

TVA

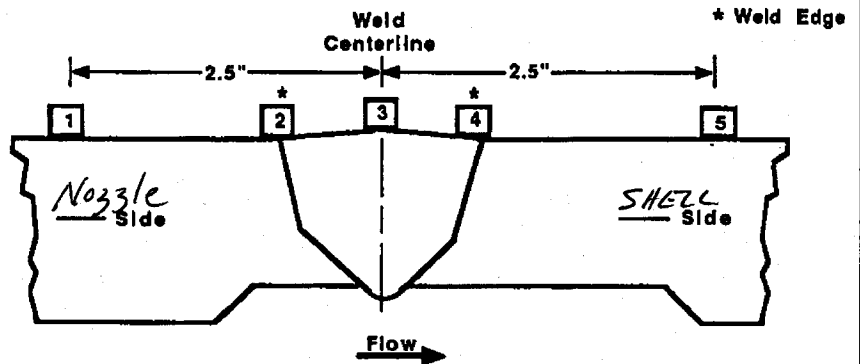
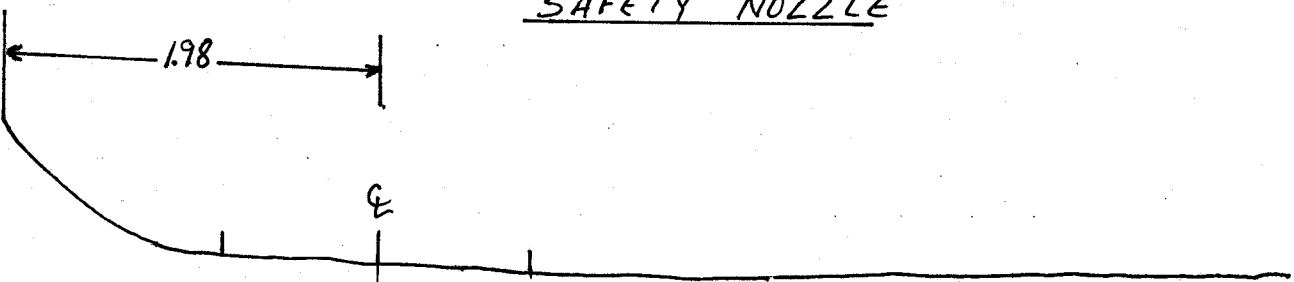
WALL THICKNESS  
PROFILE SHEET

REPORT NO:

R.P.1284

PROJECT: WBN  
UNIT: 2WELD NO: WP-13  
SYSTEM: PZRRecord Thickness Measurements As  
Indicated, Including Weld Width,  
Edge-To-Edge At 0°

Position	0°	90°	180°	270°
1	*	*	*	*
2	3.35	3.44	3.22	3.17
3	3.09	3.29	3.25	3.22
4	2.97	3.24	3.18	3.16
5	2.92	3.14	3.21	3.05

CROWN HEIGHT: FLUSH DIAMETER: 6.0  
CROWN WIDTH: 1.6 WELD LENGTH: 46.7SAFETY NOZZLE

\* No thickness readings taken on nozzle side.

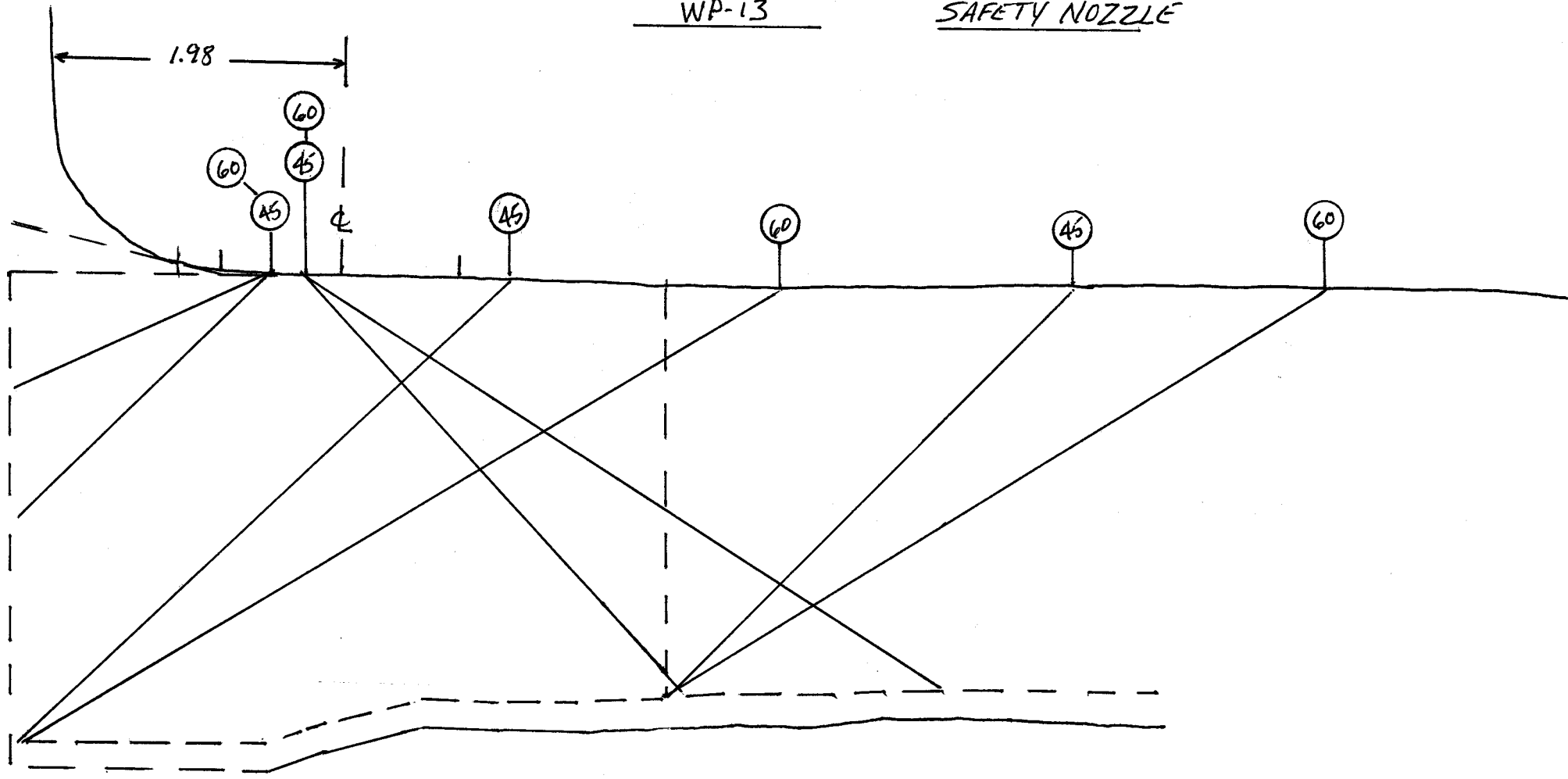
EXAMINER: Joe Clemente  
LEVEL: II  
DATE: 10-19-10REVIEWED BY: Donna Duff  
LEVEL: III DATE: 10-31-10ANII: mm  
DATE: 1-6-11  
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WBN 2

