TVA

WALL THICKNESS PROFILE SHEET

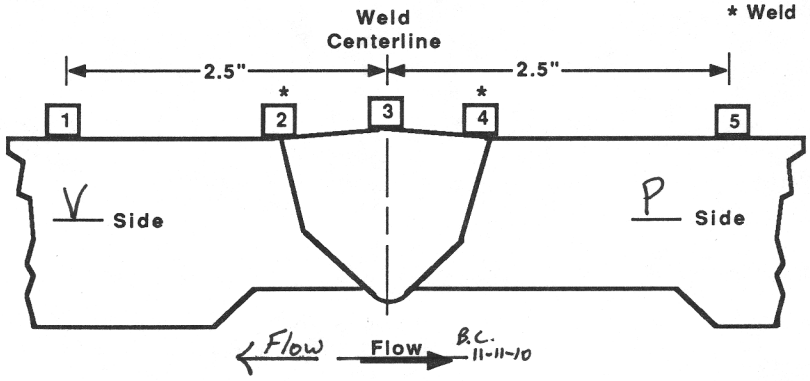
REPORT NO: R-P1328

PROJECT: WBN
UNIT: 2

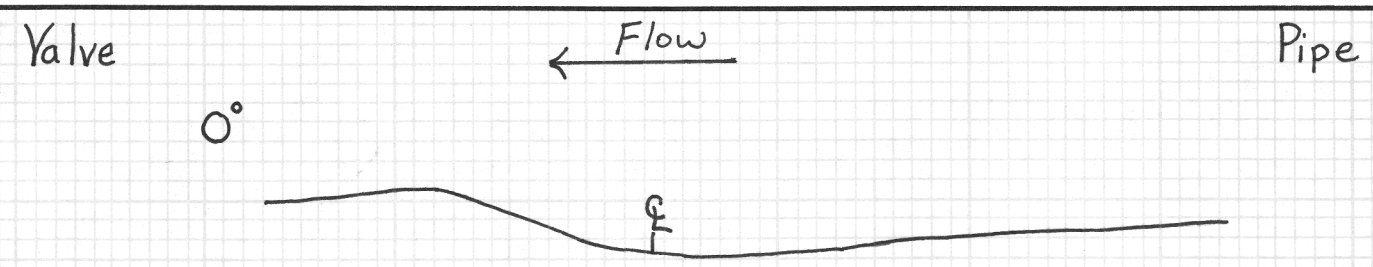
WELD NO: RCF-D145-03
SYSTEM: RCS

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	.522	N/A	.484	.548
4	.453	.484	.470	.525
5	.513	.534	.525	.479



CROWN HEIGHT: Flush
CROWN WIDTH: .6"
DIAMETER: 4"
WELD LENGTH: 14.25"



EXAMINER: Brandon Calvery
LEVEL: II-L
DATE: 11-23-10

REVIEWED BY: Darlene Dudley
LEVEL: III DATE: 12-4-10

ANII: B. Earnigh
DATE: 11/27/11

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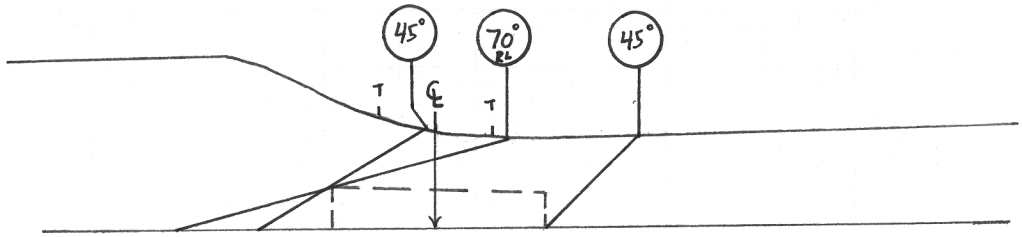
TVA Office of Nuclear Power	PROJECT: WBN SYSTEM: RCS Unit: 2 WELD NO.: RCF-D145-03	REPORT NO.: R.P 1328

FLOW

$\frac{3.33"ID}{4.35"OD}$ = .76 RATIO = 49.9° MAX CIRC

VALVE



PIPE

EXAMINATION PERFORMED TO QUALIFIED SECTOR SCAN ANGLES OF 35° TO 70° AX & 25° TO 70° CIRC (SHEAR),
40° TO 70° AX (R.L.)

BY: Brandon Calvery LEVEL: II DATE: 11-23-10 PAGE 7 OF 8

Watts Bar Unit 2

R.P 1328

TVA Procedure N-GP-31
Attachments 3 & 4

Worksheet Version 1.0 dated 07/01/09

		Measured Fields		Calculated Fields	
WELD NUMBER	RCF-D145-03				
Item 1	Required examination Volume in sq. in. **(width x height)**	1.1	0.18	0.198	sq. in.
Item 2	Number of **scan directions**			4	directions
Item 3	Total Scan **volume** in sq. in.			0.792	sq. in.
Item 4	Total **length** of weld			14.25	inches
Item 5	Total required **exam volume** in cubic inches			11.286	cu. in.
Item 6	**Exam volume acheived** (sq. in.) in direction 1 X **length of weld achieved**	0.198	14.25	2.8215	cu. In.
Item 7	**Exam volume acheived** (sq. in.) in direction 2 X **length of weld achieved**	0	14.25	0	cu. In.
Item 8	**Exam volume acheived** (sq. in.) in direction 3 X **length of weld achieved**	0.099	14.25	1.41075	cu. In.
Item 9	**Exam volume acheived** (sq. in.) in direction 4 X **length of weld achieved**	0.099	14.25	1.41075	cu. In.
Item 10	Determined the **acheived exam volume** add 6, 7, 8 & 9			5.643	cu. In.
Item 11	Exam **volume percentage** item 10/item 5 x 100			**50.00**	%

Scan # 4, 5 & 6 limitation due to valve configuration.

Initials
JAP

Date
11/23/2010