

TVA

Wall Thickness
Profile Sheet

Report No.

R-P1281

Project: WBN

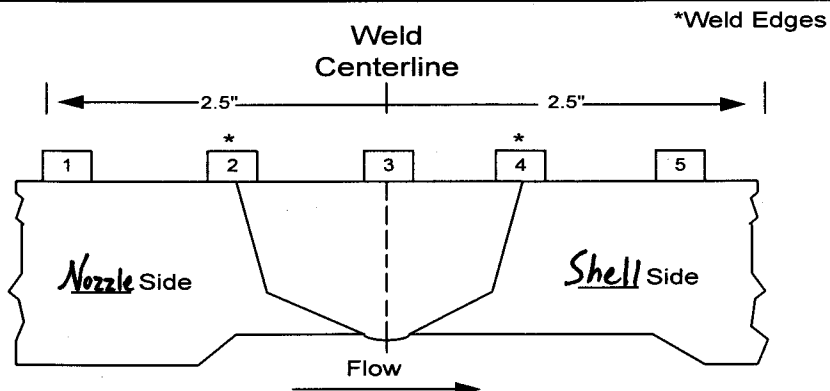
Weld No.: WP-14

Unit: 2

System: 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	3.34	3.24	3.24	3.34
4	3.21	3.15	3.15	3.27
5	2.92	3.07	3.12	3.09

