R.P1379

TVA

WALL THICKNESS PROFILE SHEET

REPORT NO: T&C 0400

PROJECT: WBN

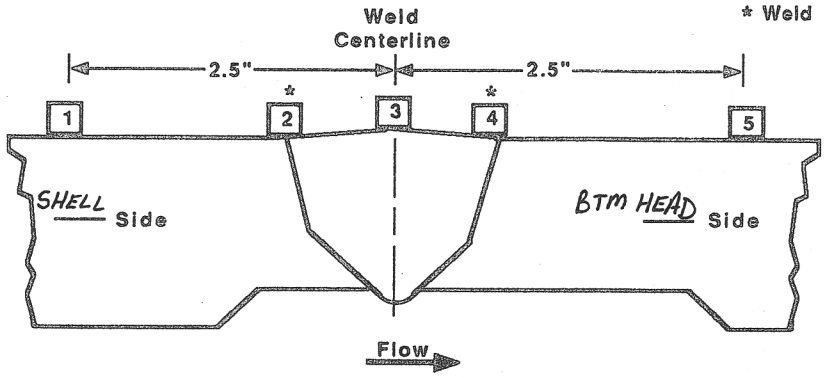
UNIT: 2

WELD NO: RHRHX-1-2B

SYSTEM: RHR

Record Thickness Measurements As Indicated, Including Weld Width, Edge-To-Edge At 0°

Position	0°	90°	180°	270°
1	1.03"			
2	1.04"		N	
3	1.08"			A
4	1.05"			
5	.98"			



CROWN HEIGHT: .10"

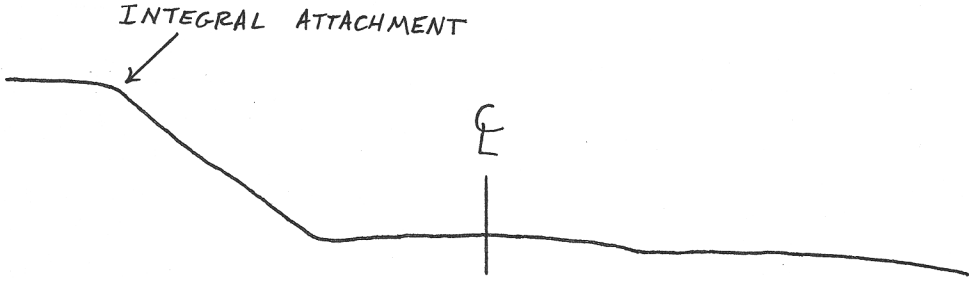
CROWN WIDTH: 1.60"

DIAMETER: 37

WELD LENGTH: 118.5

SHELL

BTM HEAD



EXAMINER: Mary L. Sable CLAY SOHLER

LEVEL: II

DATE: 1/5/11

REVIEWED BY: Darlene Dudley

LEVEL: III DATE: 1-10-11

ANII: B. Eamigh

DATE: 2/5/14

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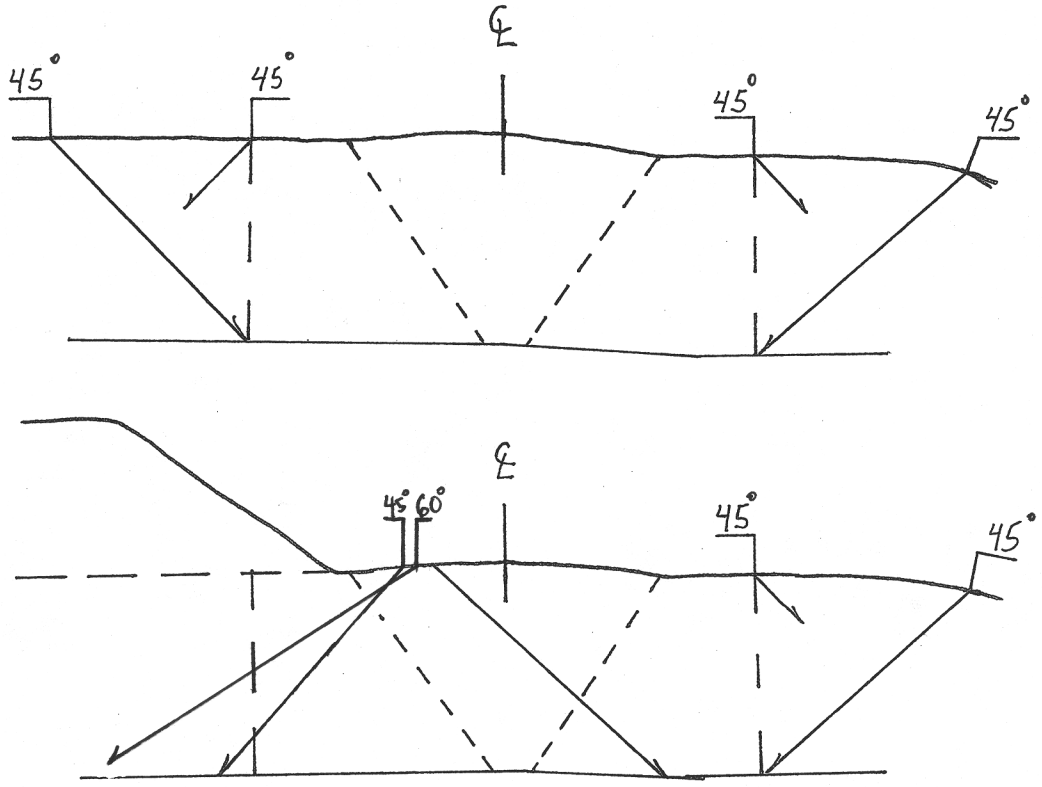
TVA 19668 (NP-5-89)

1-108-999-44

TVA Office of Nuclear Power	PROJECT: WBN SYSTEM: RHR UNIT: 2 WELD NO: RHRHX-1-2B	REPORT NO.: R-P1379 T&C 0480

SHELL

BTM HEAD



BY: CLAY SUHLER Clay D Suhler LEVEL: I DATE: 1/5/11 PAGE 6 OF 7

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Watts Bar Unit 2

TVA Procedure N-GP-31
Attachments 3 & 4

Worksheet Version 1.0 dated 07/01/09

		Measured Fields		Calculated Fields	
WELD NUMBER	RHRHX-1-2B				
Item 1	Required examination Volume in sq. in. **(width x height)**	2.6	1.05	2.73	sq. in.
Item 2	Number of **scan directions**			4	directions
Item 3	Total Scan **volume** in sq. in.			10.92	sq. in.
Item 4	Total **length** of weld			118.5	inches
Item 5	Total required **exam volume** in cubic inches			1294.02	cu. in.
Item 6	**Exam volume acheived** (sq. in.) in direction 1 X **length of weld achieved**	2.53	118.5	299.805	cu. In.
Item 7	**Exam volume acheived** (sq. in.) in direction 2 X **length of weld achieved**	1.32	118.5	156.42	cu. In.
Item 8	**Exam volume acheived** (sq. in.) in direction 3 X **length of weld achieved**	2.085	118.5	247.0725	cu. In.
Item 9	**Exam volume acheived** (sq. in.) in direction 4 X **length of weld achieved**	2.085	118.5	247.0725	cu. In.
Item 10	Determined the **acheived exam volume** add 6, 7, 8 & 9			950.37	cu. In.
Item 11	Exam **volume percentage** item 10/item 5 x 100			**73.44**	%

Limitation due to integral attachments, and inlet/outlet nozzle configurations.

Initials CDS

Date 01/05/2011