

TVA

WALL THICKNESS
PROFILE SHEET

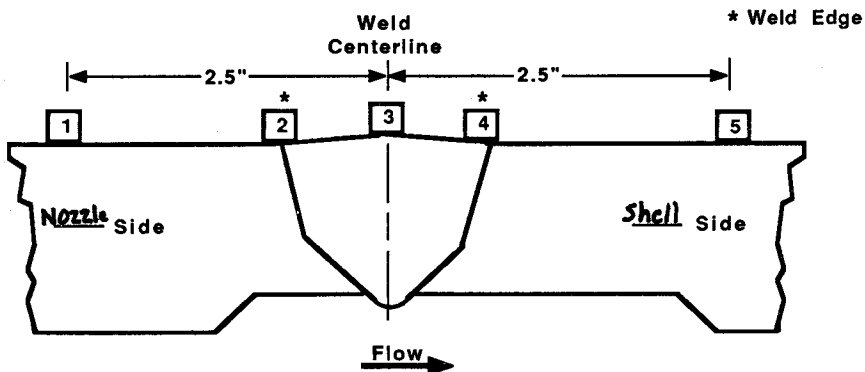
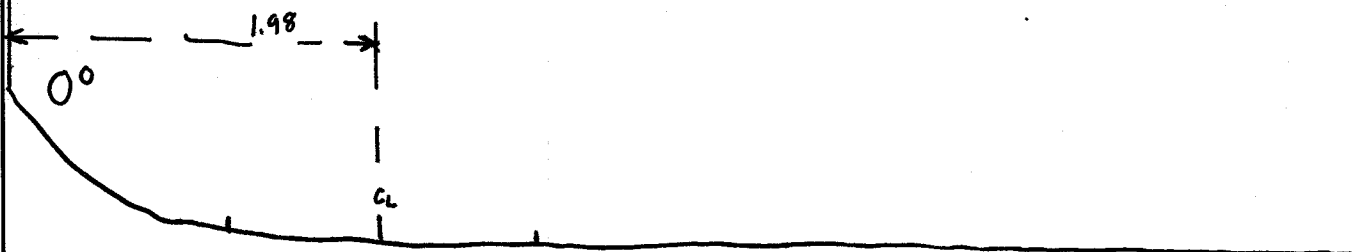
REPORT NO:

R.P1282

PROJECT: WBNWELD NO: WP-12UNIT: 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	3.93	3.54	3.29	3.55
4	3.28	3.41	3.19	3.31
5	2.96	3.14	3.31	3.07

CROWN HEIGHT: FlushDIAMETER: 6"CROWN WIDTH: 1.6"WELD LENGTH: 46.7Relief Nozzle

NOZZLE

Shell

EXAMINER: [Signature]REVIEWED BY: [Signature]ANII: [Signature]LEVEL: IILEVEL: LUDATE: 10-31-10DATE: 1-6-11DATE: 10-19-10PAGE 6 OF 10

