



**LOUISIANA**  
POWER & LIGHT

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July 25, 1983

W3I83-0217  
Q-3-N77.06

Mr. Harold R. Denton, Director  
Office of Reactor Regulation  
U. S. Nuclear Regulatory Commission  
Washington, D. C. 20555

SUBJECT: Waterford 3 SES  
Docket No. 50-382  
Preservice Inspection Program

REFERENCE: (1) LP&L letter W3I83-0098 dated April 4, 1983

Dear Mr. Denton:

In the reference above, LP&L committed to submit the Final Report of our Preservice Inspection (PSI) Program by July 1, 1983. Due to unanticipated difficulties which have arisen in the preparation of the report, the July 1 submittal date cannot be met. A revised submittal date is not yet available, however, we will advise you of the new date as soon as it is available.

A critical item in the review of our PSI Program has been the Requests for Relief. These requests are now available and are attached for your consideration. These will also be included in the PSI Final Report.

If you have any questions please feel free to contact us.

F. J. Drummond  
Project Support Manager - Nuclear

Attachment

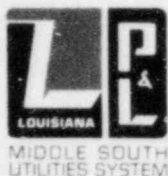
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cc w/attachment: M. Hum, T. Taylor

cc w/o attachment: E. L. Blake, W. M. Stevenson

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**LOUISIANA**  
POWER & LIGHT

WATERFORD 3 SES  
PRESERVICE INSPECTION PROGRAM

REQUEST FOR RELIEF

RELIEF REQUEST NO:

PSI-01

COMPONENT/ITEM/SYSTEM:	CODE CLASS:	CODE CATEGORY:	ITEM NO:	PARAGRAPH:
Pressure Retaining Welds in Piping:	1	B-J	All	IWB-2200 & 2500
Partial Examinations	2	C-F	All	IWC-2200 & 2500

CODE REQUIREMENT:

All required examinations shall be completed prior to initial plant startup. Components shall be examined and tested as specified in Tables IWB-2500-1 and IWC-2500-1.

BASIS/JUSTIFICATION:

- A. All partial exams were due to component configuration or non-removable restraints.
- B. Extensive surface preparation was performed to maximize coverage.
- C. Alternative or supplemental exams were employed wherever feasible. Refer to the Partial Examination Summary Sheets for details; also, see below.
- D. UT examination coverage for PSI included essentially 100% of the WRV, rather than \* just the lower 1/3t required by the referenced Tables.

ALTERNATIVE EXAMINATION(S):

- A. PT was used to complete areas inaccessible to MT, where MT was the selected method.
- B. Alternative angles, search units, vee-paths and other techniques were used to provide UT coverage, where required, to the maximum extent practical.

SCHEDULE FOR IMPLEMENTATION:

Preservice Inspection.

COMMENTS/SKETCHES:

- \*
- E. Essentially 100% of the total number of welds in Class 2 piping systems were examined for PSI; none were exempted on the basis of multiple streams performing the same function.

Details regarding partial examinations are provided in the Partial Examination Summary Sheets contained in this section.

ATTACHMENT(S): ☒ Yes ☐ No



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LP&L WATERFORD #3

Zone #02

[illegible]

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LP&L WATERFORD #3

Zone #03

[illegible]

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LP&L WATERFORD #3

Zone #04

[illegible]

# SUMMARY SHEET- PARTIAL EXAM

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Zone #06

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	scans								
				B	Met	0	2	5	7	8			
06	06-001	—	—	45°	—	—	P	P	P	P	Partial due to radius of nozzle and support lug for scans 5, 7 & 8 and by O.D. mismatch at weld 6-002 in the scan 2 direction, Adequate root area coverage was not obtained with 45° on scan 5.	*Note 2	
06	06-001	—	—	60°	—	—	P	P	P	P	Partial due to radius of nozzle and support lug for scans 5, 7 & 8 and by O.D. mismatch at weld 06-002 in the scan 2 direction, Adequate root area coverage was not obtained with scan 5 at 60°. With the 60° transducer, all circumferential scans do not intersect the I.D. of the test part.	*Note 2	
06	06-001	—	—	30°	—	—	P	Y	Y	Y	Scan 5 was restricted by the O.D. slope of the nozzle. Allowing for beam spread, good root area coverage was obtained.	*Note 2 & 5	
06	06-002	—	—	0°	P	P	—	—	—	—	Partial is due to O.D. mismatch between the nozzle and the pipe causing loss of contact,	Note 2	
06	06-002	—	—	45°	—	—	P	P	P	P	Partial is due to O.D. mismatch between the nozzle and the pipe causing loss of contact.	*Note 2	



# SUMMARY SHEET- PARTIAL EXAM

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Zone #06

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
06	06-002	---	---	60°	---	-	P	P	P	P	Partial is due to O.D. mismatch. With the 60° transducer, all circumferential scans do not intersect the I.D. of the test part.	*Note 2	
06	06-002	---	---	30°	---	-	-	P	P	P	Partial is due to O.D. mismatch causing loss of contact.	*Note 2	
06	06-005	---	---	0°	P	P	-	-	-	-	O.D. nozzle radius, causing loss of contact.	*Note 2	
06	06-005	---	---	45°	---	-	N	P	P	P	Scan 2 could not be performed because the beam would be directed away from the root area. Partial was due to O.D. slope of the nozzle.	*Note 2	
06	06-005	---	---	60°	---	-	N	P	P	P	Scan 2 could not be performed because the beam would be directed away from the root area. The 60° scan 5 beam did not intersect the I.D. surface when the beam was directed circumferentially in relation to the reactor coolant pipe. The same applies for scans 7 & 8.	*Note 2	
06	06-005	---	---	30°	---	-	N	P	P	P	Partial due to branch connection, Scan 2 was not performed because the ultrasonic beam would be directed away from the root area. Scans 5, 7 & 8 were limited by the radius of the weld crown between the main R.C. pipe and branch nozzle.	*Note 2	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #06

