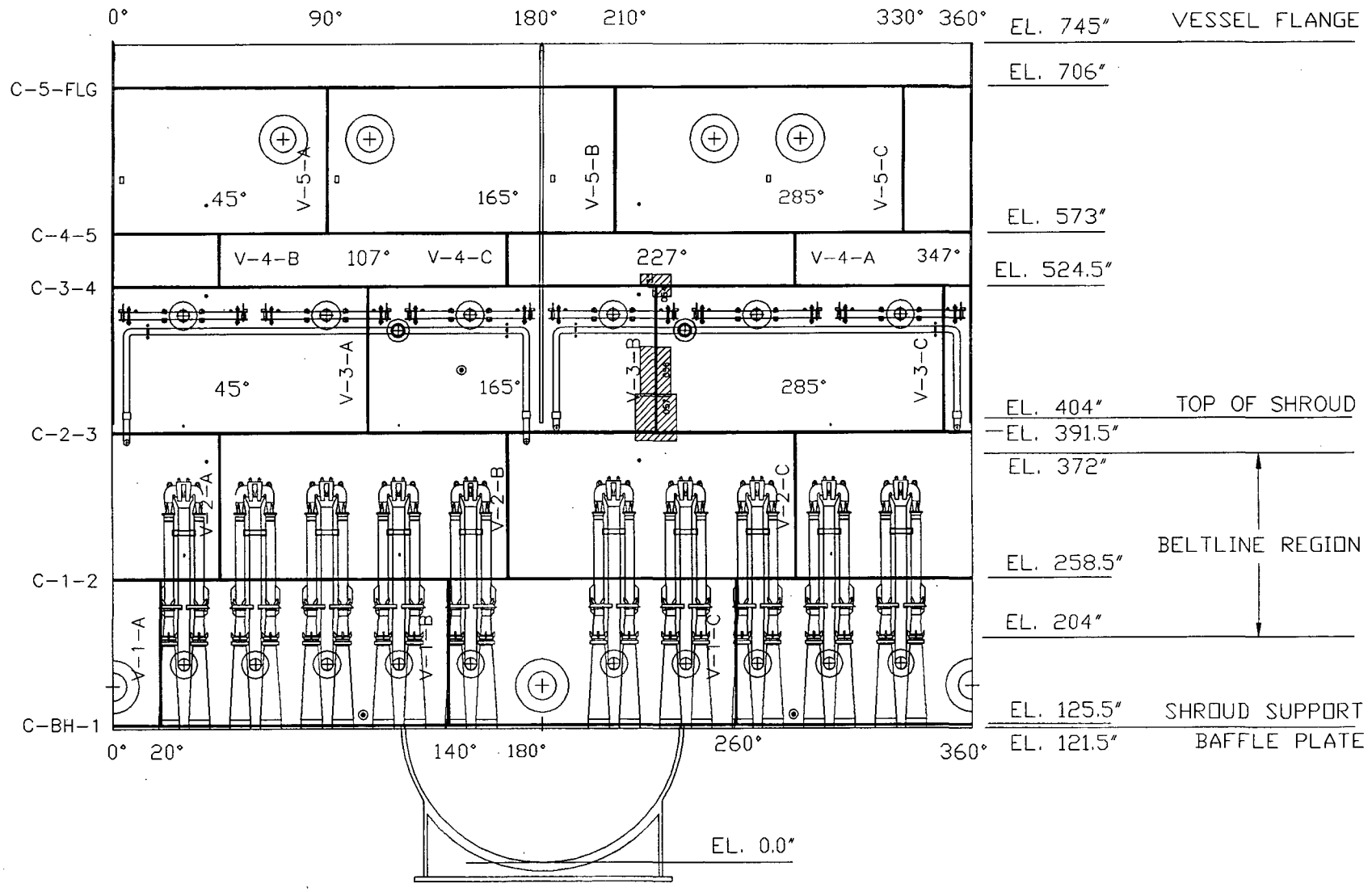
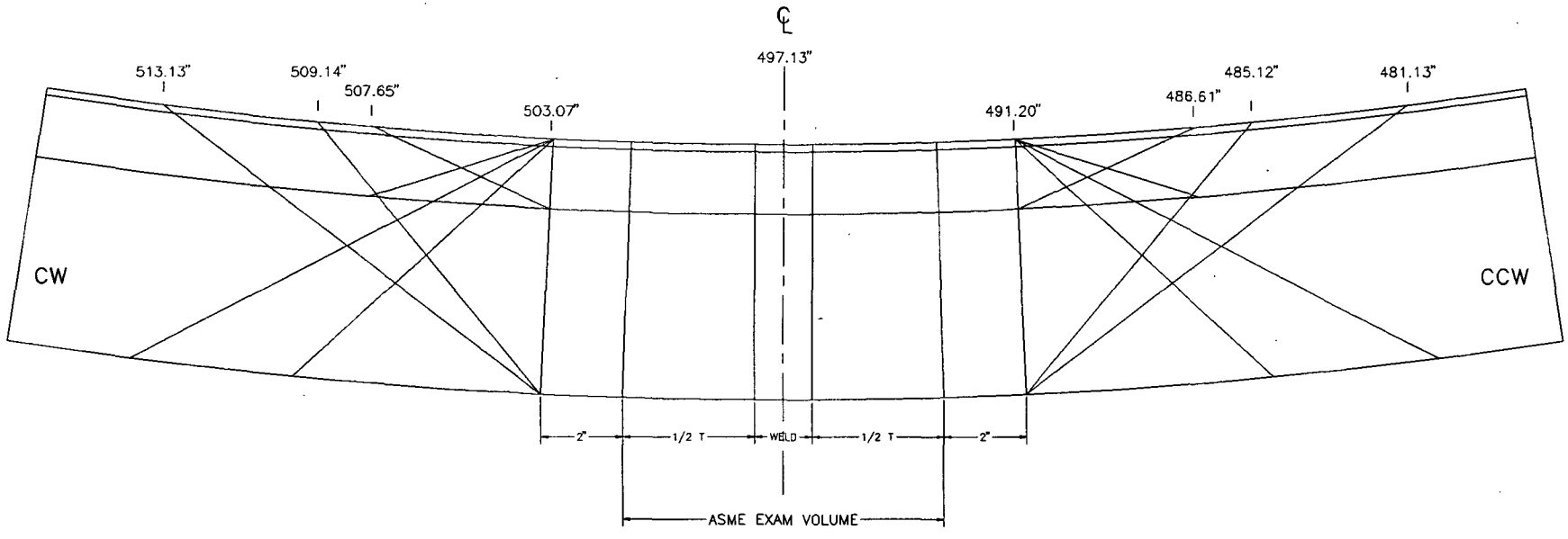
BROWNS FERRY UNIT-3 WELD LOCATIONS



