



GERIS 2000 Examination Summary Sheet

ASME Code Category: B-A

Supporting Data:	Examination Data Sheets E-11-00 thru E-11-03, Indication Data Sheets 11-001 thru 11-004, Screen Prints, Exam Patch Location Map, Exam Coverage Plots, GERIS 2000 Setup Records and Manual Examination Data Sheets D-046, D-047, D-048 and D-049.
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Fabrication records and previous examination results were reviewed prior to the completion of this examination summary.

DATE:



GERIS 2000 Examination Data Sheet

Exam Data Sheet: E-11-00

FRR No.: N/A

[illegible]

Comments: N/A

Limitations: Examination limited due to Feedwater Sparger and Core Spray Downcomer.

Analyst: S. M. A.

Level: III Date: 12/12/93

Reviewed By: [Signature]

Level: II Date: 12/13/93

R1165



GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3

Weld ID: V-3-C

Cal. ID: C-004

Exam Data Sheet No.: E-11-01**Patch ID:** BF-058**Ind. Data Sheet Series: 11-XXX**[illegible]

Comments: Note 1: Indications seen on the shell 4 side of C-3-4. These indications are not within V-C-3's required exam volume.
See weld C-3-4.

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: CLM

Level: III Date: 12/12/93

Reviewed By: He L. Li

Level: III - Date: 12/13/93



GE Nuclear Energy

GERIS 2000 Examination Data Sheet

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

Exam Data Sheet No.: E-11-02
Patch ID: BF-059
Ind. Data Sheet Series: 11-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	No Exam	~	~	~	~	~
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	No Exam	~	~	~	~	~
10	45 RS	270 CCW	NRI	~	~	~	~	~
11	60 RS	0 UP	NRI	~	~	~	~	~
12	60 RS	90 CW	NRI	~	~	~	~	~
13	60 RS	180 DN	No Exam	~	~	~	~	~
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 2, 9 and 13 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: CL MA

Level: III Date: 12/12/93

Reviewed By: John C. Davis

Level: II Date: 12/13/93



GERIS 2000 Examination Data Sheet

Ind. Data Sheet Series: 11-XXX

[illegible]

Comments: Note 1: See indications 11-001 and 11-002

Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Level: III Date: 12/13/93



GERIS 2000 Indication Data Sheet

Cal. ID: C-004

Ind. Data Sheet No.: 11-001

Direction: 0

Indication evaluated as a laminar reflector and is acceptable in accordance with IWB-3510-2, ASME Section XI, 1986 Edition, no Addenda.

Date: 12/13/93

R1165



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3

Weld ID: V-3-C

Cal. ID: C-004

Exam Data Sheet No.: E-11-03

Patch ID: BF-060

Ind. Data Sheet No.: 11-002

Indication: 11-002

Channel: 1

Angle: 0

Direction: 0

[illegible]

Comments: Backwall maintained.

Indication evaluated as a laminar reflector and is acceptable in accordance with IWB-3510-2, ASME Section XI, 1986 Edition, no Addenda.

Analyst:

Analyst: CG M-5

Level:

Level: III Date: 12/12/93

Reviewed By:

Reviewed By: H. C. Smith

Level:

Level: II Date: 12/13/93



GERIS 2000 Indication Data Sheet

Ind. Data Sheet No.: 11-003

Direction: 180

12/12/9311003.XLS
00127.

R1165



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3

Weld ID: V-3-C

Cal. ID: C-004

Exam Data Sheet No.: E-11-03**Patch ID:** BF-060

Ind. Data Sheet No.: 11-004

Indication: 11-004

Channel: 13

Angle: 60

Direction: 180

[illegible]

Comments: No apparent tip signals.

Thruwall size determined by Reg. Gulde 20% beam spread corrected method.

Indication has no determinable thruwall dimension and is acceptable to IWB 3510-1.

$$\underline{TW = 0}$$
$$L = 0.5$$

S = 1.28 with clad

Analyst: CE MS

Level: III Date: 12/12/93

Reviewed By: Sh C / L. B.