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8 Metal	0	2	5	7	8			
06	06-006			45°		-	P	P	P	P		Slope of nozzle on scan 5 side and a small amount of shrinkage on scan 2 side, typ. 360°.	*Note 2 - Carbon side.
06	06-006			45°		-	P	P	P	P		Slope of nozzle on scan 5 side and a small amount of shrinkage on scan 2 side, typ. 360°.	*Note 2 - Austenitic side.
06	06-007			0°	P	P	-	-	-	-		O.D. mismatch causing loss of contact.	*Note 2
06	06-007			45°		-	P	P	P	P		O.D. mismatch causing loss of contact.	*Note 2
06	06-007			60°		-	P	P	P	P		O.D. mismatch causing loss of contact.	*Note 2
06	06-007			30°		-	N	P	P	P		O.D. mismatch causing loss of contact.	*Note 2
06	06-010			0°	P	P	-	-	-	-		Partial due to weld contour. Base metal scan was unable to be performed on approx. 10% of required area. 0° scan was not performed on approx. 5% of required area.	*Note 2
06	06-010			30°		-	-	-	P	P		7 & 8 scans had a partial loss of approx. 7% coverage due to O.D. weld geometry.	*Note 2



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LP&L WATERFORD #3

Zone #06

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
06	06-010	---	---	45°	---	-	P	P	P	P	2 scan had a loss of approx. 7% coverage due to O.D. weld geometry. 5 scan had a loss of approx. 10% coverage due to O.D. weld geometry.	*Note 2	
06	06-010	---	---	30°	---	-	P	P	-	-	Partial due to weld contour and bevel. Approx. 15% loss on 2 scan and 5% on 5 scan.	*Note 2	
06	06-011	---	---	0°	P	P	-	-	-	-	Due to weld contour and bevel, base metal scan was unable to be performed on approx. 20% of required area. 0° scan was unable to be performed on 10% of required area.	*Note 2	
06	06-011	---	---	45°	---	-	Y	P	Y	Y	2 scan had a loss of approx. 5% coverage due to O.D. weld geometry. 5 scan had a loss of approx. 7% due to O.D. weld geometry.	*Note 2	
06	06-011	---	---	60°	---	-	P	P	-	-	Approx. 40% of scan 2 was unable to be examined due to weld contour. Due to weld contour and bevel, approx. 25% of scan 5 could not be examined.	*Note 2	
								</					

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #07

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
07	07-001	---	---	45°	---	-	P	P	P	P	Partial due to O.D. mismatch. Scan 5 restricted by O.D. 1" nozzle. Scans 7 & 8 were limited by about 15% for the coverage area.	*Note 2	
07	07-002	---	---	45°	---	-	P	P	P	P	Partial due to O.D. mismatch. Scans 7 & 8 were limited by about 15% for the coverage area.	*Note 2	
07	07-003A	---	---	0°	P	Y	-	-	-	-	Unable to maintain back reflection due to taper of weld 07-005.	*Note 2	
07	07-004B	---	---	0°	P	Y	-	-	-	-	Unable to maintain back reflection due to weld taper of 07-005.	*Note 2	
07	07-004B	---	---	60°	---	-	Y	Y	P	P	Partial due to elbow intrados. Loss of approx. 15%.	*Note 2	
07	07-005	---	---	0°	P	P	-	-	-	-	Unable to maintain back reflection due to weld taper.	*Note 2	
07	07-005	---	---	45°	---	-	P	P	P	P	Scans 2, 5, 7 & 8 were restricted by a taper on the weld between the pipe and elbow. The length of taper was about 2-1/8" average with a 14° slope. The non-contact area was about 2-1/8" long.	*Note 2	
07	07-005	---	---	60°	---	-	P	P	P	P	Partial due to O.D. weld geometry. Scan 2 loss of approx. 60%, scan 5 loss of approx. 10%, scans 7 & 8 loss of approx. 20%.	*Note 2	

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Zone #07

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
07	07-005			30°					P	P	Loss of approx. 15% coverage due to pipe to elbow O.D. weld geometry.	*Note 2	
07	07-006LA		P								Area not examined from 64" through 72" and 98" through 102".	*Note 2	
07	07-006LA			60°			Y	Y	P	P	Partial loss of contact at the ends of the long seam due to O.D. weld geometry of weld 07-005 and 07-010.	*Note 2	
07	07-007LB			60°			Y	Y	P	P	Partial loss of contact at the ends of the long seam due to O.D. weld geometry of welds 07-005 and 07-010.	*Note 2	
07	07-008			0°	P	P					O.D. slope of nozzle.	*Note 2	
07	07-008			45°			N	P	P	P	O.D. slope of nozzle.	*Note 2	
07	07-008			60°			N	P	P	P	O.D. slope of nozzle.	*Note 2	
07	07-008			30°					P	P	Branch connection and its radius.	*Note 2	
07	07-010		P								Area not examined from 16" through 36".	*Note 2	
07	07-010			0°	P	P					O.D. geometry approx. 10% loss of contact.	*Note 2	
07	07-010			45°			P	P	P	P	Partial due to weld taper. Scan 2 approx. loss was 10%. Scan 5 approx. loss was 60%. Scans 7 & 8 approx. loss was 20%.	*Note 2	



# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #07

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
07	07-010	---	---	30°	---	-	-	-	P	P	Partial due to pipe to elbow O.D. weld geometry resulting in a 10% loss of coverage.	*Note 2	
07	07-011B	---	---	60°	---	-	Y	Y	P	P	Partial loss of coverage with long seam weld due to O.D. geometry of 07-010.	*Note 2	
07	07-012A	---	---	0°	P	Y	-	-	-	-	O.D. geometry causing approx. 10% loss of contact.	*Note 2	
07	07-013	---	P	---	---	-	-	-	-	-	Area not examined from 78" through 94".	*Note 2	
07	07-013	---	---	60°	---	-	P	P	P	P	Partial due to O.D. weld geometry. Scan 2 for a loss of approx. 15%, scan 5 for a loss of approx. 15%, scans 7 & 8 for a loss of approx. 15%.	*Note 2	
07	07-014B	---	---	60°	---	-	Y	Y	P	P	Partial on long seam due to O.D. geometry of welds 07-013 and 07-018.	*Note 2	
07	07-015A	---	---	60°	---	-	Y	Y	P	P	Partial on long seam due to O.D. geometry of weld 07-018 causing loss of contact.	*Note 2	
07	07-016	---	---	45°	---	-	P	P	P	P	All scans were limited by O.D. geometry. The root area was missed completely on scan 5 using the 1" transducer.	*Note 2 - A root area scan was obtained by using a 1/2" transducer on 5 scan.	
07	07-016	---	---	45°	---	-	-	P	-	-	Partial due to O.D. geometry causing loss of contact.	*Note 2 - .5" supplemental exam.	
07	07-016	---	---	60°	---	-	P	P	P	P	Partial due to O.D. geometry. Scan 2 loss of 30%, scan 5 loss of 90%, scans 7 & 8 loss of 15%.	*Note 2 - Scan 5 to be performed using .5" transducer.	