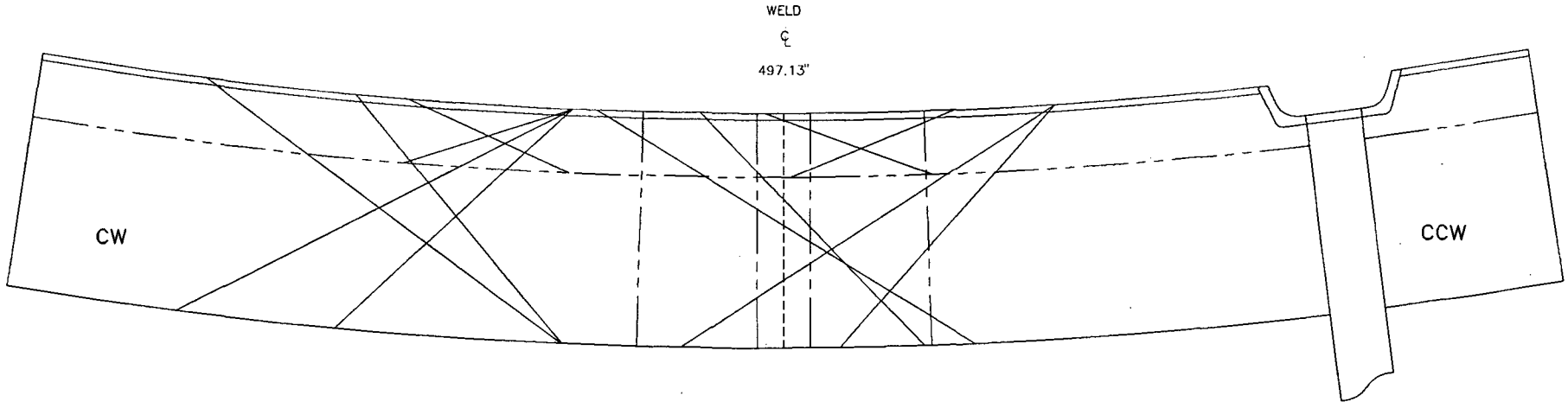
GE NUCLEAR ENERGY	BROWNS FERRY UNIT 3	VESSEL ROLLOUT & AS SCANNED PATCH LOCATIONS	BF-3-VMA	REV 0



