

TVA

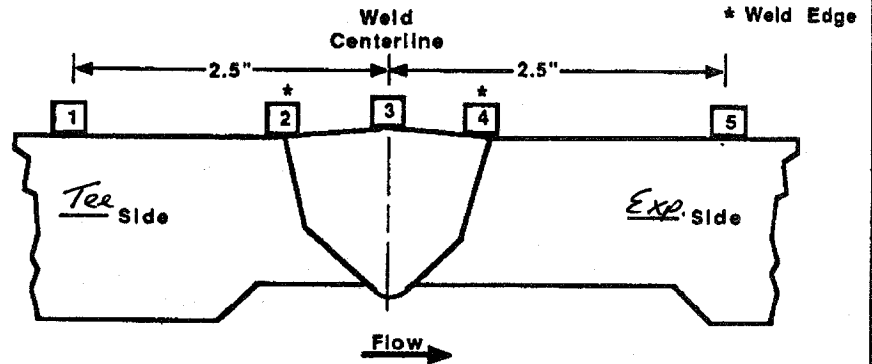
WALL THICKNESS
PROFILE SHEET

REPORT NO:

R-10228

PROJECT: WBNWELD NO: RCF-D145-05UNIT: 2SYSTEM: RCSRecord Thickness Measurements As
Indicated, Including Weld Width,
Edge-To-Edge At 0°

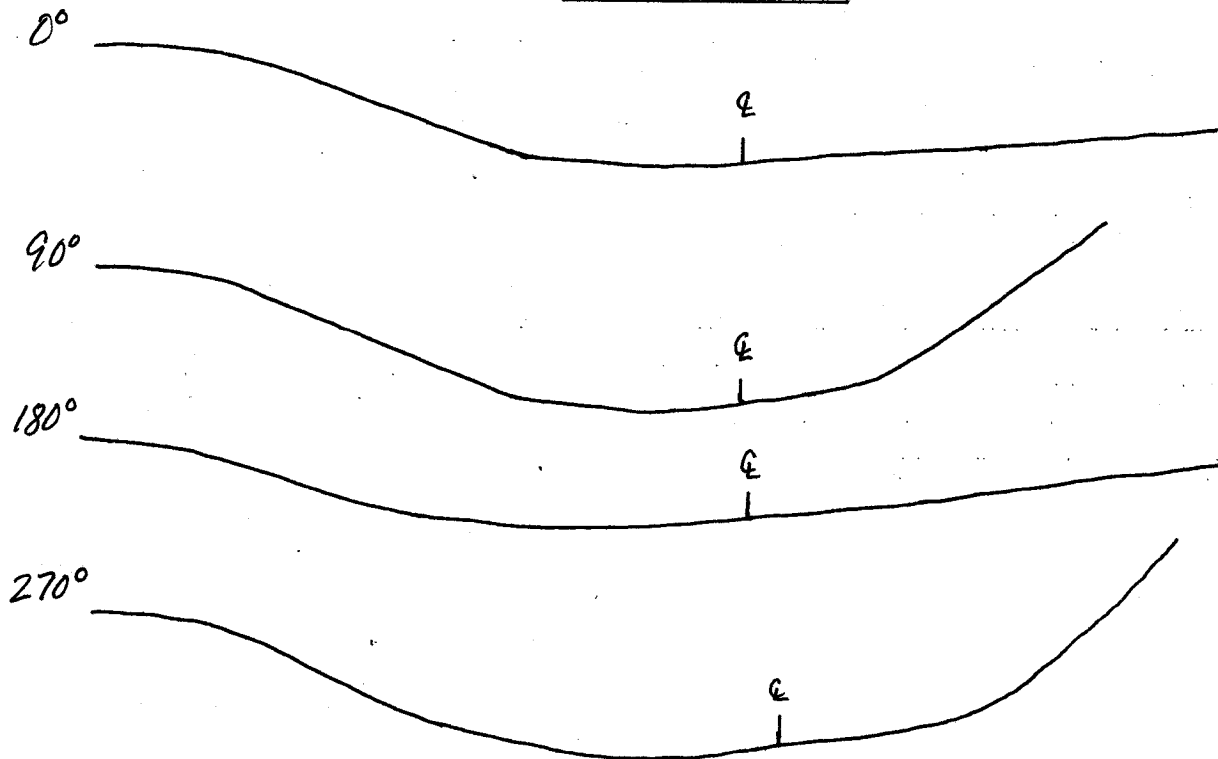
Position	0°	90°	180°	270°
<u>1</u>	.554	.601	.648	.562
<u>2</u>	.521	.541	.549	.545
<u>3</u>	.562	.542	.560	.557
<u>4</u>	.580	.532	.574	.709
<u>5</u>	.710	*	.677	*

CROWN HEIGHT: FLUSHDIAMETER: 4.0CROWN WIDTH: .75WELD LENGTH: 14.5

EXPANDER

FLOW

Tee



* unable to take thickness reading due to expander configuration.

