

TVA

WALL THICKNESS
PROFILE SHEET

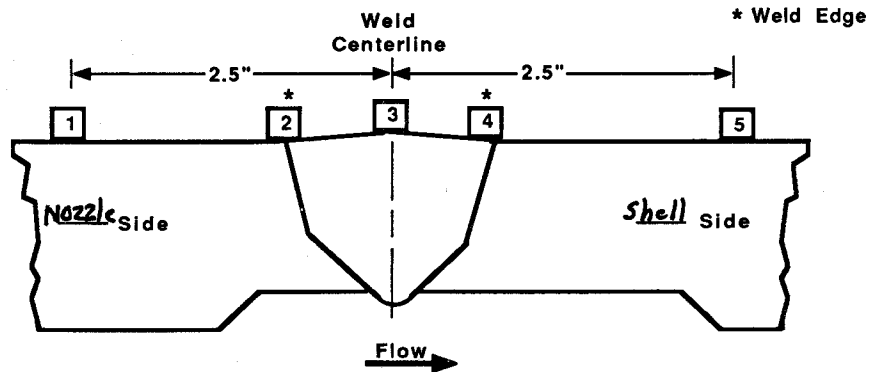
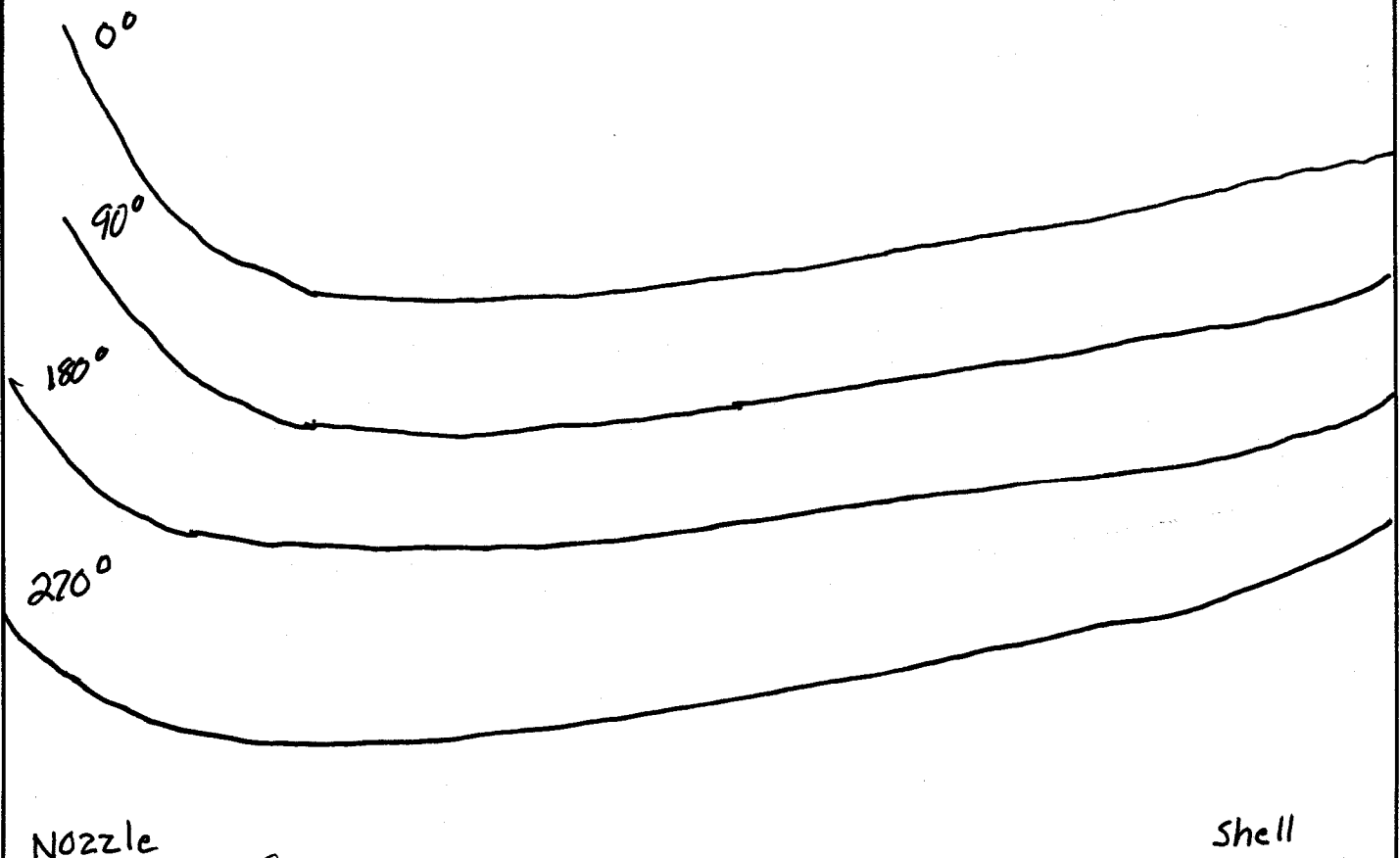
REPORT NO:

R.P1280

PROJECT: WBNWELD NO: WP-15UNIT: 2SYSTEM: PZR

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

Position	0°	90°	180°	270°
1	N/A	N/A	N/A	N/A
2	N/A	N/A	N/A	N/A
3	N/A	N/A	N/A	N/A
4	3.24	3.37	3.30	3.23
5	2.92	3.21	3.22	3.08

CROWN HEIGHT: FlushDIAMETER: 6"CROWN WIDTH: 1.6"WELD LENGTH: 46.7"EXAMINER: Jim ClearyREVIEWED BY: Darlene DwyerANII: mmLEVEL: IILEVEL: IIIDATE: 10-27-10DATE: 1-5-11DATE: 10-19-10PAGE 6 OF 210

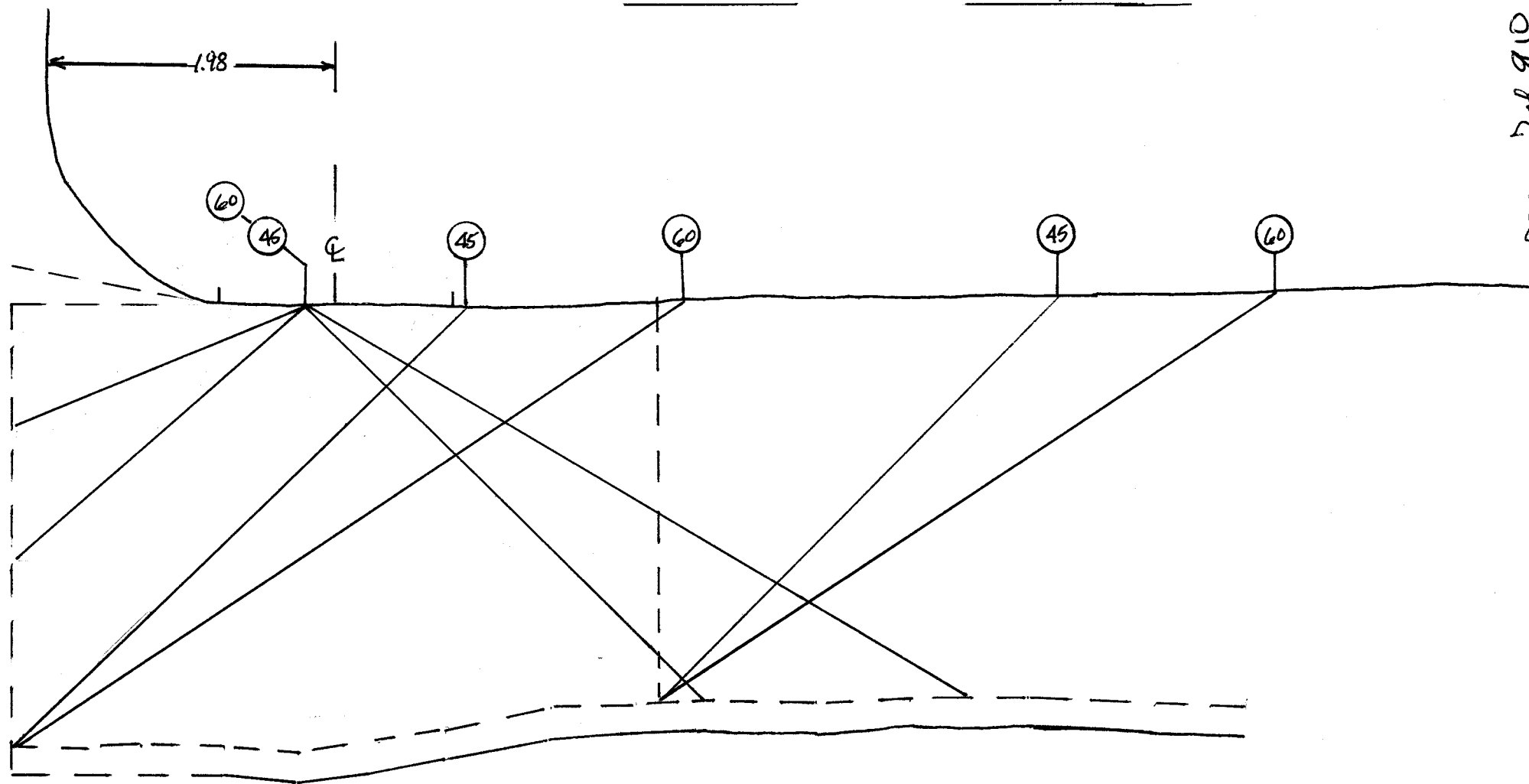
WBN 2

PZR

R.P. 80

WP-15

SAFETY NOZZLE



Page 7 of 910
08/10/21/10

Page

Watts Bar Unit 2

R. P1280

TVA Procedure N-GP-31
Attachments 3 & 4

Measured
Fields

Calculated
Fields

Worksheet Version 1.0 dated 07/01/09

WELD
NUMBER

WP-15 (45 Deg)

Item 1 Required examination Volume in sq. in.
(width x height) 4.4 2.75 12.1 sq. in.

Item 2 Number of scan directions 4 directions

Item 3 Total Scan volume in sq. in. 48.4 sq. in.

Item 4 Total length of weld 46.7 inches

Item 5 Total required exam volume in cubic inches 2260.28 cu. in.

Item 6 Exam volume acheived (sq. in.) in
direction 1 X length of weld achieved 11.5 46.7 537.05 cu. In.

Item 7 Exam volume acheived (sq. in.) in
direction 2 X length of weld achieved 3 46.7 140.1 cu. In.

Item 8 Exam volume acheived (sq. in.) in
direction 3 X length of weld achieved 6.6 46.7 308.22 cu. In.

Item 9 Exam volume acheived (sq. in.) in
direction 4 X length of weld achieved 6.6 46.7 308.22 cu. In.

Item 10 Determined the acheived exam volume
add 6, 7, 8 & 9 1293.59 cu. In.

Item 11 Exam volume percentage item 10/item 5
x 100 57.23 %

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

Page 8 of 9 ID
10-31-10

Watts Bar Unit 2

R.D.1280

TVA Procedure N-GP-31
Attachments 3 & 4

Measured
Fields

Calculated
Fields

Worksheet Version 1.0 dated 07/01/09

**WELD
NUMBER**

WP-15 (60 Deg)

Item 1

Required examination Volume in sq. in.
(width x height)

4.4	2.75	12.1 sq. in.
-----	------	--------------

Item 2

Number of scan directions

4 directions

Item 3

Total Scan volume in sq. in.

48.4 sq. in.

Item 4

Total length of weld

46.7 inches

Item 5

Total required exam volume in cubic inches

2260.28 cu. in.

Item 6