Nominal Clad T = 3/16"
Nominal Base Metal T = 6 3/8"
1 Degree = 2.19"

CH.	ANGLE	DIR.	MIN X	MAX X
1	0 W	0	491.20	503.07
2	0 W	90	491.20	503.07
3	70 UP	0	491.20	503.07
4	70 CW	90	486.61	503.07
5	70 DN	180	491.20	503.07
6	70 CCW	270	491.20	507.65
7	45 UP	0	491.20	503.07
8	45 CW	90	485.12	503.07
9	45 DN	180	491.20	503.07
10	45 CCW	270	491.20	509.14
11	60 UP	0	491.20	503.07
12	60 CW	90	481.13	503.07
13	60 DN	180	491.20	503.07
14	60 CCW	270	491.20	513.13
15	0 BM	0	491.20	513.13
16	0 BM	90	481.13	503.07

GE NUCLEAR ENERGY	BROWNS FERRY UNIT 3	WELD V-3-B EXAM VOLUME	SCALE: NONE	DWG. BF3-VERT	REV. 0



Nominal Clad T = 3/16"
Nominal Base Metal T = 6 3/8"
1 Degree = 2.19"

GE NUCLEAR ENERGY	BROWNS FERRY UNIT 3	N11B NOZ. AUTOMATED SCAN LIMIT	SCALE: NONE	DWG. V-3BN11B	REV. 0

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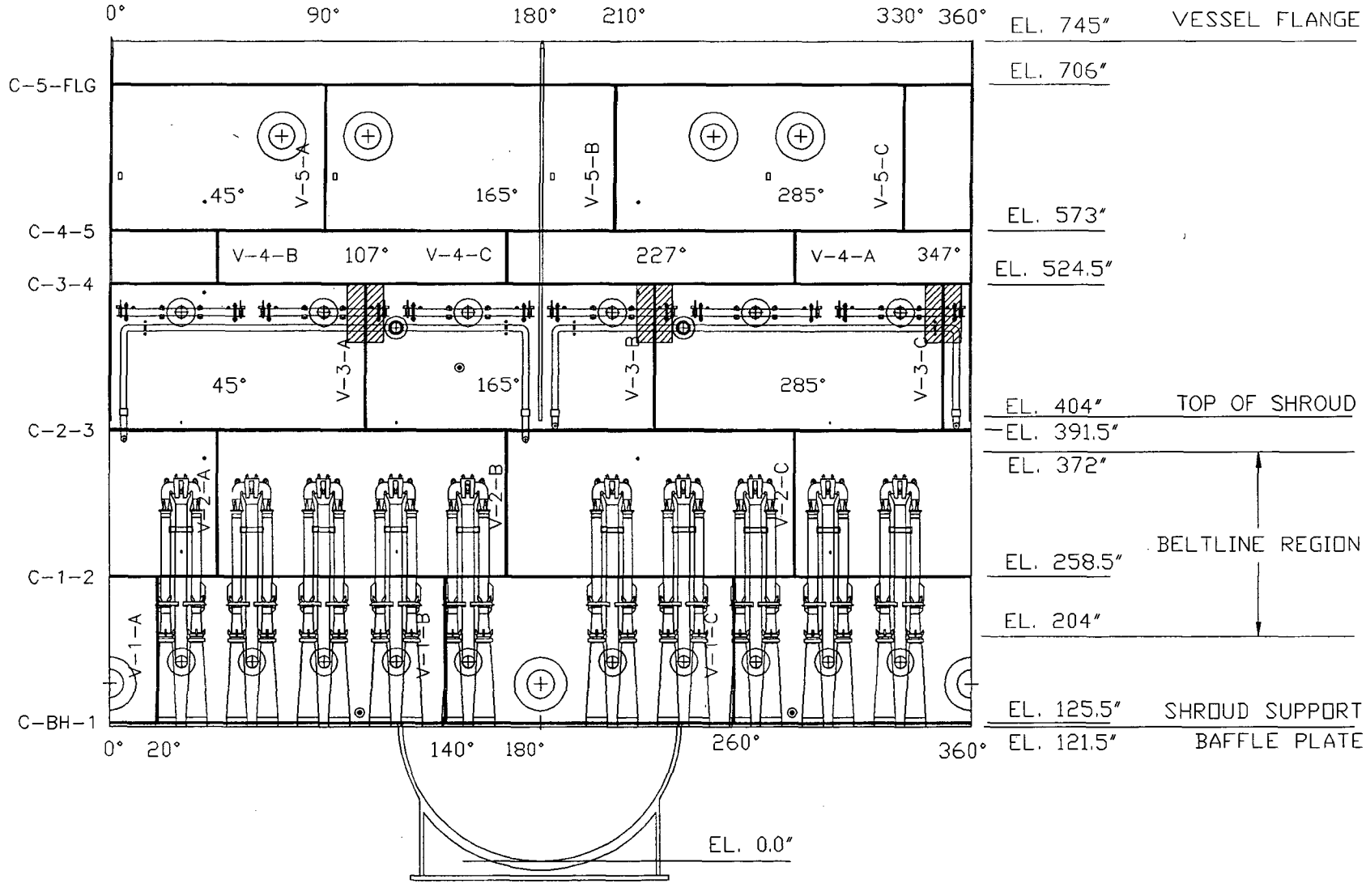
BROWNS FERRY UNIT-3 WELD LOCATIONS