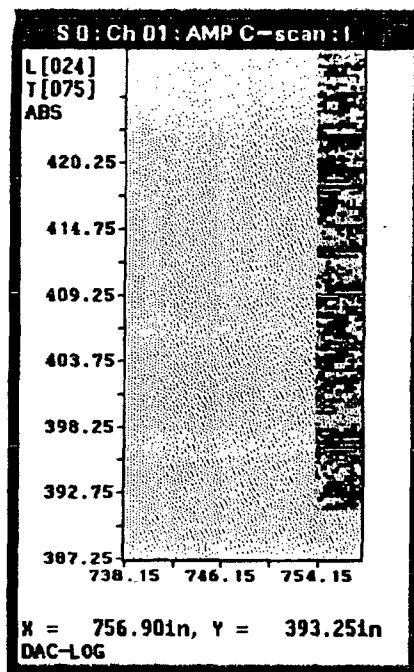
Level: III Date: 12/13/93

S 0 : Scale

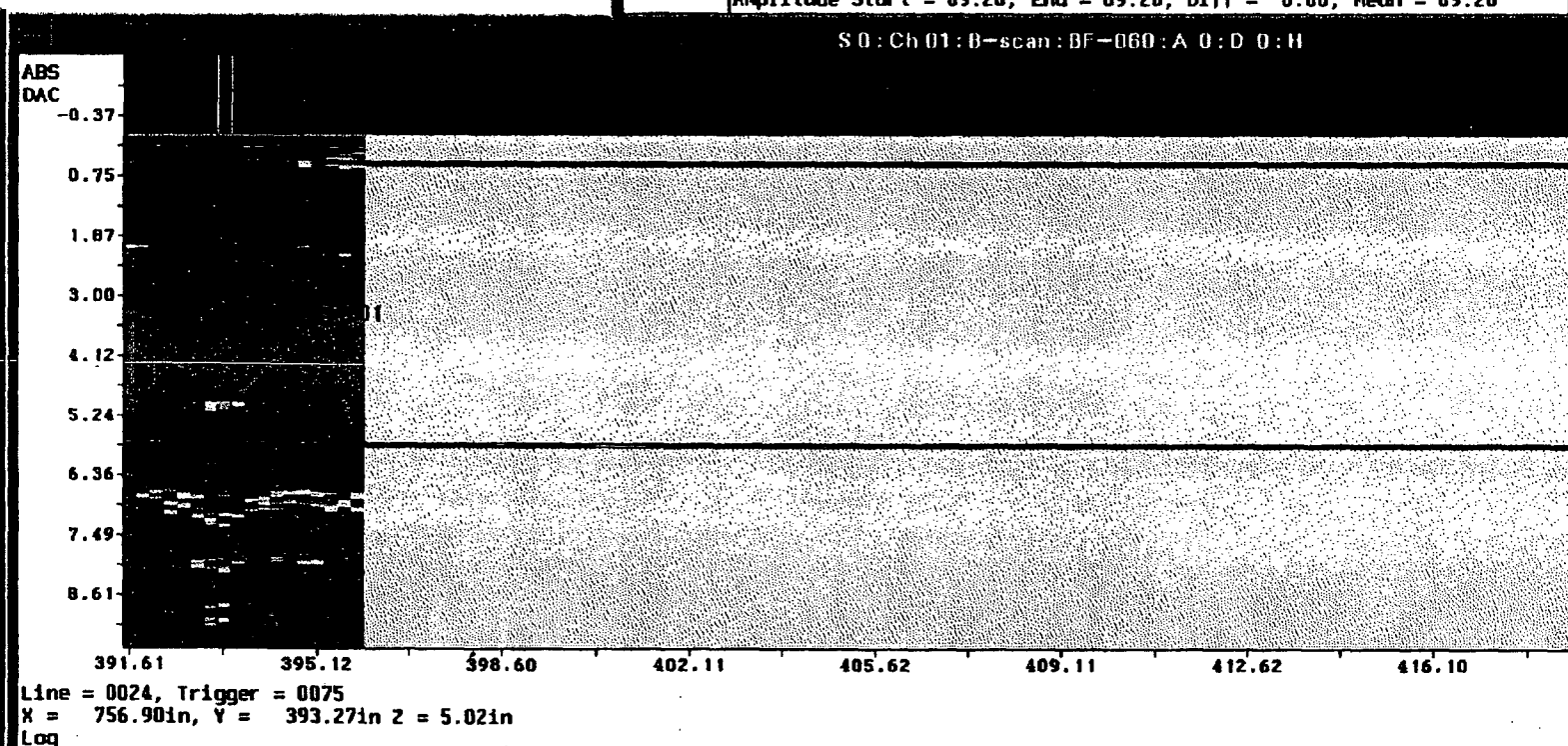
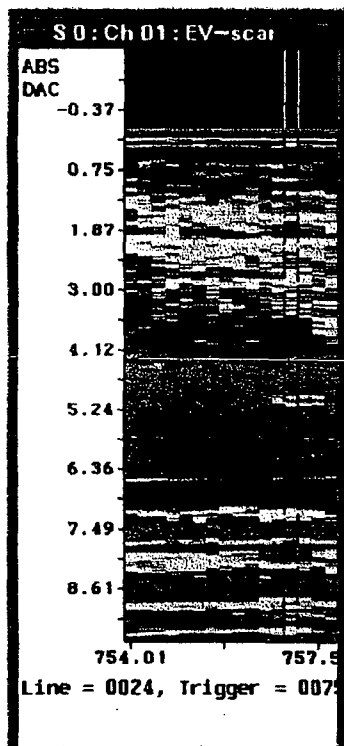
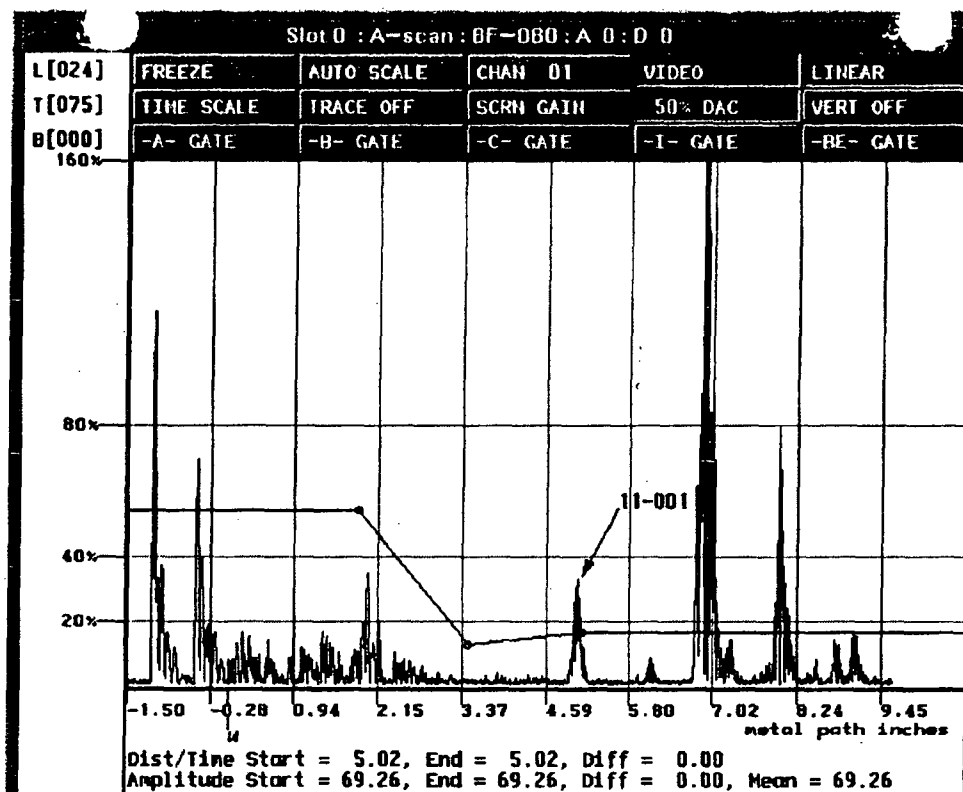
32.3
36.6
41.0
45.3
49.7
54.0
58.4
62.7
67.1
71.4
75.8
80.1
84.5
88.8
93.2