PZR

WP-13

SAFETY NOZZLE



# Watts Bar Unit 2

R.D1284

TVA Procedure N-GP-31  
Attachments 3 & 4

Measured Fields	Calculated Fields
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Worksheet Version 1.0 dated 07/01/09

**WELD  
NUMBER**

WP-13 ( 45 Deg )

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.7	11.88	sq. in.
Item 2	Number of <b>scan directions</b>			4	directions
Item 3	Total Scan <b>volume</b> in sq. in.			47.52	sq. in.
Item 4	Total <b>length</b> of weld			46.7	inches
Item 5	Total required <b>exam volume</b> in cubic inches			2219.184	cu. in.
Item 6	<b>Exam volume acheived</b> (sq. in.) in direction 1 X <b>length of weld achieved</b>	10.23	46.7	477.741	cu. In.
Item 7	<b>Exam volume acheived</b> (sq. in.) in direction 2 X <b>length of weld achieved</b>	3.24	46.7	151.308	cu. In.
Item 8	<b>Exam volume acheived</b> (sq. in.) in direction 3 X <b>length of weld achieved</b>	6.48	46.7	302.616	cu. In.
Item 9	<b>Exam volume acheived</b> (sq. in.) in direction 4 X <b>length of weld achieved</b>	6.48	46.7	302.616	cu. In.
Item 10	Determined the <b>acheived exam volume</b> add 6, 7, 8 & 9			1234.281	cu. In.
Item 11	<b>Exam volume percentage</b> item 10/item 5 x 100			55.62	%

Scan limitation due to Nozzle configuration

**Initials**  
JA

**Date**  
10/25/2010

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# Watts Bar Unit 2

R. P. 684

TVA Procedure N-GP-31  
Attachments 3 & 4

Measured Fields	Calculated Fields
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Worksheet Version 1.0 dated 07/01/09

WELD  
NUMBER

WP-13 ( 60 Deg )

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.7	11.88	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			47.52	sq. in.
Item 4	Total length of weld			46.7	inches
Item 5	Total required exam volume in cubic inches			2219.184	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	10.3225	46.7	482.06075	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	0.365	46.7	17.0455	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	6.48	46.7	302.616	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	6.48	46.7	302.616	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1104.3383	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			49.76	%

Scan limitation due to Nozzle configuration

Initials  
JA

Date  
10/25/2010

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# Watts Bar Unit 2

R.P1284

TVA Procedure N-GP-31  
Attachments 3 & 4

Measured Fields	Calculated Fields
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Worksheet Version 1.0 dated 07/01/09

**WELD  
NUMBER**

WP-13 (0 Deg)

Item 1

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

4.4	2.7	11.88 sq. in.
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Item 2

Number of **scan directions**

4 directions
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Item 3

Total Scan **volume** in sq. in.

47.52 sq. in.
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Item 4

Total **length** of weld

46.7 inches
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Item 5

Total required **exam volume** in cubic  
inches

2219.184 cu. in.
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Item 6

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

8.64	46.7	403.488 cu. In.
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Item 7

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

8.64	46.7	403.488 cu. In.
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Item 8

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

8.64	46.7	403.488 cu. In.
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Item 9

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

8.64	46.7	403.488 cu. In.
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Item 10

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

1613.952 cu. In.
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Item 11

**Exam volume percentage** item 10/item 5  
x 100

<b>72.73</b> %
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Scan limitation due to Nozzle configuration

**Initials**  
JA

**Date**  
10/25/2010

Wof10