EXAMINER: Jose Alejandro Jimenez
LEVEL: II
DATE: 03-05-09REVIEWED BY: [Signature]
LEVEL: III DATE: 3-11-09ANII: [Signature]
DATE: 3/16/09
PAGE 5 OF 6

TVA

Office of Nuclear Power

PROJECT: WBN SYSTEM: RCS

UNIT: 2 WELD NO: RCF-D145-05

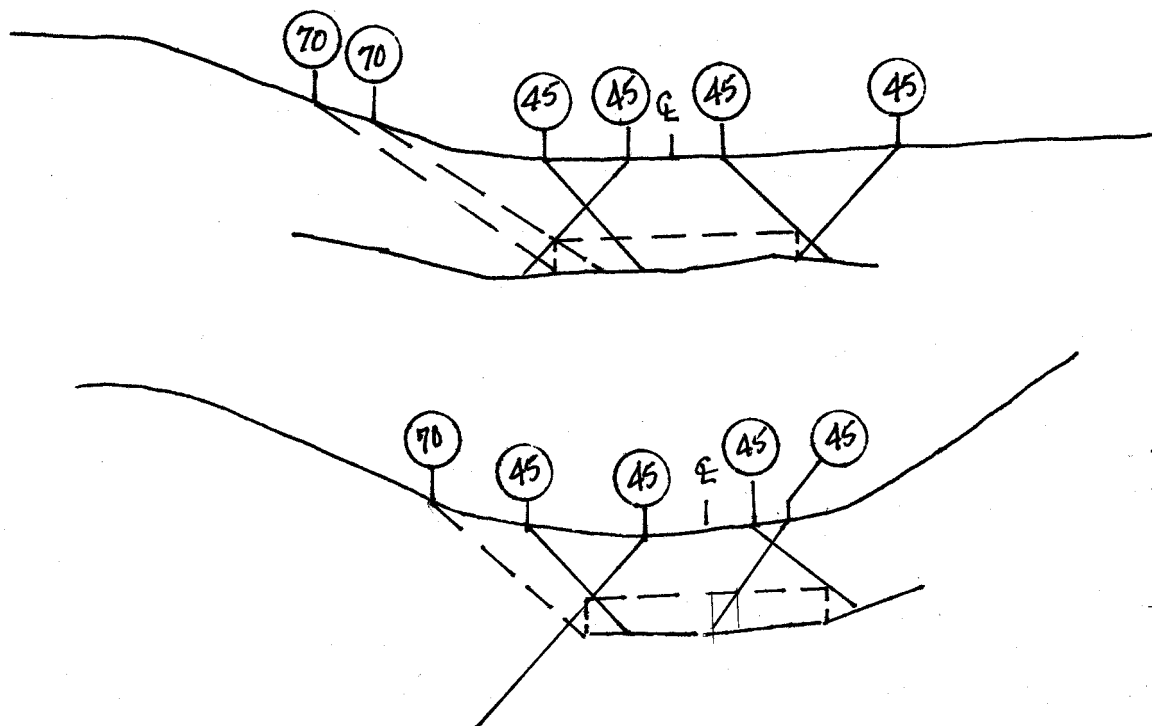
REPORT NO.:

R-P0228

← FLOW

Expander

Tee



Profile at 90° and 270°
Scan 3 limitations
due to Tee geometry.

BY: Jose Alejandro Jose Cepeda LEVEL: II DATE: 03-05-09 PAGE 6 OF 6

NPG Nondestructive Examination Procedure	CALCULATION OF ASME CODE COVERAGE FOR SECTION XI, APPENDIX VIII ULTRASONIC EXAMINATIONS	N-GP-31 Rev. 0002 Page 15 of 24
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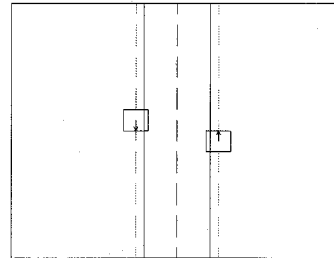
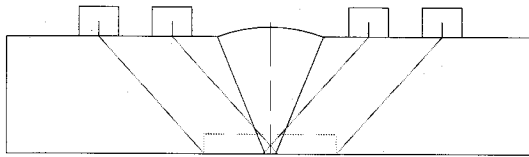
Attachment 3
(Page 1 of 1)

AUSTENITIC PIPING WELDS DUAL SIDE ACCESS - SUPPLEMENT 2

Required and obtained examination volume coverage work sheet

Below is a typical example of examination coverage plots although are not to be considered inclusive of all situations.

Typical example of a dual sided examination, generally the examination volume is the lower 1/3T of the weld metal and 1/4 inch of the adjacent base material.



Weld # RCF-D145-05

W=1.3 H=.2 L=14.5 ✓

Item	Description	Value
REQUIRED EXAMINATION VOLUME		
1	Required examination volume in sq in. (width x height) for single scan stroke	.25
2	Number of scan directions (normally 4; i.e. upst,dnst, cw, & ccw))	4
3	Total scan volume in sq inches (Item 1 * Item 2)	1.04
4	Total length of weld	14.5
5	Total required examination volume in cubic inches (Item 3 * Item 4)	15.08
OBTAINED EXAMINATION VOLUME		
6	Examination volume achieved (sq in for single scan stroke) in 1 axial scanning direction (i.e. upst) multiplied by the length of weld examined	2.25
7	Examination volume achieved (sq in for single scan stroke) in 1 axial scanning direction (i.e. dnst) multiplied by the length of weld examined	3.77
8	Examination volume achieved (sq in for single scan stroke) in 1 circumferential scanning direction (i.e. cw) multiplied by the length of weld examined	3.77
9	Examination volume achieved (sq in for single scan stroke) in 1 circumferential scanning direction (i.e. ccw) multiplied by the length of weld examined	3.77
10	Determine the achieved examination volume by adding Items 6, 7, 8, and 9	13.56
11	Examination volume percentage [(Item 10 / item 5) X 100]	(.899) = 90%

JA

INFORMATION ONLY