# SUMMARY SHEET - PARTIAL EXAM

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Zone #07

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Mel	0	2	5	7	8			
07	07-016	---	---	60°	---	-	N	P	N	N	Partial due to O.D. geometry causing loss of contact.	1/2" supplemental examination	
07	07-016	---	---	30°	---	-	P	-	Y	Y	Partial due to slope of nozzle.	*Note 2	
07	07-017	---	---	45°	---	-	P	P	P	P	Partial due to O.D. geometry causing loss of contact.	*Note 2	
07	07-017	---	---	60°	---	-	P	P	P	P	Partial due to O.D. geometry. Scan 2 for a loss of 70%, scan 5 for a loss of 50%, scans 7 & 8 for a loss of 10%.	*Note 2	
07	07-017	---	---	30°	---	-	-	P	P	P	Partial due to O.D. mismatch.	*Note 2	
07	07-018	---	---	45°	---	-	P	P	P	P	Partial due to O.D. geometry. Scan 2 root area was missed completely with a 1" transducer.	*Note 2 - Scan 2 was performed with a 1/2" transducer.	
07	07-018	---	---	45°	---	-	P	-	-	-	Partial due to O.D. geometry.	1/2" supplemental examination	
07	07-018	---	---	60°	---	-	P	P	P	P	Partial due to O.D. geometry. Scan 2 for a loss of approx. 85%, scan 5 for a loss of approx. 10%, scans 7 & 8 for a loss of approx. 10%. Scan 2 root area was missed completely with 1" transducer.	*Note 2 - Scan 2 was performed with a 1/2" transducer.	
07	07-018	---	---	60°	---	-	P	N	N	N	Partial due to O.D. geometry causing loss of contact.	1/2" supplemental examination	
07	07-018	---	---	30°	---	-	P	-	P	P	Partial due to O.D. mismatch causing loss of contact.	*Note 2	

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Zone #07

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8 Metal	0	2	5	7	8			
07	07-019A	---	---	45°	---	-	P	P	N	N		Partial due to O.D. surface geometry. No 7 & 8 scan could be obtained for the same reason.	*Note 2 - Weld shall be examined with a 1" transducer.
07	07-019A	---	---	45°	---	-	-	-	P	P		Partial due to O.D. geometry. It is felt that with the 1" and 1/2" examinations, a total of 90% of the root area was examined.	*Note 2 - 1/2" supplemental examination
07	07-019A	---	---	60°	---	-	P	P	P	P		Partial due to O.D. weld geometry. Scan 5 for a loss of approx. 22%, scan 7 for a loss of approx. 22%, scan 8 for a loss of approx. 60%, and scan 8 for a loss of approx. 45%.	*Note 2 - A supplemental 1/2" examination will be performed to increase the amount of coverage.
07	07-019A	---	---	60°	---	-	-	-	P	P		Partial due to O.D. geometry. Scan 7 loss of coverage was decreased to approx. 45%. Scan 8 loss of coverage was decreased to approx. 30%.	*Note 2 - 1/2" supplemental examination
07	07-019A	---	---	30°	---	-	P	P	P	P		Partial due to O.D. mismatch.	*Note 2
07	07-020B	---	---	45°	---	-	P	P	N	N		Partial due to O.D. geometry. 7 & 8 scans could not be performed for the same reason.	*Note 2 - a 1/2" examination will be performed to increase the amount of coverage.
07	07-020B	---	---	45°	---	-	-	-	P	P		Partial due to O.D. geometry. It is felt that with both the 1" and supplemental 1/2" examinations, a total of 90% of the root area was examined.	1/2" supplemental examination
07	07-020B	---	---	60°	---	-	P	P	P	P		Partial due to O.D. geometry of welds 07-016 and 07-018. Scan 2 for a loss of 22%, scan 5 for a loss of 22%, scan 7 for a loss of 60%, scan 8 for a loss of 45%.	*Note 2 - A supplemental 1/2" examination will be performed to increase the amount of coverage.



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LP&L WATERFORD #3

Zone #07

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #08

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
08	08-001	—	P	—	—	—	—	—	—	—	—	Partial due to support leg	
08	08-001	—	—	0° O.D.	P	P	—	—	—	—	—	Base metal scan was totally obstructed by a support lug on the 5 side from 36" to 75" and obstructed by radius on the nozzle for 2" of base metal on the 5 side for the rest of the circumference. 0° scan the H.A.Z. on the 5 side was obstructed by the support lug from 36" to 75".	*Note 2
08	08-001	—	—	45°	—	—	Y	P	Y	Y	Y	Partial due to radius of nozzle,	*Note 2
08	08-001	—	—	60°	—	—	Y	P	Y	Y	Y	Partial due to radius of nozzle,	*Note 2
08	08-001	—	—	30°	—	—	—	P	Y	—	—	Partial due to O.D. slope of nozzle,	*Note 2
08	08-002	—	—	0°	P	Y	—	—	—	—	—	Base metal scan was obstructed by a support lug on the 5 side to only 6" of base metal from 36" to 75" and obstructed by another lug on the 2 side to only 7" of base metal from 59" to 64" and from 108" to 113".	*Note 2
08	08-002	—	—	30°	—	—	—	Y	P	P	—	Partial due to O.D. mismatch,	*Note 2
08	08-004/B	—	P	—	—	—	—	—	—	—	—	Partial due to support lug.	Areas missed were covered by PT examination.
08	08-005	—	—	0°	P	Y	—	—	—	—	—	Partial due to a lug on the 5 side to only 7" base metal from 59" to 64" and from 108" to 113".	*Note 2
08	08-006	—	—	45°	—	—	N	P	Y	Y	Y	Partial due to nozzle radius on 2 & 5 scan,	*Note 2

