

TVA

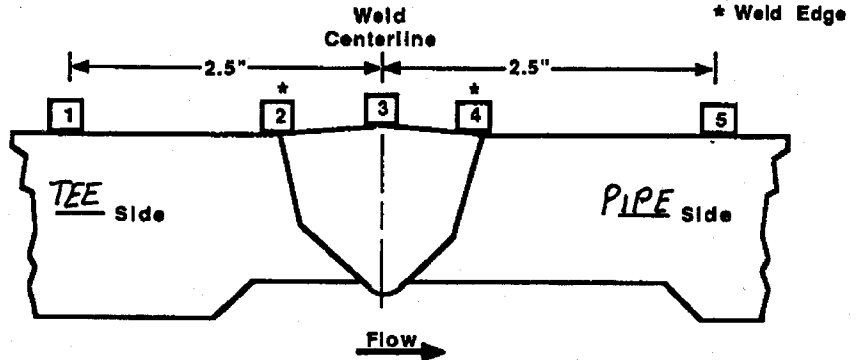
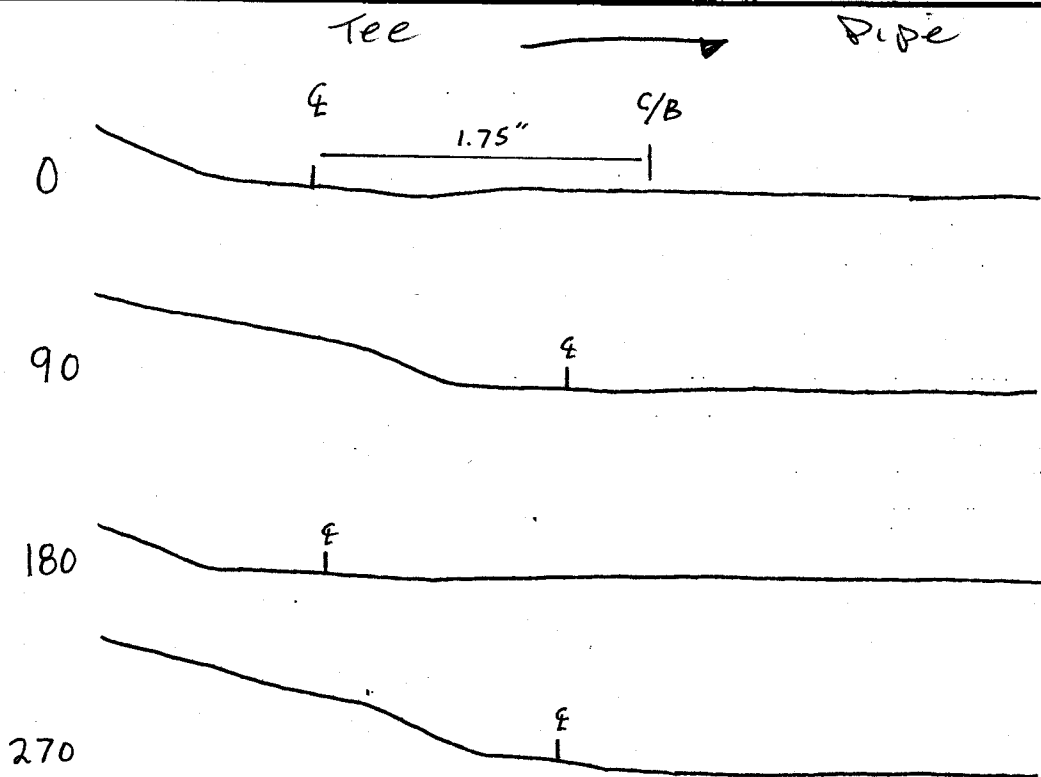
WALL THICKNESS
PROFILE SHEET

REPORT NO:

R-P0930

PROJECT: WBNWELD NO: BHRF-D033-01UNIT: 2SYSTEM: BHBRecord Thickness Measurements As
Indicated, Including Weld Width,
Edge-To-Edge At 0°

Position	0°	90°	180°	270°
1	N/A	1.37	N/A	1.48
2	.87	1.04	.85	.86
3	.93	.90	.90	.91
4	.82	.82	.82	.82
5	.95	.90	.88	.96

CROWN HEIGHT: FLUSHDIAMETER: 8.0CROWN WIDTH: 1.0WELD LENGTH: 27.5EXAMINER: Jason Polensky

JASON

POLSENSKY

REVIEWED BY: [Signature]ANII: [Signature]LEVEL: IILEVEL: IIIDATE: 10/1/09DATE: 10/21/09DATE: 09/09/09PAGE 5 OF 6