100%
50%
20%

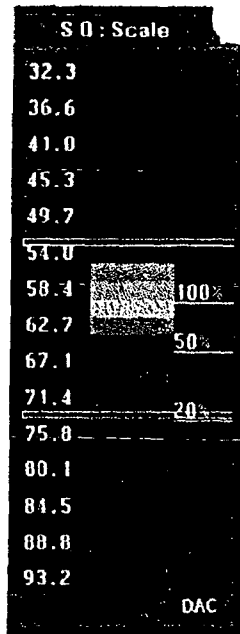
DAC



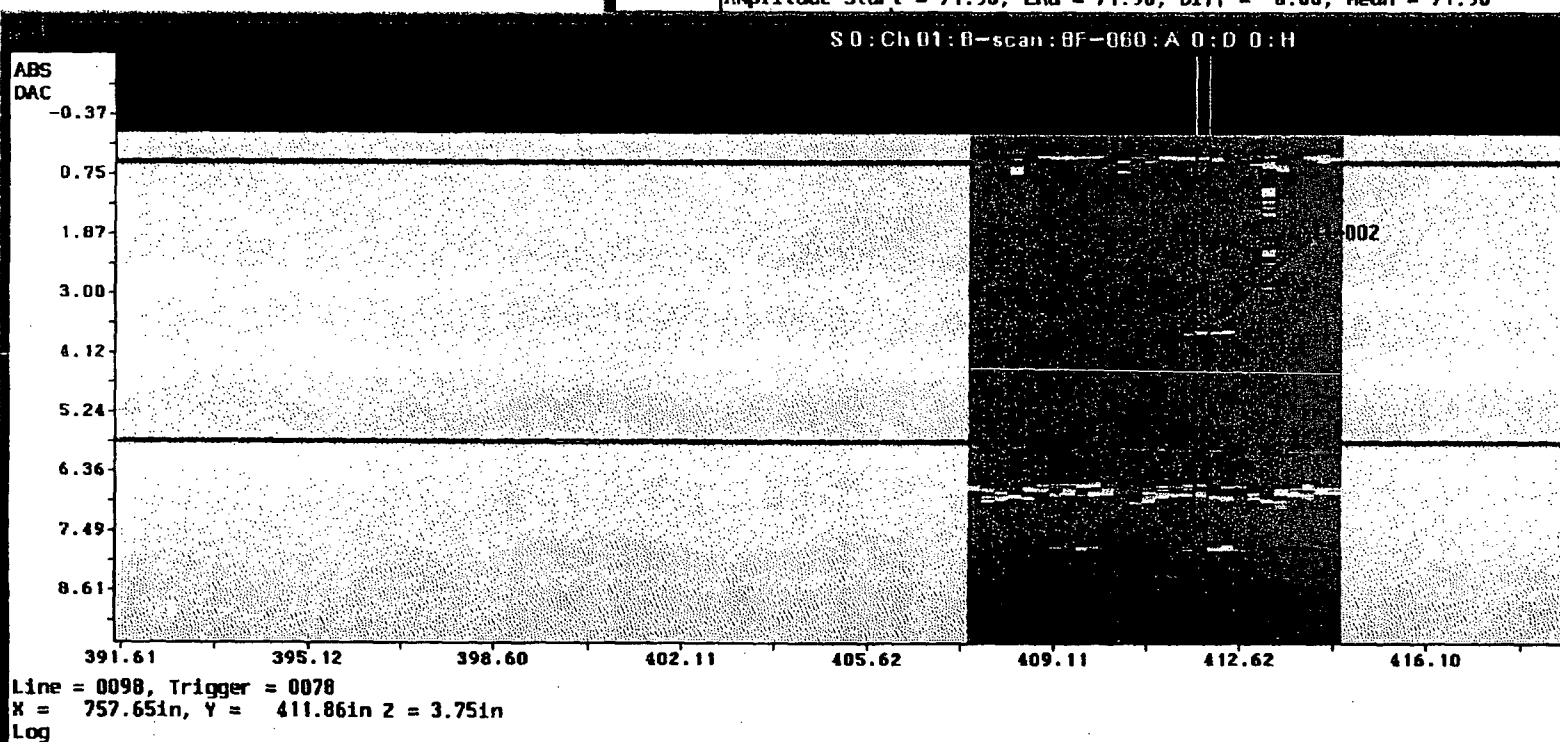
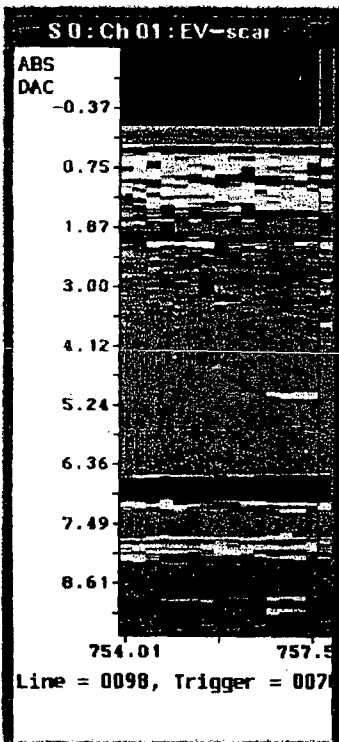
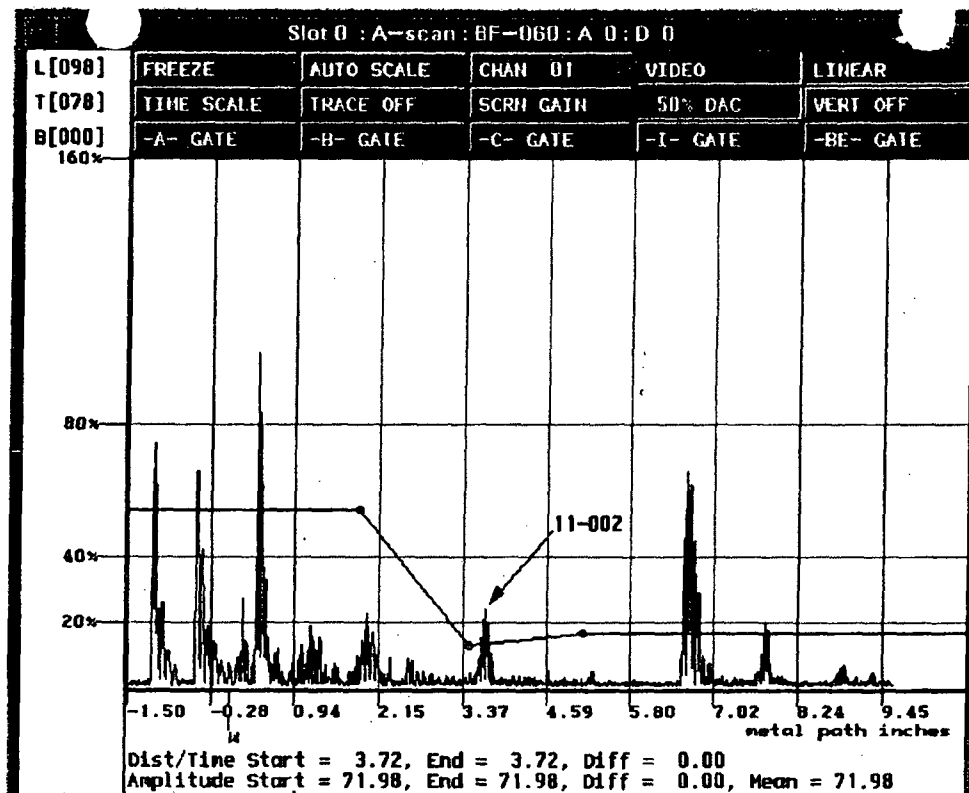
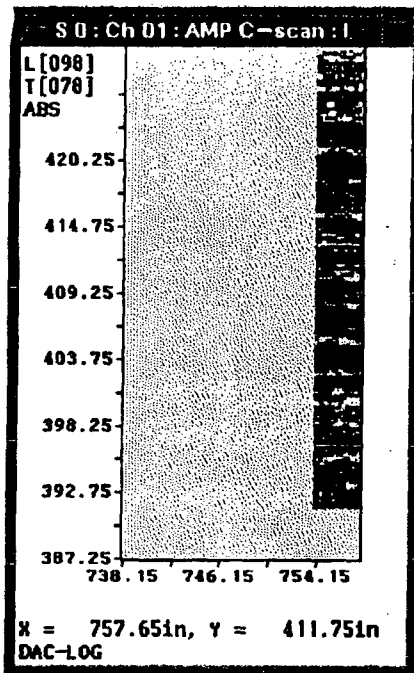
Lower T_h
axton3/11-001



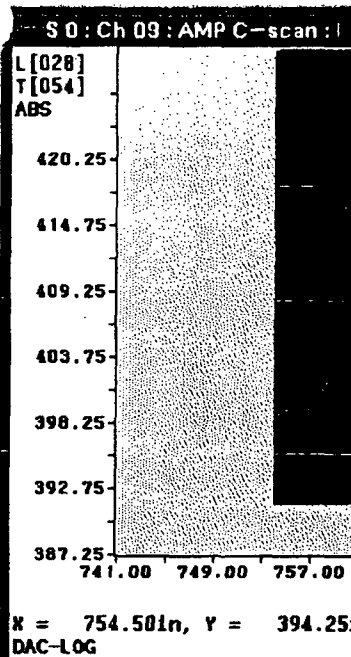
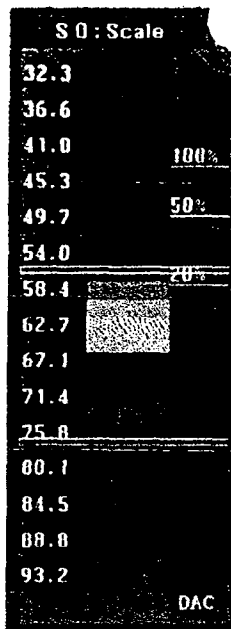
10 of 23
R1165
00129