# SUMMARY SHEET- PARTIAL EXAM

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Zone #08

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Secs	B	Met	0	2	5	7	8	
08	08-006	---	---	60°	---	-	N	P	Y	Y		Partial due to nozzle radius on 2 & 5 scan.	*Note 2
08	08-006	---	---	30°	---	-	N	Y	P	P		Partial due to branch connection.	*Note 2
08	08-007	---	---	30°	---	-	P	P	P	P		Partials due to weld contour. Approx. 10% loss of contact.	*Note 2 - Carbon side.
08	08-007	---	---	30°	---	-	P	P	P	P		Partials due to weld contour. Approx. 10% loss of contact.	*note 2 - Austenitic side.
08	08-008	---	---	0°		P	P	-	-	-	-	Base metal scan on 2 side runs off screen because nozzle is approx. 5" thick, 0° scan runs off screen because of radius, opposite datum side causing increased metal path and nozzle thickness.	*Note 2
08	08-008	---	---	45°	---	-	P	P	Y	Y		Partial due to nozzle radius on 2 & 5 scan.	*Note 2
08	08-008	---	---	60°	---	-	P	P	Y	Y		Partial due to nozzle radius on 2 & 5 scan.	*Note 2
08	08-008	---	---	30°	---	-	N	Y	P	P		Partial due to branch connection.	*Note 2
08	08-009	---	---	45°	---	-	P	P	P	P		Partial due to O.D. mismatch and slope of nozzle.	*Note 2
08	08-011LB	---	---	0°		P	P	-	-	-	-	Partial due to nozzle weld 08-006 on 08-011LB 10' from datum.	*Note 2
08	08-011LB	---	---	30°	---	-	P	P	-	-	-	Partial due to branch connection weld 08-006.	*Note 2
08	08-012	---	---	0°		P	Y	-	-	-	-	Partial due to dissimilar metal weld 08-014 within examination area.	*Note 2

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LP&L WATERFORD #3

Zone #08

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# SUMMARY SHEET- PARTIAL EXAM

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Zone #09

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans	B	Met	0	2	5	7	8	
09	09-001	---	---	45°	---	---	---	P	P	P	P	Partial due to O.D. surface geometry. The root area of this weld could not be examined.	*Note 2
09	09-001	---	---	60°	---	---	---	P	P	P	P	Partial due to O.D. geometry of weld 09-002. Scan 2 for a loss of approx. 50%. Scan 5 for a loss of approx. 70%. Scans 7 & 8 for a loss of approx. 10%.	*Note 2
09	09-001	---	---	30°	---	---	---	P	Y	Y	Y	Partial due to slope of nozzle.	*Note 2
09	09-002	---	---	45°	---	---	---	P	P	P	P	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Scan 2 shall be performed using a .5" transducer.
09	09-002	---	---	60°	---	---	---	P	P	P	P	Partial due to O.D. geometry. Scan 2 for a loss of 90%. Scan 5 for a loss of 30%. Scans 7 & 8 for a loss of 15%.	*Note 2 - Scan 2 shall be performed using a .5" transducer.
09	09-002	---	---	60°	---	---	---	P	---	---	---	Coverage was increased by using a .5" transducer. Scan 2 loss was reduced to 75%.	*Note 2
09	09-002	---	---	30°	---	---	---	P	---	P	P	Partial due to O.D. mismatch.	*Note 2
09	09-002	---	---	45°	---	---	---	P	---	---	---	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Supplemental .5" examination
09	09-003LE	---	---	60°	---	---	---	P	P	P	P	Partial due to loss of coverage at end of long seam weld due to O.D. weld geometry of welds 09-005 & 09-018.	*Note 2
09	09-004LA	---	---	60°	---	---	---	Y	Y	P	P	Partial due to loss of coverage at ends of the long seam due to O.D. geometry of welds 09-005 & 09-018.	*Note 2

## Zone #09

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Zone #09

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
09	09-009A	—	—	60°	—	—	Y	Y	Y	P	Partial due to loss of coverage at the ends of the long seam due to O.D. weld geometry of welds 09-008 and 09-013.	*Note 2	
09	09-010B	—	—	60°	—	—	Y	Y	Y	P	Partial due to loss of coverage at the end of the long seam due to O.D. weld geometry of welds 09-008 and 09-013.	*Note 2	
09	09-011	—	—	0°	P	P	—	—	—	—	Partial due to O.D. slope of nozzle.	*Note 2	
09	09-011	—	—	45°	—	—	N	P	P	P	Partial due to O.D. slope of nozzle.	*Note 2	
09	09-011	—	—	60°	—	—	N	P	P	P	Partial due to O.D. slope of nozzle.	*Note 2	
09	09-011	—	—	30°	—	—	N	P	P	P	Partial due to a branch connection and its radius.	*Note 2	
09	09-012	—	—	30°	—	—	P	P	P	P	Partial due to weld contour. Approx. 10% loss of contact.	*Note 2	
09	09-013	—	—	0°	P	P	—	—	—	—	Partial due to unparallel surfaces resulting in the inability to maintain back reflection.	*Note 2	
09	09-013	—	—	45°	—	—	P	P	P	P	Scans 2, 5, 7 & 8 were restricted by a taper on the weld between the pipe and elbow. The length of taper was about 2" with approx. a 21° slope. The non-contact area was about 2-1/8" long.	*Note	

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #09

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Melal	0	2	5	7	8			
09	09-013	—	—	60°	—	—	P	P	P	P		Partial due to O.D. geometry. Scan 2 loss of 10%, scan 5 loss of 60%, scans 7 & 8 loss of 10%.	*Note 2
09	09-013	—	—	30°	—	—	—	—	P	P		Partial due to O.D. weld geometry. Loss of coverage approx. 20%.	*Note 2
09	09-014B	—	—	0°	P	Y	—	—	—	—		Unable to maintain back reflection due to unparallel surfaces on 09-013.	*Note 2
09	09-015A	—	—	0°	P	Y	—	—	—	—		Unable to maintain back reflection due to unparallel surfaces of weld 09-013.	*Note 2
09	09-015A	—	—	60°	—	—	Y	Y	P	P		Had intermittent loss of contact with the surface as a result of elbow intrados. Scans 7 & 8 loss of approx. 15%.	*Note
09	09-016	—	—	45°	—	—	P	P	P	P		Partials due to O.D. mismatch. Good root area coverage was obtained in the 2 and 5 scans. Scans 7 & 8 had a loss of about 15%.	*Note 2
09	09-017	—	—	45°	—	—	P	P	P	P		Partials due to O.D. mismatch. Scan 5 also restricted by a 1" nozzle. Good root area was obtained with the 2 and 5 direction scans. Scans 7 & 8 were limited by about 15% for the coverage area.	*Note 2
09	09-018	—	—	45°	—	—	P	P	P	P		Partials due to O.D. geometry. Root area was missed completely with 5 scan.	*Note 2 - Scan 5 shall be performed with a 1/2" transducer.
09	09-018	—	—	45°	—	—	—	—	P	—		Partial due to O.D. geometry. Approx. 10% loss of contact.	Supplemental 1/2" examination.