GE NUCLEAR ENERGY	BROWNS FERRY UNIT 3	VESSEL ROLLOUT & MANUAL PICKUP AREAS	BF-3-VMA	REV 0

00114

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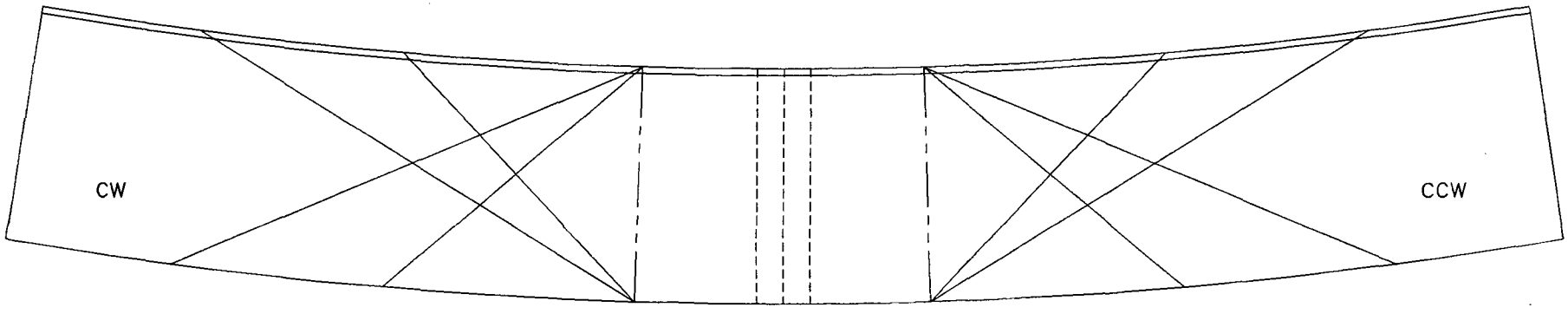


522.10"

WELD
℄

Nominal Clad T = 3/16"
Nominal Base Metal T = 6 3/8"

GE NUCLEAR ENERGY	BROWNS FERRY UNIT 3	WELD V-3-B MANUAL PICKUP	SCALE: NONE	DWG. MANV-3-B	REV. 0

R1164

GE Nuclear Energy

ULTRASONIC EXAMINATION DATA SHEET

(MANUAL RPV VESSEL WELDS)