Lower Te
xtor3/11-002

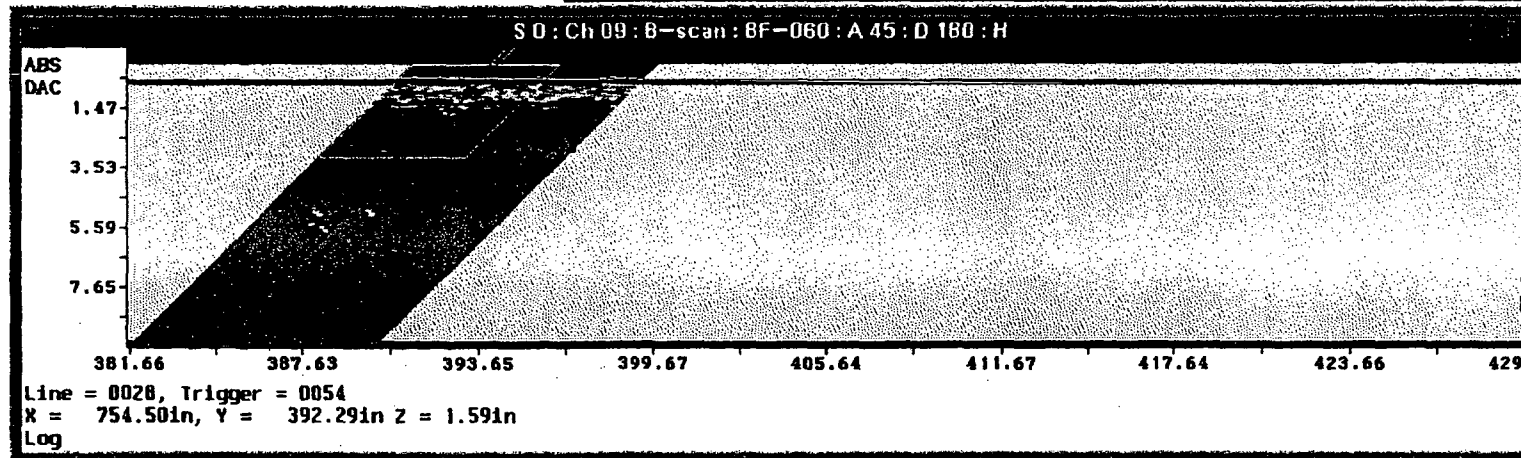
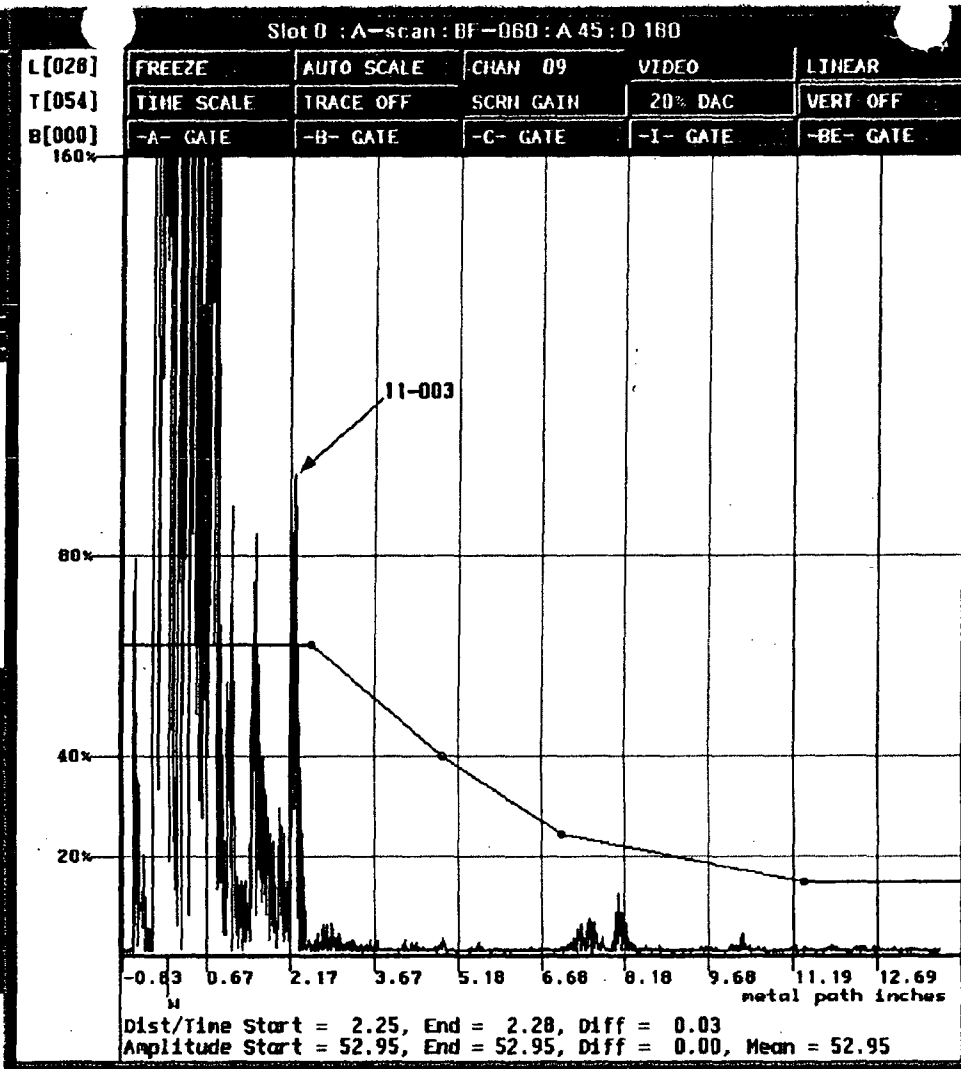
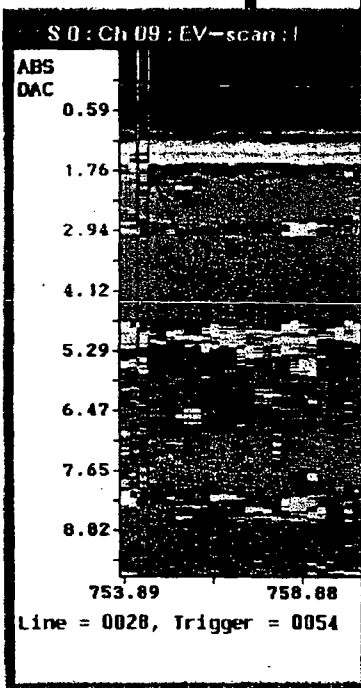
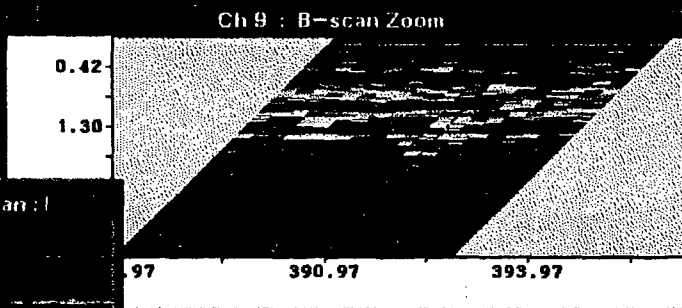
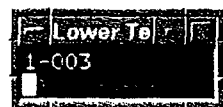


21195
11 OF 23 * 00130

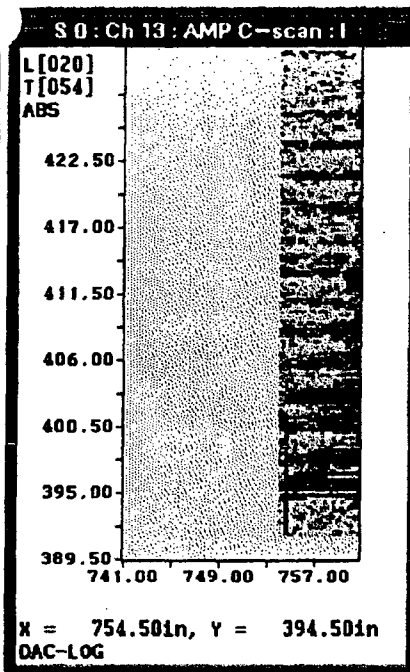
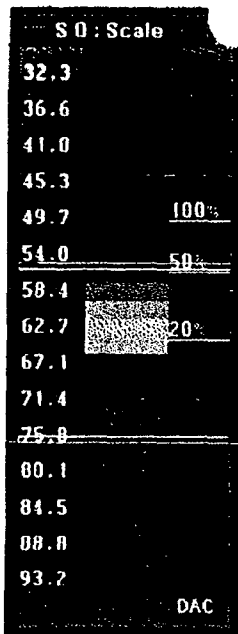