Exam volume acheived (sq. in.) in
direction 1 X length of weld achieved

11.5	46.7	537.05 cu. In.
------	------	----------------

Item 7

Exam volume acheived (sq. in.) in
direction 2 X length of weld achieved

4.49	46.7	209.683 cu. In.
------	------	-----------------

Item 8

Exam volume acheived (sq. in.) in
direction 3 X length of weld achieved

6.6	46.7	308.22 cu. In.
-----	------	----------------

Item 9

Exam volume acheived (sq. in.) in
direction 4 X length of weld achieved

6.6	46.7	308.22 cu. In.
-----	------	----------------

Item 10

Determined the acheived exam volume
add 6, 7, 8 & 9

1363.173 cu. In.

Item 11

Exam volume percentage item 10/item 5
x 100

60.31 %

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

Page 2 of 10
DD 10-31-11

Watts Bar Unit 2

R. P. D80

TVA Procedure N-GP-31
Attachments 3 & 4

Measured Fields	Calculated Fields
-----------------	-------------------

Worksheet Version 1.0 dated 07/01/09

WELD
NUMBER

WP-15 (0 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.75	12.1	sq. in.
--------	--	-----	------	------	---------

Item 2	Number of scan directions	4	directions
--------	---------------------------	---	------------

Item 3	Total Scan volume in sq. in.	48.4	sq. in.
--------	------------------------------	------	---------

Item 4	Total length of weld	46.7	inches
--------	----------------------	------	--------

Item 5	Total required exam volume in cubic inches	2260.28	cu. in.
--------	--	---------	---------

Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
--------	--	--------	------	-----------	---------

Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
--------	--	--------	------	-----------	---------

Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
--------	--	--------	------	-----------	---------

Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
--------	--	--------	------	-----------	---------

Item 10	Determined the acheived exam volume add 6, 7, 8 & 9	1494.867	cu. In.
---------	--	----------	---------

Item 11	Exam volume percentage item 10/item 5 x 100	66.14	%
---------	--	-------	---

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

10 of 10