08014.0

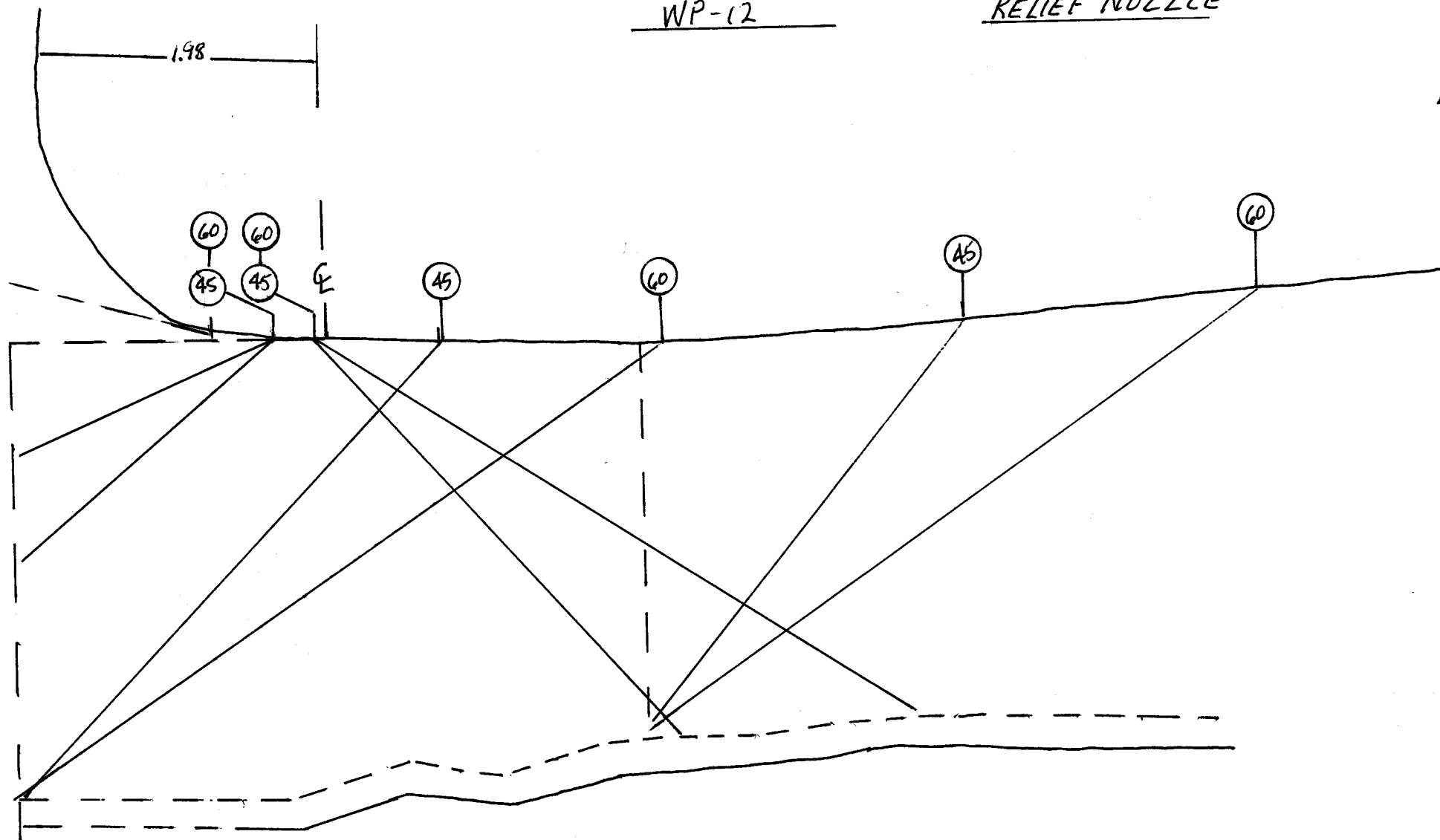
WBN 2

PZR

WP-12

RELIEF NOZZLE

08014



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-12 (60 Deg)

Item 1

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

4.4

2.8

12.32 sq. in.

Item 2

Number of scan directions

4 directions

Item 3

Total Scan volume in sq. in.

49.28 sq. in.

Item 4

Total length of weld

46.7 inches

Item 5

Total required exam volume in cubic
inches

2301.376 cu. in.

Item 6

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

11.58

46.7

540.786 cu. In.

Item 7

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

6.3843

46.7

298.14681 cu. In.

Item 8

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

5.7625

46.7

269.10875 cu. In.

Item 9

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

5.7625

46.7

269.10875 cu. In.

Item 10

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

1377.1503 cu. In.

Item 11

Exam volume percentage item 10/item 5
x 100

59.84 %

Scan limitation due to Nozzle configuration

Initials
JADate
10/25/2010

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-12 (45 Deg)

Item 1

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

4.4

2.8

12.32 sq. in.

Item 2

Number of scan directions

4 directions

Item 3

Total Scan volume in sq. in.

49.28 sq. in.

Item 4

Total length of weld

46.7 inches

Item 5

Total required exam volume in cubic
inches

2301.376 cu. in.

Item 6

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

10.9325

46.7

510.54775 cu. In.

Item 7

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

2.645

46.7

123.5215 cu. In.

Item 8

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

5.7625

46.7

269.10875 cu. In.

Item 9

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

5.7625

46.7

269.10875 cu. In.

Item 10

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

1172.2868 cu. In.

Item 11

Exam volume percentage item 10/item 5
x 100

50.94 %

Scan limitation due to Nozzle configuration

Initials
JADate
10/25/2010

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-12 (0 Deg)

Item 1

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

4.4

2.8

12.32 sq. in.

Item 2

Number of scan directions

4 directions

Item 3

Total Scan volume in sq. in.

49.28 sq. in.

Item 4

Total length of weld

46.7 inches

Item 5

Total required exam volume in cubic
inches

2301.376 cu. in.

Item 6

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

8.12

46.7

379.204 cu. In.

Item 7

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

8.12

46.7

379.204 cu. In.

Item 8

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

8.12

46.7

379.204 cu. In.

Item 9

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

8.12

46.7

379.204 cu. In.

Item 10

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

1516.816 cu. In.

Item 11

Exam volume percentage item 10/item 5
x 100

65.91 %

Scan limitation due to Nozzle configuration

Initials
JADate
10/25/2010