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Zone #09

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS	B Metal	0	2	5	7	8		
09	09-018	—	—	60°	—	—	—	P	P	P	P	Partial due to O.D. geometry. Scan 2 for a loss of 10%, scan 5 for a loss of 85%, scans 7 & 8 for a loss of 10%.	*Note 2
09	09-018	—	—	60°	—	—	—	—	P	—	—	Coverage was increased by using .5" transducer. Scan 5 loss of coverage was decreased to approx. 60%.	
09	09-018	—	—	30°	—	—	—	—	P	P	P	Partial due to O.D. mismatch.	*Note 2
09	09-018LB	—	—	30°	—	—	—	—	P	P	P	Partial due to O.D. mismatch.	*Note 2
09	09-019LB	—	—	45°	—	—	—	—	P	P	N	Scans could not be obtained because of O.D. surface geometry.	*Note 2 - Supplemental .5" examination was performed to increase area of coverage.
09	09-019LB	—	—	60°	—	—	—	—	P	P	P	Coverage was increased by using .5" transducer. Scan 7 coverage loss was decreased to approx. 30%. Scan 8 loss of coverage was decreased to approx. 45%.	*Note 2
09	09-019LB	—	—	60°	—	—	—	—	N	N	P	Coverage was increased by using .5" transducer. Scan 7 coverage loss was decreased to approx. 30%. Scan 8 loss of coverage was decreased to approx. 45%.	*Note 2
09	09-0201A	—	—	45°	—	—	—	—	P	P	N	Scans 7 & 8 could not be performed because of the O.D. surface geometry. A partial 2 & 5 scan was obtained.	*Note 2 - A supplemental .5" examination was performed to increase the area of coverage.
09	09-0201A	—	—	45°	—	—	—	—	—	P	P	Partials due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Supplemental 1/2" examination.

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Zone #09

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Zone #10

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	scans								
				B Metal	0	2	5	7	8				
10	10-001	---	---	45°	---	-	P	P	P	P	All scans were restricted by O.D. mismatch. Good root area coverage was obtained with scan 5. Marginal root area coverage was obtained with scan 2. Scans 7 & 8 were limited by about 20% for the coverage area.	*Note 2	
10	10-002	---	---	45°	---	-	P	P	P	P	All scans were restricted by O.D. mismatch. Good root area coverage was obtained with scan 2. Marginal root area coverage was obtained with scan 5. Scans 7 & 8 were limited by about 30% for the coverage area.	*Note 2	
10	10-005	---	---	0°	P	P	-	-	-	-	0° scan had a partial loss of contact due to nozzle radius. Base metal scan had partial on 2 side due to nozzle configuration.	*Note 2	
10	10-005	---	---	60°	---	-	N	P	P	P	Weld 10-005 is a nozzle branch connection weldment with a curved radius weld area which causes varying degrees of loss of sound coverage.	*Note 2	
10	10-005	---	---	30°	---	-	N	P	P	P	Partial due to branch connection.	*Note 2	
10	10-006	---	---	30°	---	-	P	P	P	P	Partial due to weld contour. Approx. 10% loss of contact.	*Note 2	
10	10-007	---	---	0°	---	P	-	-	-	-	0° scan had a partial due to nozzle radius causing loss of contact and increased metal path from 0° to 60° and 300° to 360°. Base metal scan had partial on 2 side due to nozzle configuration.	*Note 2	

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Zone #10

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
10	10-007	—	—	45°	—	—	P	P	P	P		Unable to maintain contact in radius area using excess co. plant. Partial scans 2, 5, 7 & 8 due to nozzle coming off 36" pipe at 60°. The root was off screen because of radius causing increased metal path from approx. 0° (datum) to 60° and from 300° to 360°.	*Note 2
10	10-007	—	—	60°	—	—	P	P	Y	Y		Weld is a nozzle branch connection with a curved radius weld area which causes varying degrees of loss of sound coverage.	*Note 2
10	10-007	—	—	30°	—	—	N	P	P	P		Partial due to branch connection.	*Note 2
10	10-008	—	—	45°	—	—	P	P	P	P		Partial due to O.D. mismatch and shrinkage on the scan 2 side. Slope of nozzle on scan 5 side. Good root area coverage was obtained.	*Note 2
10	10-009	—	—	45°	—	—	P	P	P	P		Partial due to O.D. mismatch. Estimated loss of contact for 2 scan was 10%, 5 scan was 5%, and scans 7 & 8 were 10%.	*Note 2
10	10-009	—	—	60°	—	—	P	P	P	P		Partial due to O.D. mismatch. Scan 2 for a loss of 10%, scan 5 for a loss of 5%, and scans 7 & 8 for a loss of 10%.	*Note 2
10	10-011B	—	P	—	—	—	—	—	—	—		Partial. Area not examined is 15" (7 direction) to 27" (7 direction).	
10	10-012	—	—	45°	—	—	P	P	P	P		Partial due to O.D. mismatch. Scan 2 for a loss of 10%, scan 5 for a loss of 5%, and scans 7 & 8 for a loss of 10%.	*Note 2



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Zone #10

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

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ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metrol	0	2	5	7	8			
10	10-012	—	—	60°	—	-	P	P	P	P	Scan 2 was obstructed by a support lug for a loss of 10% and O.D. mismatch for a loss of 10%. Scan 5 was obstructed by a lug for a loss of 2% and O.D. mismatch for a loss of 5%. Scans 7 & 8 were obstructed by O.D. mismatch for a loss of 10%.	*Note 2	
10	10-C13	—	—	45°	—	-	P	Y	P	P	Scan 2 and scans 7 & 8 were obstructed by radius of nozzle and support lug. Scan 2 was obstructed totally for a length of 39" for a loss of 34%. Scans 7 & 8 for a loss of 10%. Good root area coverage was obtained.	*Note 2	
10	10-013	—	—	60°	—	-	P	Y	P	P	Partial due to radius of nozzle, support lug and O.D. mismatch. Scan 2 for a loss of 70% and totally obstructed by a support lug for a length of 39". Scans 7 & 8 for a loss of 10%.	*Note 2	
10	10-013	—	—	30°	—	-	P	-	Y	Y	Partial due to slope of nozzle. Scan 2 was obstructed for approx. 39" at the base of the nozzle by a support lug and for 360° by the O.D. slope of the nozzle. Taking into account for beam spread, good root area coverage was obtained.	*Note 2	