SITE: BROWNS FERRY | PROCEDURE NO.: GE-UT-300 | REPORT NO.: E-10

UNIT: 3 | REVISION NO.: 6 | DATA SHEET NO.: D-032

PROJECT NO.: 00387 | FRR NO.: 004 | CALIBRATION SHEET NO.: 0° C-115

45° N/A 60° N/A

SYSTEM: RPV | EXAM SURFACE TEMP: 73 °F | COUPLANT: Ultrasel F | EXAM START: 1224

WELD ID: V-3-B | THERMOMETER S/N: L0250CL | BATCH NO.: 093011 | EXAM END.: 1228

BEAM ANGLE: [X] 0° [ ] 45° [ ] 60° [ ] OTHER N/A | SURFACE CONDITION: [X] SMOOTH [ ] GROUND [ ] OTHER N/A

MATERIAL TYPE: [X] CS [ ] SS [ ] OTHER N/A | EXAM SURFACE: [ ] ID [X] OD

Lo REFERENCE TOE OF WELD ℄ C-3-4

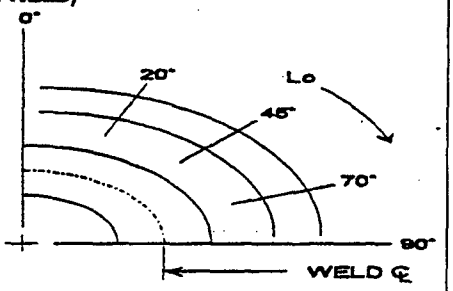
Wo REFERENCE WELD ℄

0° SCAN SENSITIVITY 61 dB

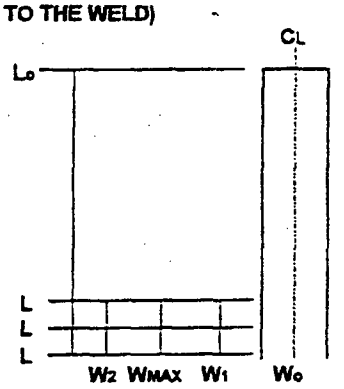
45° SCAN SENSITIVITY N/A dB

60° SCAN SENSITIVITY N/A dB

NOZZLE WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



L/R	% DAC (MAX)	W1 20% DAC	WF1 50% DAC	WM MAX DAC	WF2 50% DAC	W2 20% DAC	MP1 20% DAC	MPF1 50% DAC	MP MAX DAC	MPF2 50% DAC	MP2 20% DAC	CONTINUOUS (C) OR SPOT (S) TRANSVERSE (T) OR PARALLEL (P)	CW/CCW TOP OR BOTTOM
	NO RECORDABLE INDICATIONS, WELD EXAM												

REMARKS: EXAMINED FROM AN ELEVATION OF 471.5" TO 524.5" Area Below Elevation 471.5" was not examined due to the proximity of an insulation ring and non-removable insulation.

Edward Catron II 11-4-93
EXAMINED BY LEVEL DATE

J R Woody 12/15/93
UTILITY REVIEW DATE

C A Ms 12/1/93
GE REVIEWED BY DATE

Albert Todd 12/15/93
ANII REVIEW DATE

PAGE: 1 OF: 1

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GE Nuclear Energy

ULTRASONIC EXAMINATION DATA SHEET

(MANUAL RPV VESSEL WELDS)