Utilities

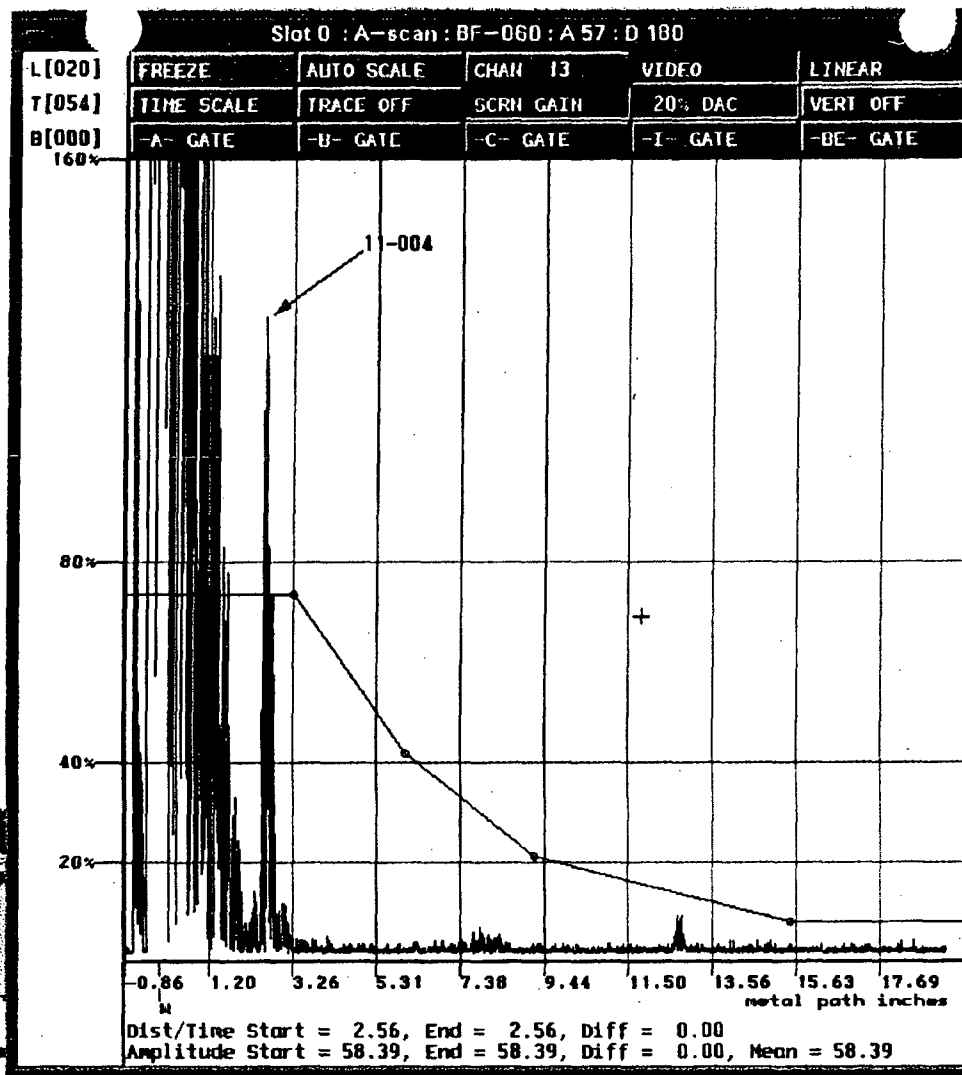
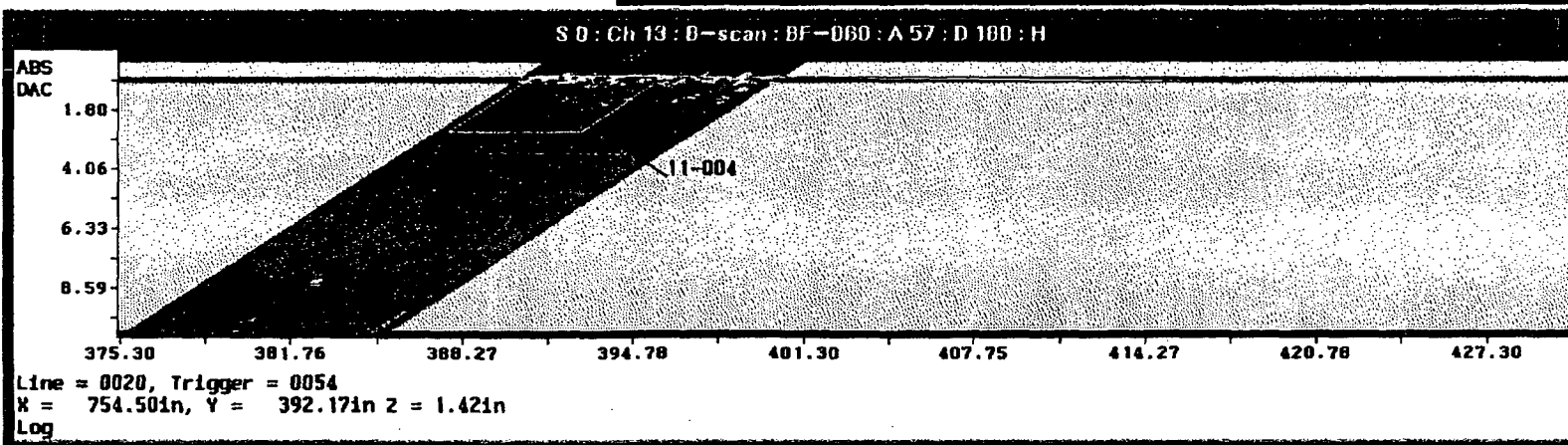
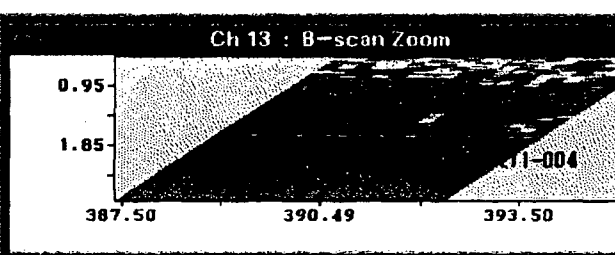
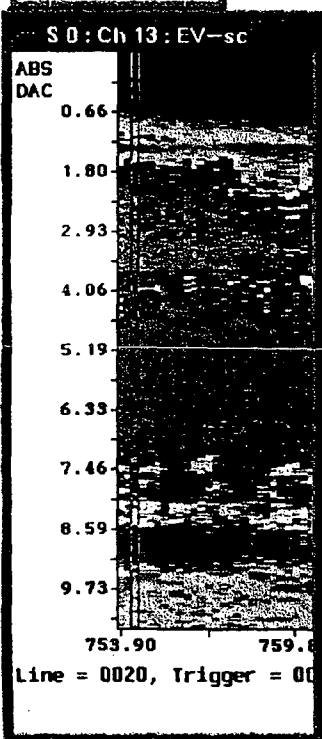
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R1165
12 OF 23
00131