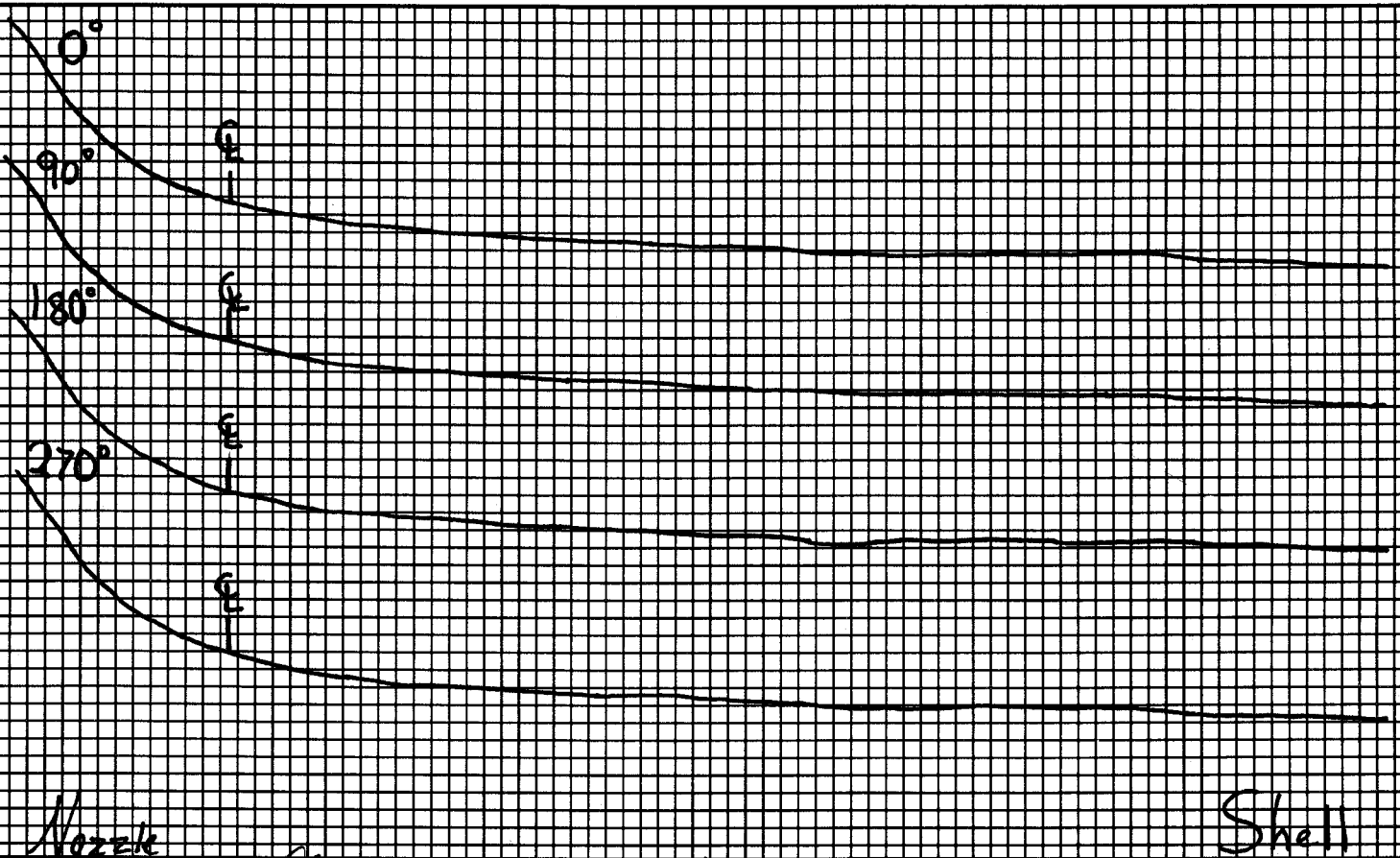


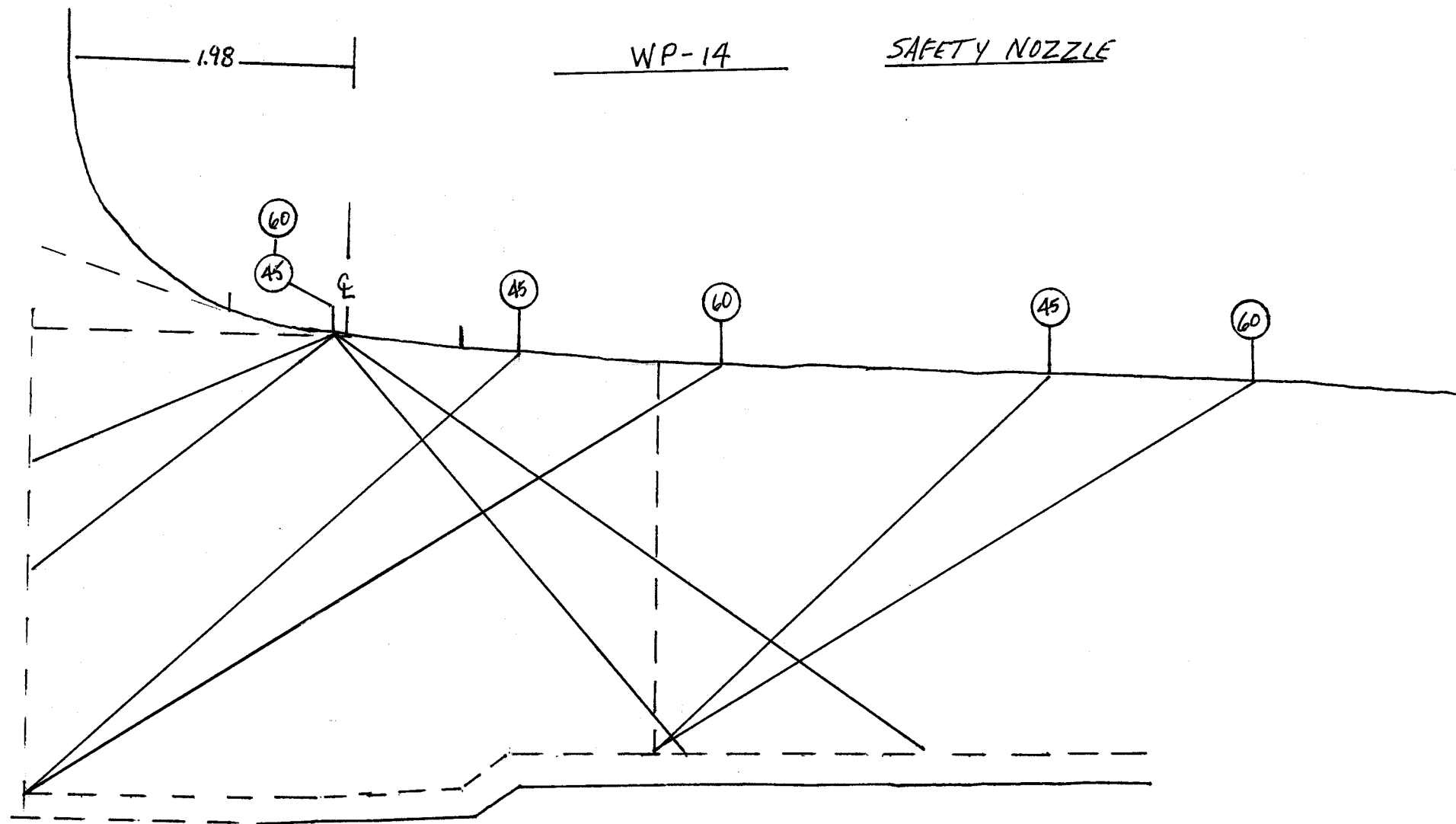
Crown Height: Flush

Diameter: 6"

Crown Width: 1.6"

Weld Length: 46.7"

Examiner: Mike DeFuriaReviewed By: Dorene DoolayANII: noneLevel: IILevel: IIIDate: 10-19-10Date: 10-31-10Date: 1-6-11

WBN 2PZRWP-14SAFETY NOZZLE

Watts Bar Unit 2

R. D1281

TVA Procedure N-GP-31
Attachments 3 & 4

Measured
Fields

Calculated
Fields

Worksheet Version 1.0 dated 07/01/09

WELD
NUMBER

WP-14 (45 Deg)

Item 1

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

4.3	2.7	11.61	sq. in.
-----	-----	-------	---------

Item 2

Number of scan directions

4	directions
---	------------

Item 3

Total Scan volume in sq. in.

46.44	sq. in.
-------	---------

Item 4

Total length of weld

46.7	inches
------	--------

Item 5

Total required exam volume in cubic
inches

2168.748	cu. in.
----------	---------

Item 6

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

9.93	46.7	463.731	cu. In.
------	------	---------	---------

Item 7

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

5.1525	46.7	240.62175	cu. In.
--------	------	-----------	---------

Item 8

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

6.075	46.7	283.7025	cu. In.
-------	------	----------	---------

Item 9

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

6.075	46.7	283.7025	cu. In.
-------	------	----------	---------

Item 10

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

1271.7578	cu. In.
-----------	---------

Item 11

Exam volume percentage item 10/item 5
x 100

58.64	%
-------	---

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010

8 of 10

Watts Bar Unit 2

TVA Procedure N-GP-31
Attachments 3 & 4Measured
FieldsCalculated
Fields

Worksheet Version 1.0 dated 07/01/09

WELD
NUMBER

WP-14 (60 Deg)

Item 1

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

4.3

2.7

11.61 sq. in.

Item 2

Number of scan directions

4

directions

Item 3

Total Scan volume in sq. in.