# SUMMARY SHEET - PARTIAL EXAM

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Zone #11

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scan	0	1	2	5	7	8		
11	11-001	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. mismatch. Scan 5 was also restricted by a 1" line coming off the pump nozzle. Good root area coverage was obtained with the 2 and 5 scans. Scans 7 & 8 were limited by about 15% for the coverage area.	*Note 5
11	11-002	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. mismatch. Good root area coverage was obtained with 2 & 5 scans. Scans 7 & 8 were limited by about 15% for the coverage area.	*Note 2
11	11-003B	—	—	60°	—	—	—	Y	Y	P	P	Partial due to loss of coverage at the ends of the long seam weld due to O.D. geometry of welds 11-002 and 11-005.	*Note
11	11-004A	—	—	0°	P	Y	—	—	—	—	—	Unable to maintain back reflection due to unparallel surfaces of weld 11-005.	*Note 2
11	11-005	—	—	0°	P	P	—	—	—	—	—	Unable to maintain back reflection due to unparallel surfaces.	*Note 2
11	11-005	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2
11	11-005	—	—	60°	—	—	—	P	P	P	P	Partial due to O.D. geometry. Scan 2 loss of 60%, scan 5 loss of 10%, scans 7 & 8 loss of 10%.	*Note 2
11	11-005	—	—	30°	—	—	—	—	P	P	P	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #11

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
11	11-006	—	—	0°	P	P	—	—	—	—	Contact was difficult to maintain on the weld and only the base metal on the 36" pipe section was examined.	*Note 2	
11	11-006	—	—	45°	—	—	N	P	P	P	Scan 5 was not performed because the sound beam would be directed away from the root area. Scans 2, 7 & 8 were restricted by the radius of the weld crown. The centerline of the sound beam did pass through the root area of the weld.	*Note 2	
11	11-006	—	—	60°	—	—	N	P	P	P	Scan 5 was not performed because the sound beam would be directed away from the root area. Scans 2, 7 & 8 were restricted by the radius of the weld crown. The centerline of the sound beam did pass through the root area of the weld.	*Note 2	
11	11-006	—	—	30°	—	—	N	P	P	P	Partial due to branch connection and it's radius.	*Note 2	
11	11-007	—	—	30°	—	—	P	P	P	P	Partial due to weld contour and adjacent weld.	*Note 2	
11	11-009A	—	—	60°	—	—	P	P	P	P	Partial due to loss of coverage with long seam weld due to O.D. geometry of welds 11-005 and 11-010. Approx. 10% loss of contact.	*Note 2	
11	11-009A	—	—	60°	—	—	P	P	P	P	Partial due to loss of coverage with long seam weld due to O.D. geometry of welds 11-005 and 11-010. Approx. 10% loss of contact.	*Note 2	

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #11

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans								
					B Metal	0	2	5	7	8			
11	11-009B	—	—	60°	—	-	P	P	P	P	Partial due to loss of coverage with long seam weld due to O.D. geometry of welds 11-009 and 11-010. Approx. 10% loss of contact.	*Note 2	
11	11-010	—	—	0°	P	P	-	-	-	-	Unable to maintain contact due to unparallel surface of weld.	*Note 2	
11	11-010	—	—	45°	—	-	P	P	P	P	Partial due to O.D. geometry. Scan 2 approx. loss of 10%, scan 5 approx. loss of 60%, and scans 7 & 8 approx. loss of 10%.	*Note	
11	11-010	—	—	60°	—	-	P	P	P	P	Partial due to loss of contact with the surface as a result of O.D. geometry. Scan 2 for a loss of 10%, scan 5 for a loss of 60%, and scans 7 & 8 for a loss of 10%.	*Note 2	
11	11-010	—	—	30°	—	-	-	-	P	P	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2	
11	11-011B	—	—	60°	—	-	P	P	P	P	Partial loss of coverage with long seam weld due to O.D. geometry of welds 11-010 and 11-013. Approx. 10% loss of contact.	*Note 2	
11	11-012A	—	—	0°	P	Y	-	-	-	-	Unable to maintain back reflection due to unparallel surfaces of weld 11-010.	*Note 2	
11	11-013	—	P	—	—	-	-	-	-	-	Partial examination. Area not inspected is from 80" (7 direction) to 94" (7 direction).	*Note 2	
11	11-013	—	Y	—	—	-	-	-	-	-	Re-examination of all areas not covered in previous inspection.	*Note 2	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #11

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8	Metrol	0	2	5	7	8		
11	11-013	—	—	60°	—	—	—	P	P	P	P	Partial due to loss of coverage due to O.D. weld geometry of weld 11-013. Scan 2 for a loss of approx. 15%, scan 5 for a loss of approx. 15%, scans 7 & 8 for a loss of approx. 15%.	*Note 2
11	11-014A	—	—	60°	—	—	—	P	P	P	P	Partial loss of coverage on the end of the long seam weld due to weld 11-018.	*Note 2
11	11-015B	—	—	60°	—	—	—	P	P	P	P	Partial loss of coverage with long seam weld due to O.D. geometry of weld 11-018. Approx. 10% loss of contact.	*Note 2
11	11-016	—	—	45°	—	—	—	P	P	Y	Y	Partial due to O.D. geometry. Approx. 10% loss of contact ORS.	*Note 2 - Areas missed by 1" transducer will be covered by .5" transducer.
11	11-016	—	—	45°	—	—	—	P	P	—	—	Partials due to O.D. geometry.	*Note 2 - .5" supplemental inspection.
11	11-016	—	—	60°	—	—	—	P	P	P	P	Partial loss of coverage due to welds 11-018 and 11-012. Scan 2 for a loss of 30%, scan 5 for a loss of 90%, and scans 7 & 8 for a loss of 15%.	*Note 2
11	11-016	—	—	60°	—	—	—	P	P	P	P	Coverage was increased by using a .5" transducer. Scan 2 was decreased to 20% loss of coverage. Scan 5 was decreased to 70% loss of coverage.	*Note 2
11	11-016	—	—	30°	—	—	—	P	—	Y	Y	Partial due to O.D. slope of nozzle.	*Note 2