TVA

Office of Nuclear Power

PROJECT: WBN

SYSTEM: RHR

UNIT: 2

WELD NO: RHRF-D033-01

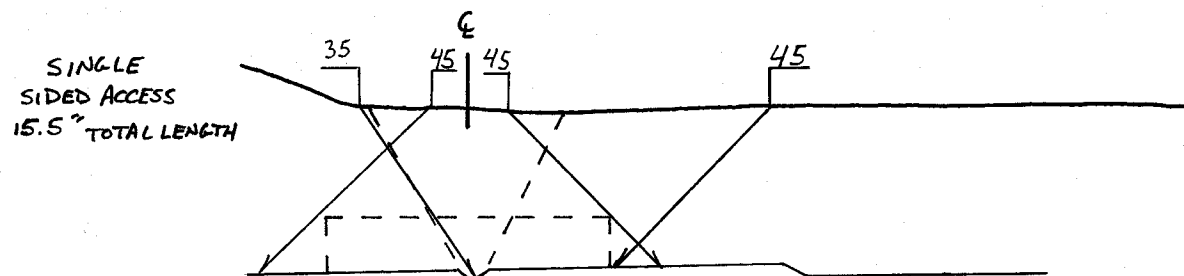
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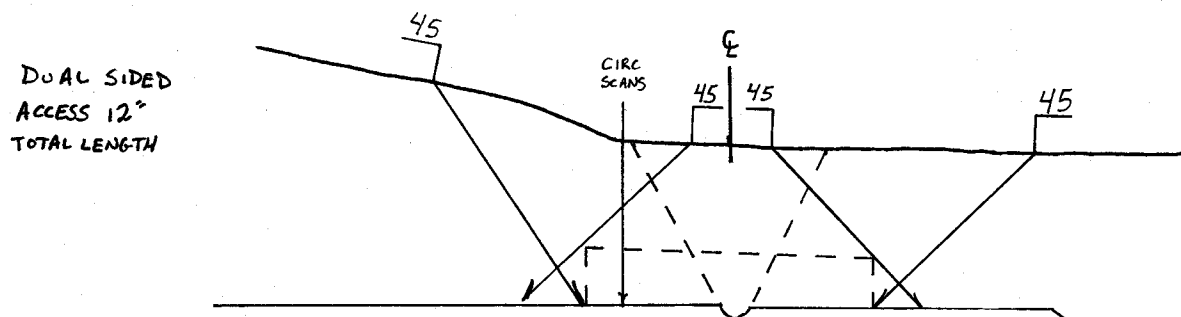
TEE

FLOW

PIPE



DUE TO CONFIGURATION, SCANS 5&6
LIMITED ON PIPE SIDE TO WELD TOE
TEE SIDE.



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

BY: Jason Polisenky JASON POLISENSKY LEVEL: II DATE: 09/09/09 PAGE 6 OF 6

R.P 0930

Watts Bar Unit 2

TVA Procedure N-GP-31
Attachments 3 & 4

Measured
Fields

Calculated
Fields

Worksheet Version 1.0 dated 07/01/09

WELD
NUMBER

RHRF-D033-01

Item 1 Required examination Volume in sq. in.
(width x height) 1.5 0.28 0.42 sq. in.

Item 2 Number of scan directions 4 directions

Item 3 Total Scan volume in sq. in. 1.68 sq. in.

Item 4 Total length of weld 27.5 inches

Item 5 Total required exam volume in cubic inches 46.2 cu. in.

Item 6 Exam volume acheived (sq. in.) in
direction 1 X length of weld achieved * 0.3368 27.5 9.262 cu. In.

Item 7 Exam volume acheived (sq. in.) in
direction 2 X length of weld achieved 0.42 27.5 11.55 cu. In.

Item 8 Exam volume acheived (sq. in.) in
direction 3 X length of weld achieved 0.372 27.5 10.23 cu. In.

Item 9 Exam volume acheived (sq. in.) in
direction 4 X length of weld achieved 0.372 27.5 10.23 cu. In.

Item 10 Determined the acheived exam volume
add 6, 7, 8 & 9 41.272 cu. In.

Item 11 Exam volume percentage item 10/item 5
x 100 89.33 %

Scan 3 limited due to Branch config.
Single sided access 15.5" of 27.5"

* value to achieve caculate 9.26 cu.in. total
scan volume

Initials
JAP

Date

09/09/2009

INFORMATION ONLY