SITE: BROWNS FERRY | PROCEDURE NO.: GE-UT-300 | REPORT NO.: E-10

UNIT: 3 | REVISION NO.: 6 | DATA SHEET NO.: D-033

PROJECT NO.: 00387 | FRR NO.: 004 | CALIBRATION SHEET NO.: 0° C-115

45° N/A 60° N/A

SYSTEM: RPV | EXAM SURFACE TEMP: 73 °F | COUPLANT: Ultragel II | EXAM START: 1219

WELD ID: V-3-B | THERMOMETER S/N: L0250CL | BATCH NO.: 093011 | EXAM END.: 1224

BEAM ANGLE: [X] 0° [ ] 45° [ ] 60° [ ] OTHER N/A | SURFACE CONDITION: [X] SMOOTH [ ] GROUND [ ] OTHER N/A

MATERIAL TYPE: [X] CS [ ] SS [ ] OTHER N/A | EXAM SURFACE: [ ] ID [X] OD

Lo REFERENCE TOE OF WELD C-3-4

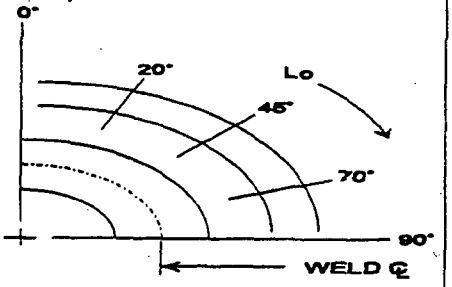
Wo REFERENCE WELD ℄

0° SCAN SENSITIVITY 61 dB

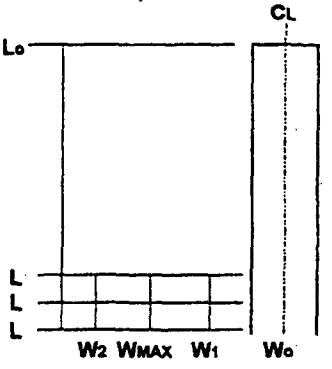
45° SCAN SENSITIVITY N/A dB

60° SCAN SENSITIVITY N/A dB

NOZZLE WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



L/R	% DAC (MAX)	W1 20% DAC	WF1 50% DAC	WM MAX DAC	WF2 50% DAC	W2 20% DAC	MP1 20% DAC	MPF1 50% DAC	MP MAX DAC	MPF2 50% DAC	MP2 20% DAC	CONTINUOUS (C) OR SPOT (S) TRANSVERSE (T) OR PARALLEL (P)	CW/CCW TOP OR BOTTOM
			NO RECORDABLE INDICATIONS, BASE METAL.										

REMARKS: EXAMINED FROM AN ELEVATION OF 471.5" TO 524.5" Area Below Elevation 471.5" was not examined due to the proximity of an insulation ring and non-removable insulation.

Edward Cotton II 11-4-93
EXAMINED BY LEVEL DATE

C A Ms 12/1/93
GE REVIEWED BY DATE

D M Woody 12/15/93
UTILITY REVIEW DATE

Albert Todd 12/15/94
ANII REVIEW DATE

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00117

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GE Nuclear Energy

ULTRASONIC EXAMINATION DATA SHEET
(MANUAL RPV VESSEL WELDS)

SITE: BROWNS FERRY
UNIT: 3
PROJECT NO.: 00387

PROCEDURE NO.: GE-UT-300
REVISION NO.: 6
FRR NO.: 004

REPORT NO.: E-10
DATA SHEET NO.: D-039
CALIBRATION SHEET NO.: 0° N/A 45° C116 60° N/A

SYSTEM: RPV
EXAM SURFACE TEMP: 73 °F
COUPLANT: Ultragel II
EXAM START: 1235

WELD ID: V-3-B
THERMOMETER S/N: L0250CL
BATCH NO.: 093011
EXAM END.: 1241

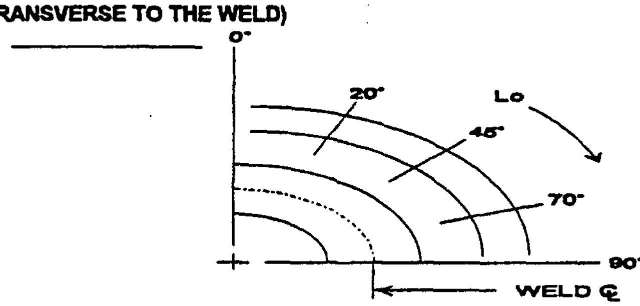
BEAM ANGLE: ☐ 0° ☒ 45° ☐ 60° ☐ OTHER N/A
SURFACE CONDITION: ☒ SMOOTH ☐ GROUND ☐ OTHER N/A

MATERIAL TYPE: ☒ CS ☐ SS ☐ OTHER N/A
EXAM SURFACE: ☐ ID ☒ OD

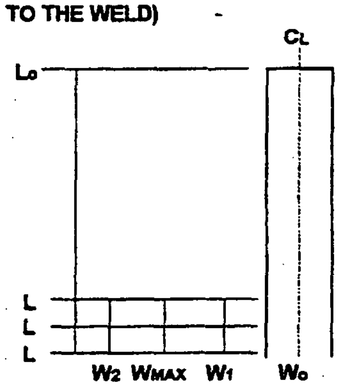
Lo REFERENCE: TOE OF WELD C-3-4
Wo REFERENCE: WELD ℄

0° SCAN SENSITIVITY N/A dB
45° SCAN SENSITIVITY 65.6 dB
60° SCAN SENSITIVITY N/A dB

NOZZLE WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



L/R	% DAC (MAX)	W1 20% DAC	WF1 50% DAC	WM MAX DAC	WF2 50% DAC	W2 20% DAC	MP1 20% DAC	MPF1 50% DAC	MP MAX DAC	MPF2 50% DAC	MP2 20% DAC	CONTINUOUS (C) OR SPOT (S) TRANSVERSE (T) OR PARALLEL (P)	CW/CCW TOP OR BOTTOM
		NO RECORDABLE INDICATIONS											

REMARKS: EXAMINED FROM AN ELEVATION OF 471.5" TO 524.5" Area Below Elevation 471.5" was not examined due to the proximity of an insulation ring and non-removable insulation.