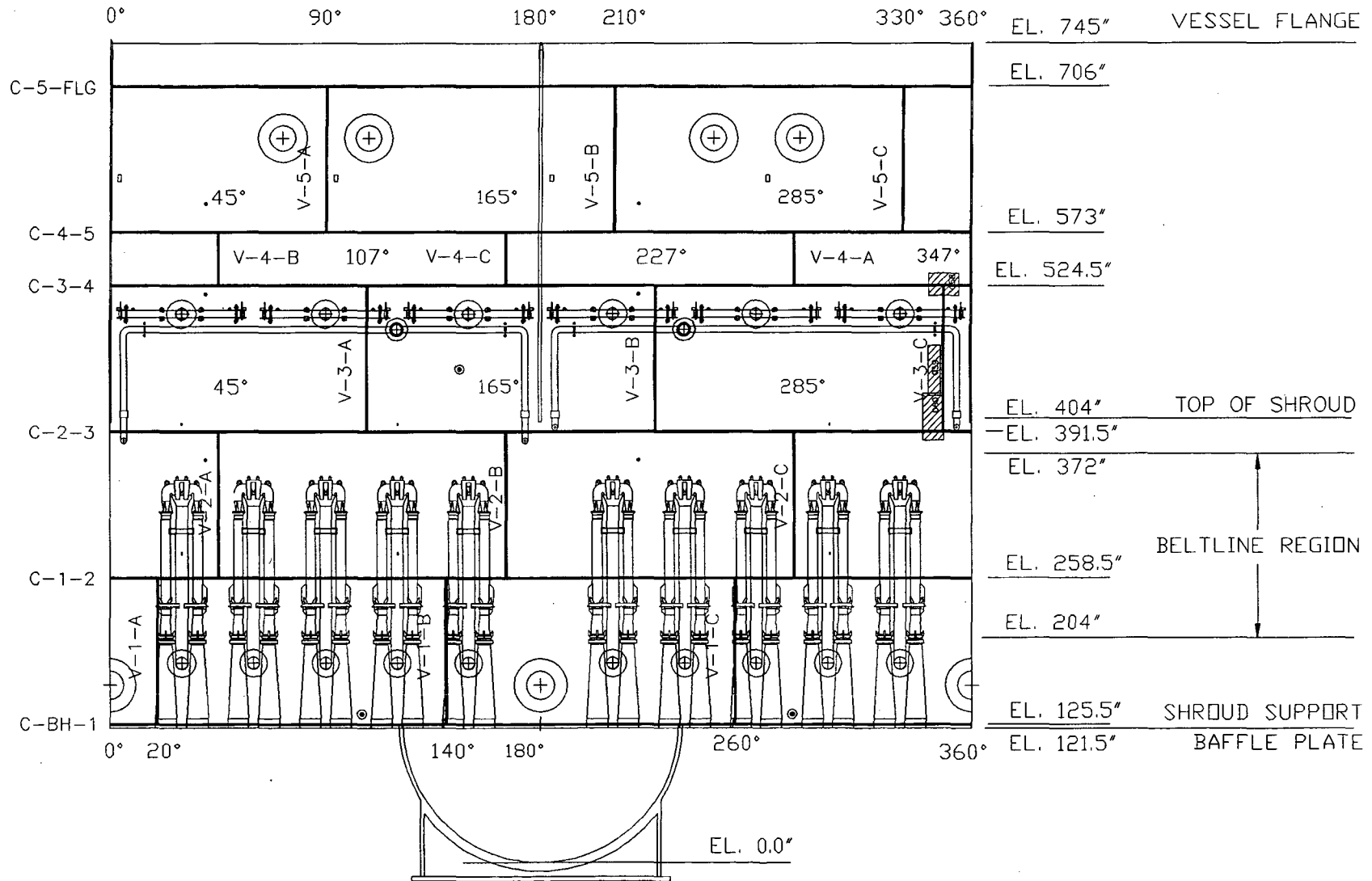


Lower To
xtr3/11-004



21165
13 OF 23
00132

BROWNS FERRY UNIT-3 WELD LOCATIONS

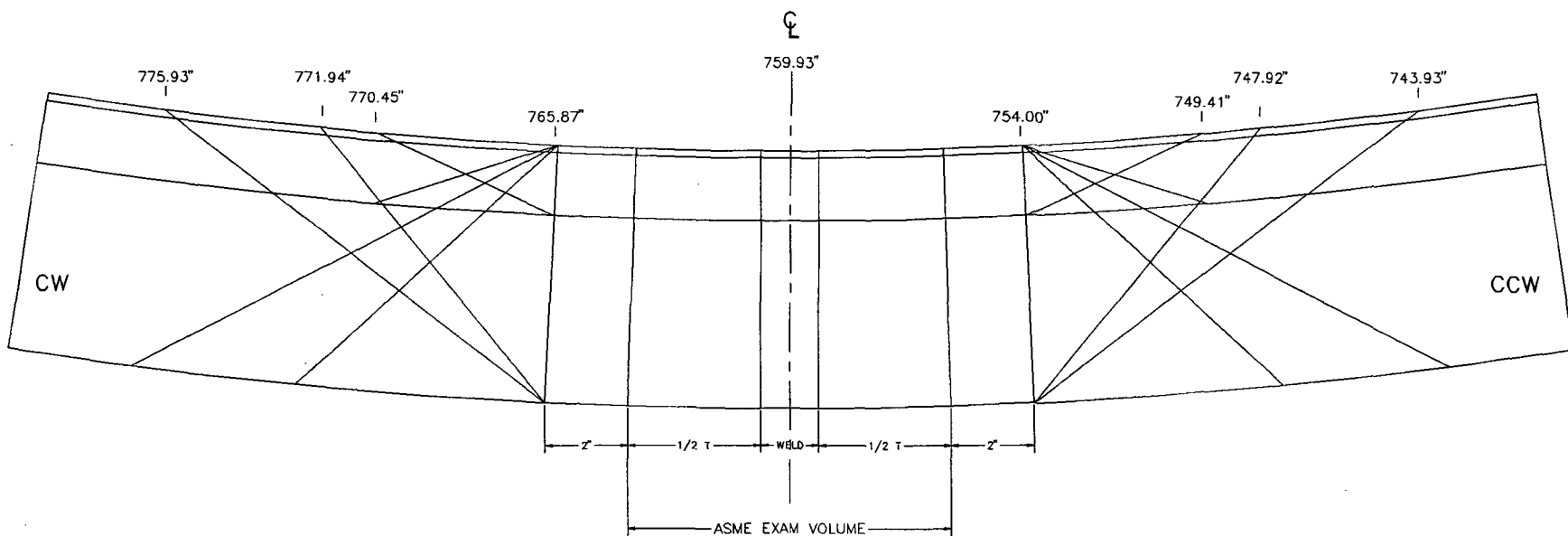


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21165
14 OF 23

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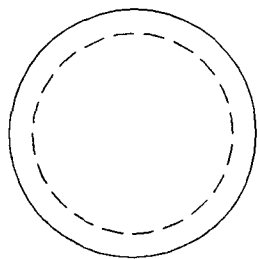
2145
15 of 23



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	754.00	765.87
2	0 W	90	754.00	765.87
3	70 UP	0	754.00	765.87
4	70 CW	90	749.41	765.87
5	70 DN	180	754.00	765.87
6	70 CCW	270	754.00	770.45
7	45 UP	0	754.00	765.87
8	45 CW	90	747.92	765.87
9	45 DN	180	754.00	765.87
10	45 CCW	270	754.00	771.94
11	60 UP	0	754.00	765.87
12	60 CW	90	743.93	765.87
13	60 DN	180	754.00	765.87
14	60 CCW	270	754.00	775.93
15	0 BM	0	754.00	775.93
16	0 BM	90	743.93	765.87

00134



WELD
⊥
759.93"

