

TVA

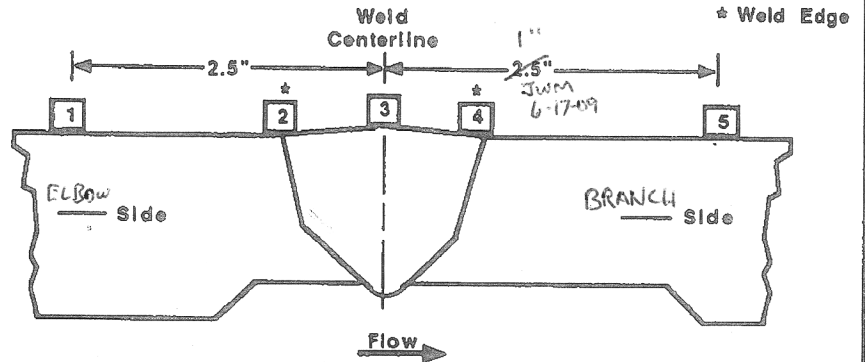
WALL THICKNESS  
PROFILE SHEET

REPORT NO:

R-P0491

PROJECT: WBNWELD NO: SIF-D199-15UNIT: 2SYSTEM: Ø63 (SIS)Record Thickness Measurements As  
Indicated, Including Weld Width,  
Edge-To-Edge At 0°

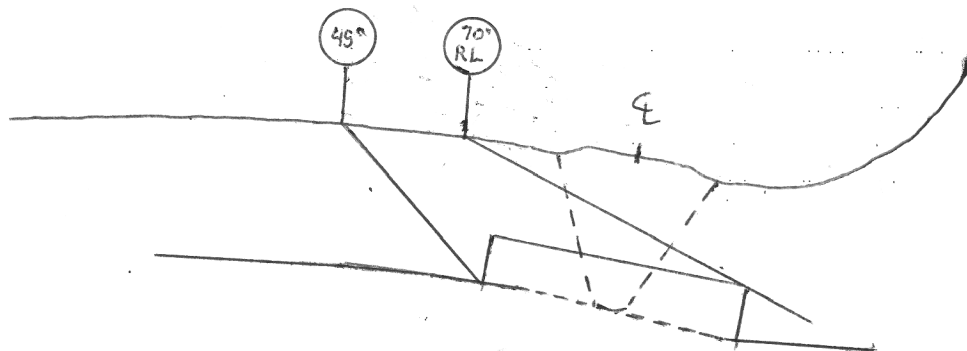
Position	0°	90°	180°	270°
1	.72"	.79"	.87"	.72"
2	.73"	.75"	.80"	.72"
3	.80"	.78"	.82"	.82"
4	.83"	.83"	.79"	.82"
5	N/A	.89"	N/A	.89"

CROWN HEIGHT: < = .0625"DIAMETER: 6"CROWN WIDTH: ~ .85"WELD LENGTH: 21 3/8"

ELBOW

FLOW

BRANCH



EXAMINATION PERFORMED TO QUALIFIED SECTOR SCAN ANGLES OF 35° TO 70° (AX)  
AND 25° TO 70° (CIRC) SHEARWAVE, 40° TO 70° (AX) RL

EXAMINER:

REVIEWED BY:

ANII:

LEVEL:

LEVEL:

DATE:

DATE:

DATE:

PAGE

OF

TVA

Office of Nuclear Power

PROJECT: WBN

SYSTEM: Q63 (S15)

REPORT NO.:

UNIT: 2

WELD NO: SIF-D199-15

R-P0491

ELBOW

FLOW →

BRANCH

0°

ε

90°

180°

270°

BY:

*P. Mahoney*

LEVEL: II

DATE: 6/17/09

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R-P0491

TVA Procedure  
N-GP-31

## Weld # SIF-D199-15

## Attachment 3

Item 1	Required examination Volume in sq. in. (width x height)	1.375	0.26	0.3575	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			1.43	sq. in.
Item 4	Total length of weld			21.375	inches
Item 5	Total required exam volume in cubic inches			30.56625	cu. in.
Item 6	Exam volume achieved (sq. in.) in direction 1 X length of weld achieved	0.3575	21.375	7.6415625	cu. In.
Item 7	Exam volume achieved (sq. in.) in direction 2 X length of weld achieved	0.3575		0	cu. In.
Item 8	Exam volume achieved (sq. in.) in direction 3 X length of weld achieved	0.3575	15.375	5.4965625	cu. In.
Item 9	Exam volume achieved (sq. in.) in direction 4 X length of weld achieved	0.3575	15.375	5.4965625	cu. In.
Item 10	Determined the achivied exam volume add 6, 7, 8 & 9			18.6346875	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			60.96491228	%

At 180 Degrees, Obstruction due to the surface curvature of the "Tee Throat Area" which caused a loss of contact between the wedge & surface of componant.  
This was a single sided examination

*P. Mahoney*  
P. Mahoney

Level:

II

Date:

6/17/09

INFORMATION ONLY