[signature]	II	11-4-93	[signature]	12/15/93
EXAMINED BY	LEVEL	DATE	UTILITY REVIEW	DATE
[signature]		12/1/93	[signature]	8/25/94
GE REVIEWED BY		DATE	ANII REVIEW	DATE

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00118

R1164

GE Nuclear Energy

ULTRASONIC EXAMINATION DATA SHEET

(MANUAL RPV VESSEL WELDS)

SITE: Browns Ferry | PROCEDURE NO.: GE-UT-300 | REPORT NO.: E-10

UNIT: 3 | REVISION NO.: 6 | DATA SHEET NO.: D-043

PROJECT NO.: 00387 | FRR NO.: 004 | CALIBRATION SHEET NO.: 0° N/A

45° N/A 60° C-117

SYSTEM: RPV | EXAM SURFACE TEMP: 73 °F | COUPLANT: Ultrasee/H | EXAM START: 1245

WELD ID: V-3-B | THERMOMETER S/N: L0250 CL | BATCH NO.: 093011 | EXAM END.: 1254

BEAM ANGLE: ☐ 0° ☐ 45° ☒ 60° ☐ OTHER N/A | SURFACE CONDITION: ☒ SMOOTH ☐ GROUND ☐ OTHER N/A

MATERIAL TYPE: ☒ CS ☐ SS ☐ OTHER N/A | EXAM SURFACE: ☐ ID ☒ OD

Lo REFERENCE TOE OF WELD C-3-4

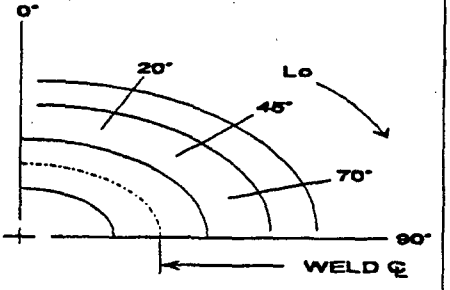
Wo REFERENCE WELD ℄

0° SCAN SENSITIVITY N/A dB

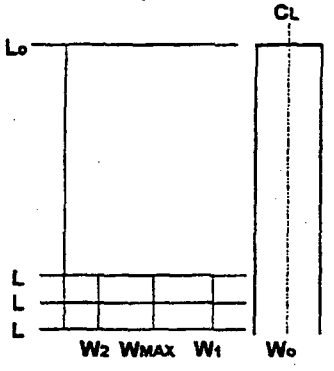
45° SCAN SENSITIVITY N/A dB

60° SCAN SENSITIVITY 73 dB

NOZZLE WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



WELD REFERENCE SYSTEM (Lo AND Wo ARE INTERCHANGED WHEN SCANNING FOR REFLECTORS TRANSVERSE TO THE WELD)



L/R	% DAC (MAX)	W1 20% DAC	WF1 50% DAC	WM MAX DAC	WF2 50% DAC	W2 20% DAC	MP1 20% DAC	MPF1 50% DAC	MP MAX DAC	MPF2 50% DAC	MP2 20% DAC	CONTINUOUS (C) OR SPOT (S) TRANSVERSE (T) OR PARALLEL (P)	CW/CCW TOP OR BOTTOM
			NO RECORDABLE INDICATIONS										

REMARKS: EXAMINED FROM AN ELEVATION OF 471.5" TO 524.5". Area Below Elevation 471.5" WAS NOT EXAMINED DUE TO THE PROXIMITY OF an INSULATION ring And non-removable Insulation.

Ernest Cotton II 11-4-93
EXAMINED BY LEVEL DATE

J McWoody 12/15/93
UTILITY REVIEW DATE

C Q M5 12/1/93
GE REVIEWED BY DATE

Robert Todd 12/25/93
ANII REVIEW DATE

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00119