CW

CCW

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

00135

21165
16 OF 23

GE NUCLEAR ENERGY

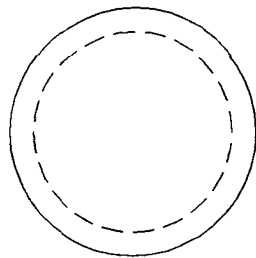
BROWNS FERRY UNIT 3

CS DNCMR AUTOMATED SCAN LIMIT

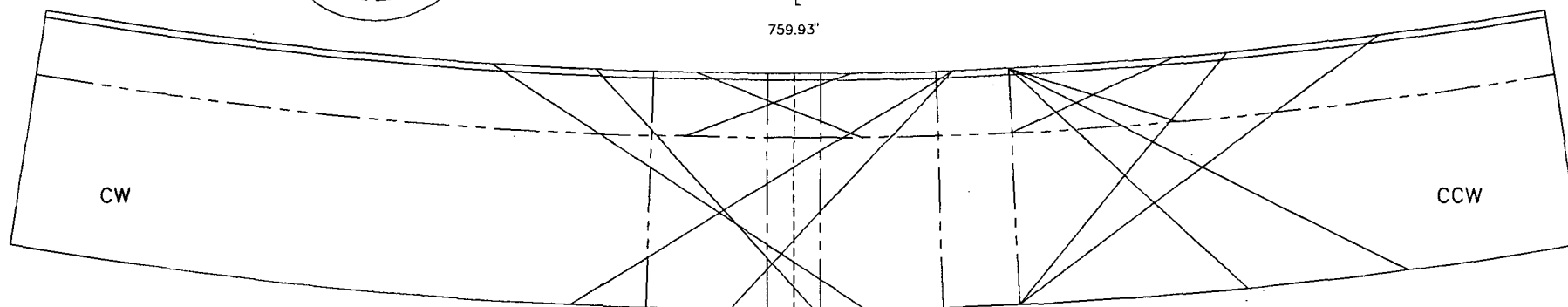
SCALE: NONE

DWG. V-3CCSDN

REV. 0



WELD
⊥
759.93"



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

00136

R1165
170F23

0000 0000

GE NUCLEAR ENERGY

BROWNS FERRY UNIT 3

CS DNCMR AUTOMATED SCAN LIMIT

SCALE: NONE

DWG. V-3CCSDN

REV. 0



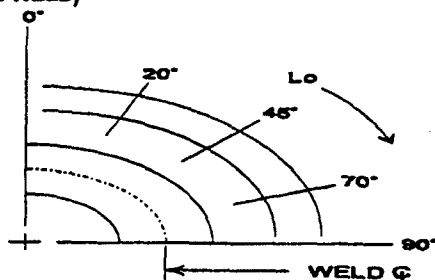
GE Nuclear Energy

ULTRASONIC EXAMINATION DATA SHEET

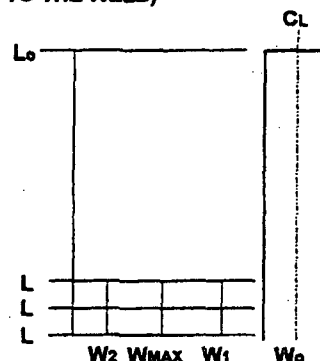
(MANUAL RPV VESSEL WELDS)

SITE: BROWNS FERRYPROCEDURE NO.: GE-UT-300REPORT NO.: E-11UNIT: 3REVISION NO.: 6DATA SHEET NO.: D-046PROJECT NO.: 00387FRR NO.: 004CALIBRATION SHEET NO.: 0° C-11845° N/A 60° N/ASYSTEM: RPV EXAM SURFACE TEMP: 73 °F COUPLANT: ULTRAGEL EXAM START: 1357WELD ID: V-3-C THERMOMETER S/N: L0250CL BATCH NO.: 093011 EXAM END: 1420BEAM ANGLE: ☒ 0° ☐ 45° ☐ 60° ☐ OTHER N/ASURFACE CONDITION: ☒ SMOOTH ☐ GROUND ☐ OTHER N/AMATERIAL TYPE: ☒ CS ☐ SS ☐ OTHER N/AEXAM SURFACE: ☐ ID ☒ ODLo REFERENCE TOE OF WELD C-3-40° SCAN SENSITIVITY 59.6 dBWo REFERENCE WELD C45° SCAN SENSITIVITY N/A dB60° 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/CW 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-remarkable insulation.Examined by Edmund Cation II 11-5-93
LEVEL DATE

UTILITY REVIEW

12/16/93
DATE

ANII REVIEW

DATE

PAGE: 1 OF: 1

FORM UT-14 REV. 8

R1145



GE Nuclear Energy

ULTRASONIC EXAMINATION DATA SHEET

(MANUAL RPV 0° BASE MATERIAL)

SITE BROWNS FERRY

PROCEDURE NO. GE-UT-300

REPORT NO. E-11

UNIT 3REVISION 6

DATA SHEET NO. D-047

PROJECT NO. 00387

FRR NO. 004

CALIBRATION SHEET 0° C-118

SYSTEM RPV SURFACE TEMP 73 °F COUPLANT ultraseal EXAM START 1351

WELD ID V-3-C THERMOMETER S/N LD250CL BATCH NO. 093011 EXAM END 1357

SURFACE CONDITION: ☒ SMOOTH ☐ GROUND ☐ OTHER N/A

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

L₀ REFERENCE TDE OF WELD C-3-4 W₀ REFERENCE WELD F 0° SCANNING SENSITIVITY 59.6 dB

[illegible]

REMARKS	Loss of Backwall due to Core spray sparger support Brackets(I.D. Geometry).
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Ernest Cator II 11-5-93
EXAMINED BY LEVEL DATE
CQ MS
GE REVIEWED BY DATE

12/16/93
DATE

PAGE: 1 OF: 1

FORM UT. 08ASE REV. 11-01



ULTRASONIC EXAMINATION DATA SHEET

(MANUAL RPV VESSEL WELDS)

REPORT NO.: E-11

DATA SHEET NO.: D-048

CALIBRATION SHEET NO.: 0° N/A

45° C-119 60° N/A

EXAM START: 1444

EXAM END.: 1459

SURFACE CONDITION: ☒ SMOOTH ☐ GROUND ☐ OTHER N/A

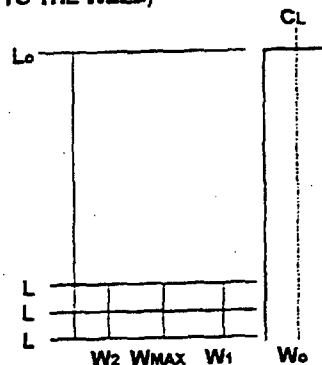
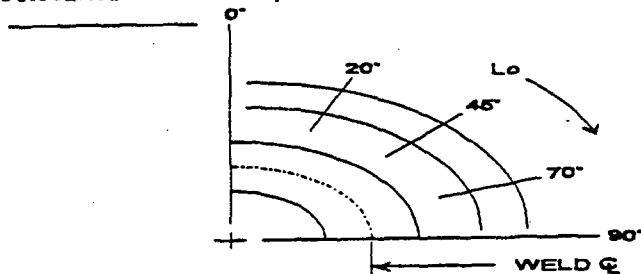
EXAM SURFACE: ☐ ID ☒ OD

0° SCAN SENSITIVITY N/A dB

45° SCAN SENSITIVITY 65.6 dB

60° SCAN SENSITIVITY N/A dB

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

[illegible]

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.