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #11

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS	B	Metol	0	2	5	7	8	
11	11-017	—	—	45°	—	—	—	P	P	Y	Y	Partial due to O.D. geometry. 10% loss of contact.	*Note 2 - Areas missed will be covered with a 1/2" transducer.
11	11-017	—	—	45°	—	—	—	P	P	—	—	Partial due to O.D. geometry.	*Note 2 - Supplemental 1/2" examination.
11	11-017	—	—	60°	—	—	—	P	P	P	P	Partial due to nozzle radius. Scan 2 for a loss of 70%, scan 5 for a loss of 55%, and scans 7 & 8 for a loss of 10%.	*Note 2
11	11-017	—	—	30°	—	—	—	—	P	P	P	Partial due to O.D. mismatch.	*Note 2
11	11-018	—	—	45°	—	—	—	P	P	Y	Y	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Areas missed will be covered by 1/2" transducer.
11	11-018	—	—	45°	—	—	—	P	P	—	—	Partial due to O.D. geometry.	*Note 2 - Supplemental 1/2" examination.
11	11-018	—	—	60°	—	—	—	P	P	P	P	Partial due to loss of coverage due to O.D. geometry of welds 11-016 and 11-018. Scan 2 for a loss of 75%, scan 5 for a loss of 15%, and scans 7 & 8 for a loss of 10%.	*Note 2
11	11-018	—	—	60°	—	—	—	P	P	P	P	Coverage was increased by using a .5" transducer. Scan 2 was decreased to 50% loss of coverage. Scan 5 was decreased to 10% loss of coverage.	*Note 2
11	11-018	—	—	30°	—	—	—	P	—	P	P	Partial due to O.D. mismatch. Allowing for beam spread, good root area coverage was obtained.	*Note 2
11	11-019A	—	—	45°	—	—	—	P	P	Y	Y	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Areas missed shall be covered by a 1/2" transducer.

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #11

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8	Metol	0	2	5	7	8		
11	11-0191A	—	—	45°	—	—	—	P	P	—	—	Partial due to O.D. geometry.	Note 2 - Supplemental 1/2" examination.
11	11-0191A	—	—	60°	—	—	—	P	P	P	P	Partial loss of coverage due to O.D. weld geometry of welds 11-016 and 11-018. Scan 2 for a loss of 22%, scan 5 for a loss of 22%, scan 7 for a loss of 55%, and scan 8 for a loss of 40%.	*Note 2 - Areas missed shall be covered by a 1/2" transducer.
11	11-0191A	—	—	60°	—	—	—	P	P	P	P	Coverage was increased by using a .50" transducer. Scan 7 loss decreased to 40%, Scan 8 loss decreased to 20%.	*Note 2 - 1/2" supplemental examination
11	11-0191A	—	—	30°	—	—	—	P	P	P	P	Partial due to O.D. mismatch.	*Note 2
11	11-0201B	—	—	45°	—	—	—	P	P	Y	Y	Partial due to O.D. mismatch.	*Note 2 - Areas missed shall be covered by a 1/2" transducer.
11	11-0201B	—	—	45°	—	—	—	P	P	—	—	Partial due to O.D. geometry.	*Note 2 - 1/2" supplemental examination.
11	11-0201B	—	—	60°	—	—	—	P	P	P	P	Partial loss of coverage due to O.D. weld geometry of welds 11-016 and 11-018. Scan 2 for a loss of approx. 22%, scan 5 for a loss of approx. 22%, scan 7 for a loss of approx. 55%, and scan 8 for a loss of approx. 40%.	*Note 2 - Areas missed shall be covered by a 1/2" transducer.
11	11-0201B	—	—	60°	—	—	—	P	P	P	P	Coverage was increased by using a .5" transducer. Scan 7 loss decreased to 40%, Scan 8 loss decreased to 20%.	*Note 2 - 1/2" supplemental examination
11	11-0201B	—	—	30°	—	—	—	P	P	P	P	Partial due to O.D. mismatch.	*Note 2



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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #12

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8	Metrol	0	2	5	7	8		
12	12-001	—	—	45°	—	—	—	Y	P	P	P	Scan 5 and scans 7 & 8 were obstructed by radius of nozzle and a support lug. Scan 5 was obstructed totally for a length of 39" for a loss of approx. 34%. Approx. 10% of scans 7 & 8 was lost. Good root area coverage was not obtained.	*Note 2
12	12-001	—	—	60°	—	—	—	Y	P	P	P	Scan 5 was limited totally by the support lug for 39", and limited by the radius of the nozzle for 75%. Scan 2 was limited by O.D. mismatch on weld 12-002 for 10% and by radius of nozzle and support lug for 15%. Scans 7 & 8 were limited by radius of nozzle and support lug for 15%.	*Note 2
12	12-001	—	—	30°	—	—	—	P	—	Y	Y	Scan 5 was obstructed for approx. 39" at the base of the nozzle by a support lug, and for 360° by the O.D. slope of the nozzle. Scans 7 & 8 were limited on the 5 side of the weld by the support lug and the O.D. slope of the nozzle. On the 2 side of the weld the 7 & 8 scans were limited by the O.D. mismatch between the nozzle extension and elbow.	*Note 2
12	12-002	—	—	45°	—	—	—	P	P	P	P	Had intermittent contact with the surface as a result of O.D. mismatch. Scan 5 for a loss of 10%. Scan 2 for a loss of 10%. Scans 7 & 8 for a loss of 10%.	*Note 2



