

TVA

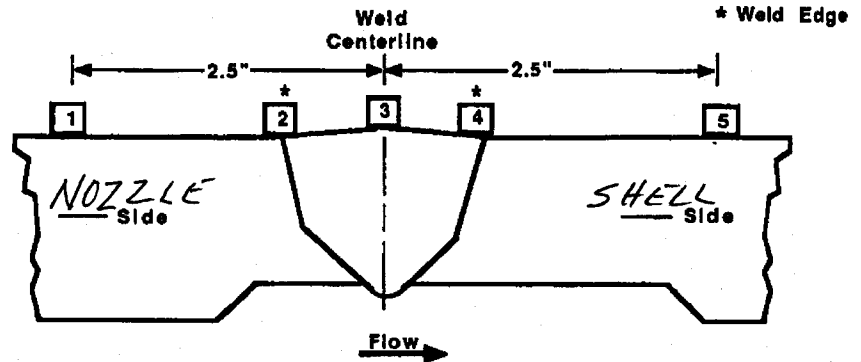
WALL THICKNESS
PROFILE SHEET

REPORT NO:

R.1283

PROJECT: WBN
UNIT: 2WELD NO: WP-11
SYSTEM: PZRRecord Thickness Measurements As
Indicated, Including Weld Width,
Edge-To-Edge At 0°

Position	0°	90°	180°	270°
<u>1</u>	*	*	*	*
<u>2</u>	3.61	3.68	3.61	3.68
<u>3</u>	3.11	3.44	3.15	3.02
<u>4</u>	2.97	3.13	3.06	3.07
<u>5</u>	2.79	2.84	2.82	2.82

CROWN HEIGHT: FLUSH DIAMETER: ~~4.0~~ 6.0
CROWN WIDTH: 1.6 WELD LENGTH: 39.8SPRAY NOZZLE

1.9

4

* No thickness reading taken on nozzle side.

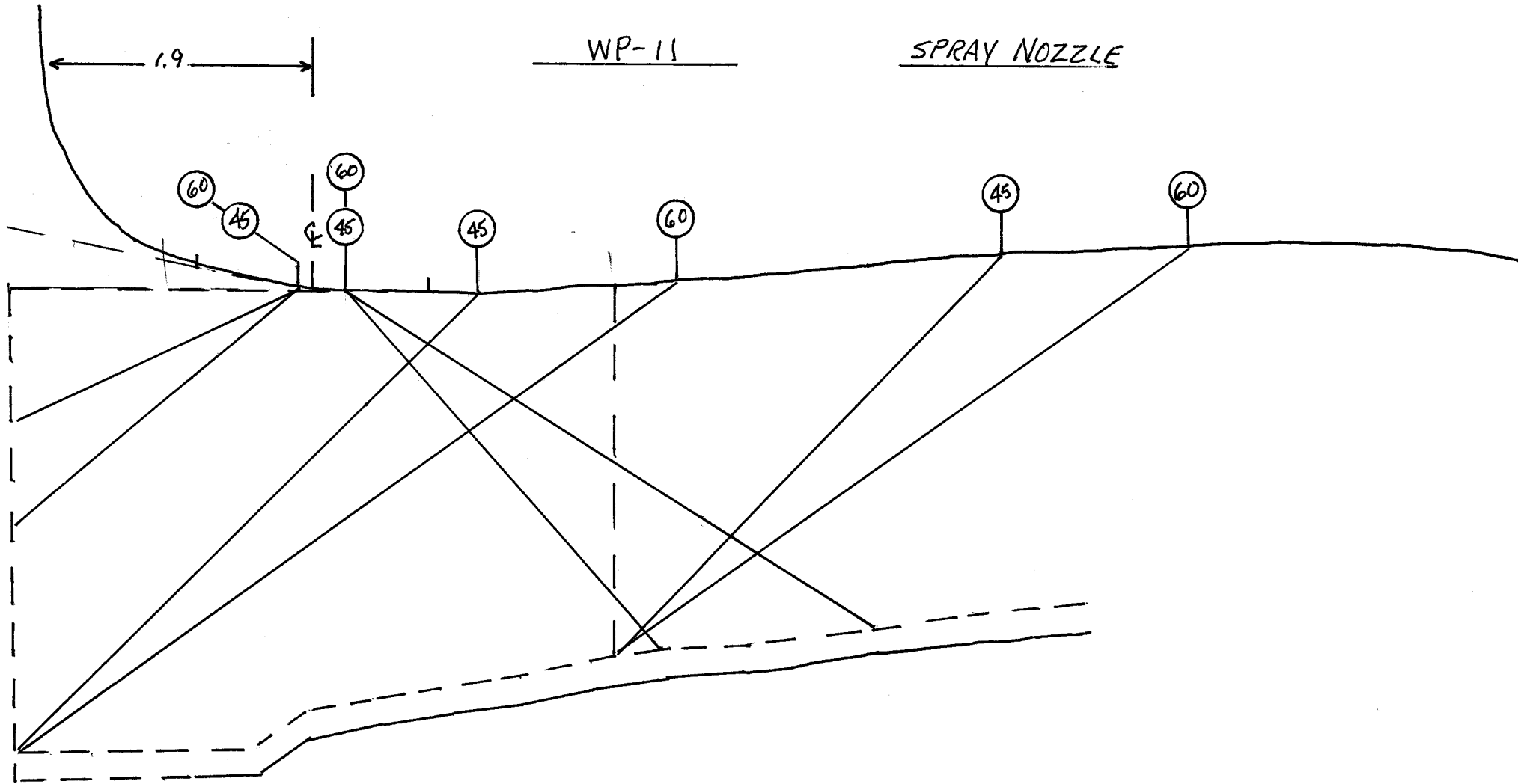
EXAMINER: Joe Clemente
LEVEL: II
DATE: 10-19-10REVIEWED BY: Dan Dineen
LEVEL: III DATE: 10-31-10ANII: MM
DATE: 1-6-10
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WBN 2