Earnest Cotton II 11-5-93
EXAMINED BY _____ LEVEL _____ DATE _____
CA M5 12/1/93
GE REVIEWED BY _____ DATE _____

UTILITY REVIEW

12	16	93
DATE		

ANIL REVIEW

DATE _____

PAGE: 1 OF: 1

FORM UT-14 REV. 5

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-11

DATA SHEET NO.: D-049

CALIBRATION SHEET NO.: 0° 2/A

45° N/A 60° C-120

SYSTEM: RPV EXAM SURFACE TEMP: 73 °F COUPLANT: Ultragel II EXAM START: 1423

WELD ID: K-3-C THERMOMETER S/N: L0250CL BATCH NO.: 093011 EXAM END.: 1441

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

MATERIAL TYPE: ☒ CS ☐ SS ☐ OTHER ALIA EXAM SURFACE: ☐ ID ☒ OD

Lo REFERENCE TOE OF WELD C-3-4

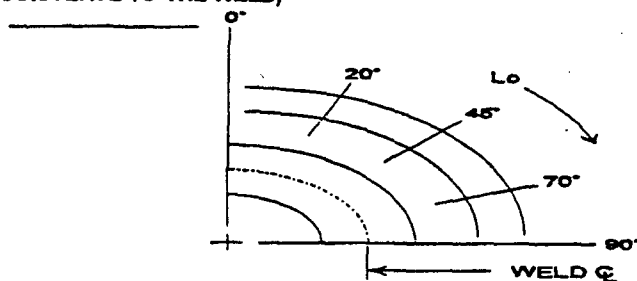
W. REFERENCE WELD C

0° SCAN SENSITIVITY N/A dB

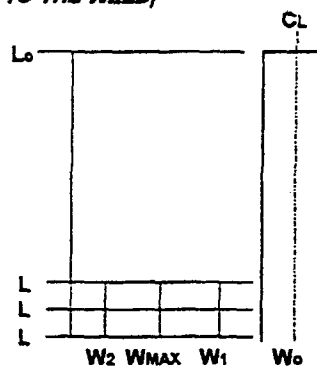
45° SCAN SENSITIVITY N/A dB

60° SCAN SENSITIVITY 73.6 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)

[illegible]

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.

EXAMINED BY E. Asant Cator II LEVEL 11-5-93 DATE

GE REVIEWED BY CL M5 DATE 12/1/93

21 Wood
UTILITY REVIEW

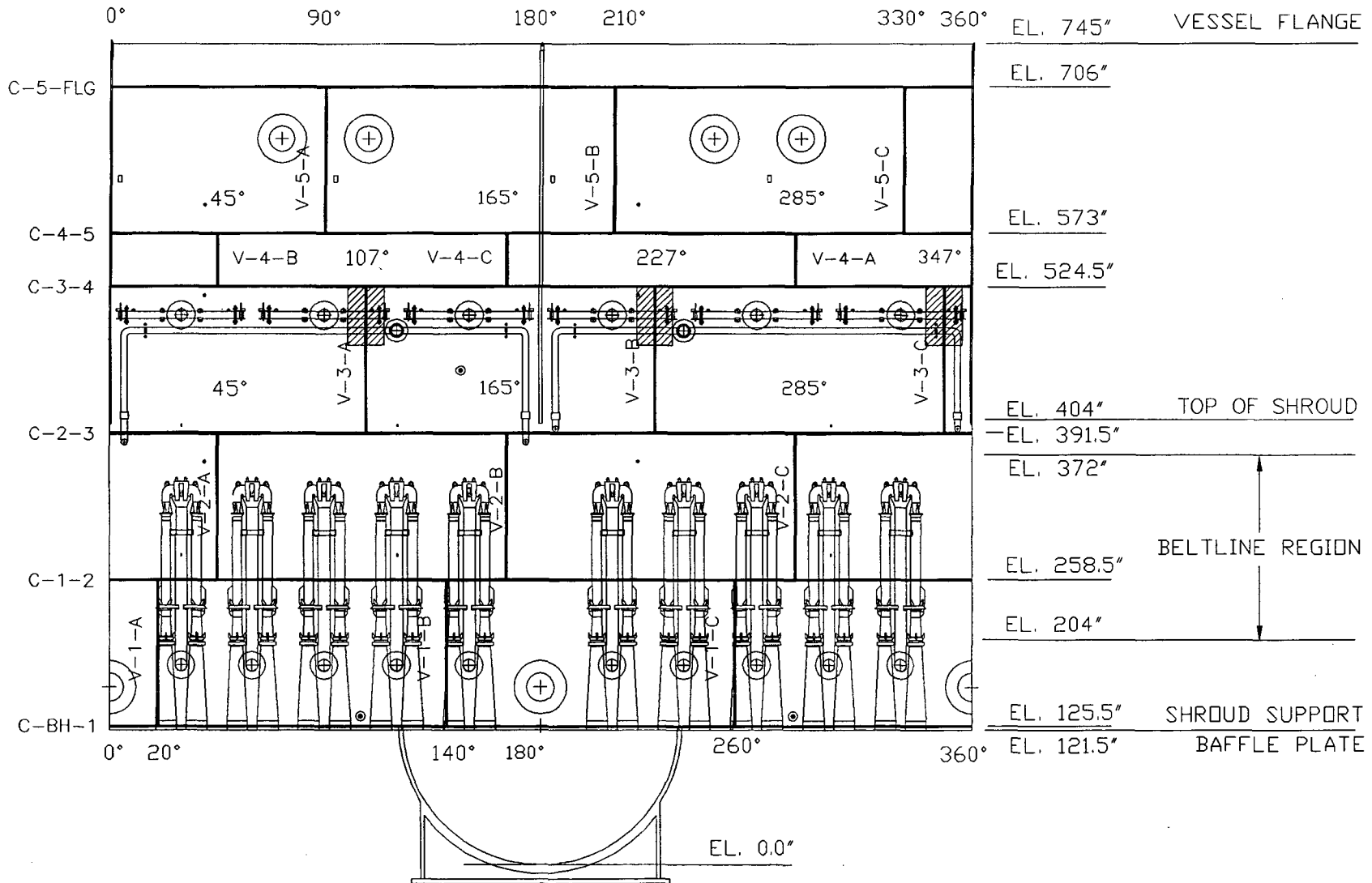
12/16/93
DATE

ANIL REVIEW

DATE _____

PAGE: 1 OF: 1

BROWNS FERRY UNIT-3 WELD LOCATIONS



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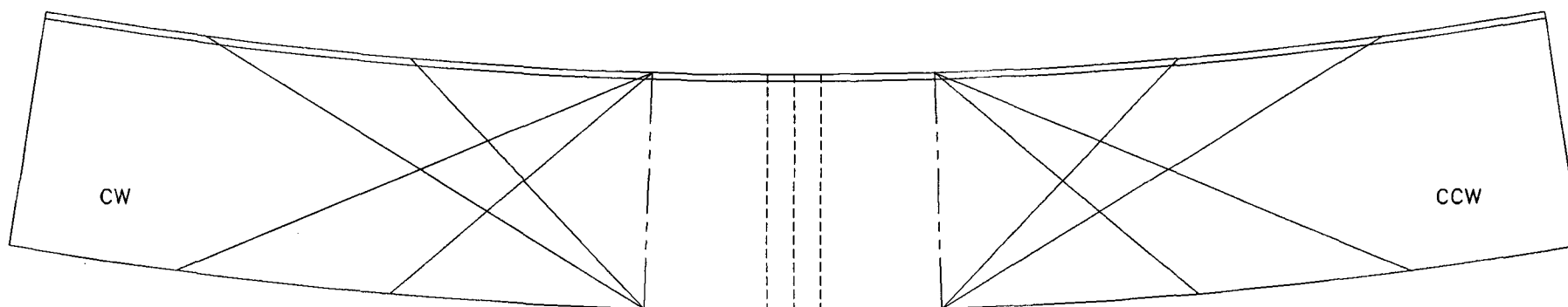
R1165

00141

22 OF 23

00000 00000

21165



798.10"

WELD
C

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

GE NUCLEAR ENERGY

BROWNS FERRY UNIT 3

WELD V-3-C MANUAL PICKUP

SCALE: NONE

DWG. MANV-3-C

REV. 0

00142

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