46.44 sq. in.

Item 4

Total length of weld

46.7 inches

Item 5

Total required exam volume in cubic
inches

2168.748 cu. in.

Item 6

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

10.665

46.7

498.0555 cu. In.

Item 7

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

2.53425

46.7

118.34948 cu. In.

Item 8

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

6.075

46.7

283.7025 cu. In.

Item 9

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

6.075

46.7

283.7025 cu. In.

Item 10

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

1183.81 cu. In.

Item 11

Exam volume percentage item 10/item 5
x 100

54.58 %

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010

R.D1281

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**

WP-14 (0 Deg)

Item 1

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

4.3	2.7	11.61	sq. in.
-----	-----	-------	---------

Item 2

Number of scan directions

4	directions
---	------------

Item 3

Total Scan volume in sq. in.

46.44	sq. in.
-------	---------

Item 4

Total length of weld

46.7	inches
------	--------

Item 5

Total required exam volume in cubic
inches

2168.748	cu. in.
----------	---------

Item 6

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

7.425	46.7	346.7475	cu. In.
-------	------	----------	---------

Item 7

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

7.425	46.7	346.7475	cu. In.
-------	------	----------	---------

Item 8

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

7.425	46.7	346.7475	cu. In.
-------	------	----------	---------

Item 9

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

7.425	46.7	346.7475	cu. In.
-------	------	----------	---------

Item 10

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

1386.99	cu. In.
---------	---------

Item 11

Exam volume percentage item 10/item 5
x 100

63.95	%
-------	---

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010

10 d10