PZR

WP-11

SPRAY NOZZLE



R.P1283

7410

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-11 (60 Deg)

Item 1

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

4.2

2.6

10.92 sq. in.

Item 2

Number of scan directions

4 directions

Item 3

Total Scan volume in sq. in.

43.68 sq. in.

Item 4

Total length of weld

39.7 inches

Item 5

Total required exam volume in cubic
inches

1734.096 cu. in.

Item 6

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

10.638

39.7

422.3286 cu. In.

Item 7

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

8.56125

39.7

339.88163 cu. In.

Item 8

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

5.72

39.7

227.084 cu. In.

Item 9

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

5.72

39.7

227.084 cu. In.

Item 10

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

1216.3782 cu. In.

Item 11

Exam volume percentage item 10/item 5
x 100

70.14 %

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010

R.D.1283

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-11 (45 Deg)

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

4.2	2.6	10.92
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sq. in.

Item 2 Number of scan directions

4

directions

Item 3 Total Scan volume in sq. in.

43.68

sq. in.

Item 4 Total length of weld

39.7

inches

Item 5 Total required exam volume in cubic inches

1734.096

cu. in.

Item 6 Exam volume acheived (sq. in.) in
direction 1 X length of weld achieved

8.62	39.7	342.214
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cu. In.

Item 7 Exam volume acheived (sq. in.) in
direction 2 X length of weld achieved

8.56125	39.7	339.88163
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cu. In.

Item 8 Exam volume acheived (sq. in.) in
direction 3 X length of weld achieved

5.72	39.7	227.084
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cu. In.

Item 9 Exam volume acheived (sq. in.) in
direction 4 X length of weld achieved

5.72	39.7	227.084
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cu. In.

Item 10 Determined the acheived exam volume
add 6, 7, 8 & 9

1136.2636

cu. In.

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

65.52

%

Scan limitation due to Nozzle configuration

Initials
JADate
10/25/2010

a 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-11 (0 Deg)

Item 1

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

4.2

2.6

10.92 sq. in.

Item 2

Number of scan directions

4

directions

Item 3

Total Scan volume in sq. in.

43.68 sq. in.

Item 4

Total length of weld

39.7 inches

Item 5

Total required exam volume in cubic
inches

1734.096 cu. in.

Item 6

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

7.8

39.7

309.66 cu. in.

Item 7

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

7.8

39.7

309.66 cu. in.

Item 8

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

7.8

39.7

309.66 cu. in.

Item 9

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

7.8

37.7

294.06 cu. in.

Item 10

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

1223.04 cu. in.

Item 11

Exam volume percentage item 10/item 5
x 100

70.53 %

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010