TVA

WALL THICKNESS PROFILE SHEET

REPORT NO: R-P6591

PROJECT: WBN

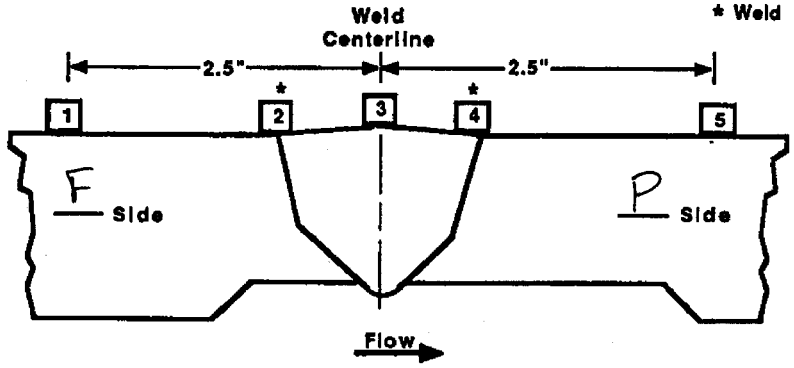
UNIT: 2

WELD NO: 51F-B-T076-23

SYSTEM: SIS (063)

Record Thickness Measurements As Indicated, Including Weld Width, Edge-To-Edge At 0°

Position	0°	90°	180°	270°
1	N/A			
2	.347		N	
3	.260			
4	.264		A	
5	.249			



CROWN HEIGHT: .0625

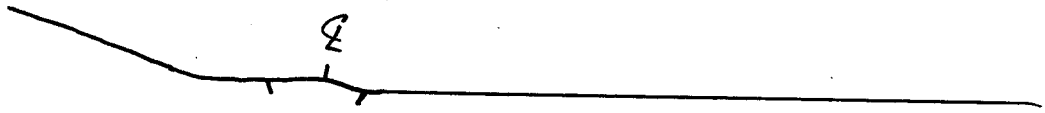
CROWN WIDTH: .5"

DIAMETER: 1.5"

WELD LENGTH: 6.5"

FLANGE

PIPE



FLOW

EXAMINER: [signature]

LEVEL: II

DATE: 6/29/09

REVIEWED BY: [signature]

LEVEL: III DATE: 7-2-09

ANII: [signature]

DATE: 7/26/09

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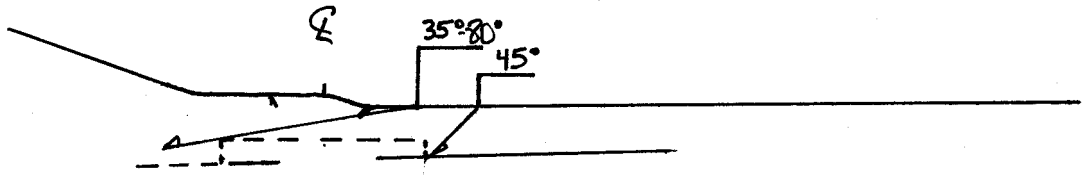
TVA 19668 (NP-5-89)

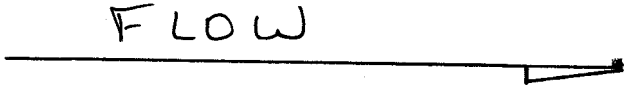
1-108-999-44

TVA Office of Nuclear Power	PROJECT: WBN SYSTEM: SIS (063) UNIT: 2 WELD NO: SIF-B-TD76-23	REPORT NO.: R-P0591

FLANGE

PIPE





EXAMINATION PERFORMED WITH QUALIFIED SECTOR SCAN ANGLES OF 35° TO 80° AX & 35° TO 70° CIRC

BY: Patrick Mahoney LEVEL: II DATE: 6/21/09 PAGE 5 OF 5

R.P0591

TVA Procedure
N-GP-31

Weld # SIF-B-T076-23

Attachment 3

Item 1	Required examination Volume in sq. in. **(width x height)**	1	0.102	0.102 sq. in.
Item 2	Number of **scan directions**			4 directions
Item 3	Total Scan **volume** in sq. in.			0.408 sq. in.
Item 4	Total **length** of weld			6.5 inches
Item 5	Total required **exam volume** in cubic inches			2.652 cu. in.
Item 6	**Exam volume achieved** (sq. in.) in direction 1 X **length of weld achieved**	0.102	6.5	0.663 cu. In.
Item 7	**Exam volume achieved** (sq. in.) in direction 2 X **length of weld achieved**	0.102		0 cu. In.
Item 8	**Exam volume achieved** (sq. in.) in direction 3 X **length of weld achieved**	0.051	6.5	0.3315 cu. In.
Item 9	**Exam volume achieved** (sq. in.) in direction 4 X **length of weld achieved**	0.051	6.5	0.3315 cu. In.
Item 10	Determined the **achivied exam volume** add 6, 7, 8 & 9			1.326 cu. In.
Item 11	Exam **volume percentage** item 10/item 5 x 100			50 %

Directions 3 & 4 (Circ Scan directions 5 & 6) were restricted to pipe side of weld.
This was a single sided examination

Level: II Date: 6/29/09

INFORMATION ONLY