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #12

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	scans								
					B Metal	0	2	5	7	8			
12	12-002	—	—	60°	—	—	P	P	P	P	Scan 5 limited by radius of nozzle and support lug for 10% and by O.D. mismatch for 5%. Scan 2 was limited by a lug for 4% and O.D. mismatch for 5%. Scans 7 & 8 were limited by O.D. mismatch for 15%.	*Note 2	
12	12-004LB	—	—	30°	—	—	P	P	—	—	Partial due to branch connection of weld 12-006.	*Note 2	
12	12-006	—	—	0°	P	P	—	—	—	—	0° scan had a partial due to nozzle radius causing loss of contact. Base metal scan had a partial on 2 side due to nozzle configuration.	*Note 2	
12	12-006	—	—	45°	—	—	N	P	P	—	The welds form the radius between nozzle and the R.C. pipe. The root area can be scanned during scan 5 but contact is lost before the beam can pass completely through the weld. Contact for scans 7 & 8 can only be maintained on scan 5 side. Partial coverage of the H.A.Z. and root area was obtained by directing the beam at a tangent to the weld. Scan 2 was not performed because the beam is directed away from the weld and H.A.Z.	*Note 2	
12	12-006	—	—	60°	—	—	N	P	P	P	Partial due to nozzle branch connection on radius.	*Note 2	
12	12-006	—	—	30°	—	—	N	P	P	P	Partial due to branch connection radius.	*Note 2	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #12

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8 Metal	0	2	5	7	8			
12	12-007	—	—	30°	—	—	P	P	P	P	Partial due to weld contour. Approx. 10% loss of contact,	*Note 2	
12	12-008	—	—	0°	P	P	—	—	—	—	Partial due to nozzle radius causing loss of contact and increased metal path from 0° to 60° and 300° to 360°. Partial on base metal 2 side due to nozzle configuration.	*Note 2	
12	12-008	—	—	45°	—	—	N	P	P	P	Partial due to nozzle radius. Root area can be scanned during scan 5 but contact is lost before the beam can pass completely through the weld. Contact for scans 7 & 8 can only be maintained on the scan 5 side of the weld. Partial coverage of the H.A.Z. and root area was obtained by directing the beam at a tangent to the weld. Scan 2 was not performed because the beam is directed away from the weld and H.A.Z.	*Note 2	
12	12-008	—	—	60°	—	—	P	P	Y	Y	Partial due to nozzle branch connection radius.	*Note 2	
12	12-008	—	—	30°	—	—	N	P	P	P	Partial due to nozzle branch connection radius. Scan 2 was not performed because the ultrasonic beam is directed away from the weld root. Scans 7 & 8 were limited by the radius of the weld crown.	*Note 2	
12	12-009	—	—	45°	—	—	P	P	P	P	Slope of nozzle O.D. mismatch and shrinkage on scan 2 side, good root area coverage was obtained.	*Note 2	

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LP&L WATERFORD #3

Zone #12

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					8 Metal	0	2	5	7	8			
12	12-012	—	—	45°	—	-	P	P	P	P	All scans were restricted by O.D. mismatch. Good root area coverage was obtained with scan 2. Marginal root area coverage was obtained with scan 5. Scans 7 & 8 were limited by about 30% for the coverage area.	*Note 2	
12	12-013	—	—	45°	—	-	P	P	P	P	All scans were restricted by O.D. mismatch. Good root area coverage was obtained with scan 5. Marginal root area coverage was obtained with scan 2. Scans 7 & 8 were limited by about 20% for the coverage area.	*Note 2	

# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #13

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans	0	2	5	7	8			
13	13-001	—	—	45°	—	—	P	P	Y	Y		Partial due to O.D. geometry.	Areas missed will be covered with a 1/2" transducer.
13	13-001	—	—	45°	—	—	P	P	—	—		Partial due to O.D. geometry.	*Note 2 - 1/2" supplemental examination.
13	13-001	—	—	60°	—	—	P	P	Y	Y		Partial due to O.D. geometry. As a result, the root area was not examined.	*Note 2
13	13-001	—	—	30°	—	—	—	P	Y	Y		Partial due to slope of nozzle.	*Note 2
13	13-002	—	—	45°	—	—	P	P	Y	Y		Partial due to O.D. geometry.	*Note 2 - Areas missed will be covered with a 1/2" transducer.
13	13-002	—	—	45°	—	—	P	P	—	—		Partial due to O.D. geometry.	*Note 2 - 1/2" supplemental examination.
13	13-002	—	—	60°	—	—	P	P	P	P		Partial due to O.D. geometry.	*Note 2 - Areas missed shall be covered with a 1/2" examination.
13	13-002	—	—	60°	—	—	P	—	—	—		Partial due to O.D. geometry.	*Note 2 - 1/2" supplemental examination.
13	13-002	—	—	30°	—	—	P	—	P	P		Partial due to O.D. mismatch.	*Note 2
13	13-005	—	P	—	—	—	—	—	—	—		Partial examination area not examined is from 80° (7 direction) to 90° (7 direction).	*Note 2 - Areas missed were examined after surface preparation for UT.
13	13-005	—	—	60°	—	—	P	P	P	P		Partial due to O.D. mismatch.	*Note 2
13	13-007/B	—	—	0°	P	Y	—	—	—	—		Partial due to unparallel surfaces at weld.	*Note 2
13	13-008	—	—	0°	P	P	—	—	—	—		Partial due to O.D. geometry of weld 13-008.	*Note 2



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #13

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
13	13-008	—	—	45°	—	-	P	P	P	P	Partial due to O.D. geometry of weld 13-008.	*Note 2	
13	13-008	—	—	60°	—	-	P	P	P	P	Partial due to O.D. geometry of weld 13-008.	*Note 2	
13	13-008	—	—	30°	—	-	-	-	P	P	Partial due to O.D. mismatch.	*Note 2	
13	13-011	—	—	0°	P	P	-	-	-	-	Partial due to branch connection radius. Only the base metal on the 36" pipe was examined.	*Note 2	
13	13-011	—	—	45°	—	-	P	-	P	P	Partial due to branch connection radius.	*Note 2	
13	13-011	—	—	60°	—	-	P	N	P	-	Partial due to branch connection radius.	*Note 2	
13	13-011	—	—	30°	—	-	N	P	P	P	Partial due to branch connection radius.	*Note 2	
13	13-012	—	—	30°	—	-	P	P	P	P	Partial due to weld contour.	*Note 2	
13	13-013	—	—	0°	P	P	-	-	-	-	Partial due to O.D. taper of weld 13-013.	*Note 2	
13	13-013	—	—	45°	—	-	P	P	P	P	Partial due to O.D. taper of weld 13-013.	*Note 2	
13	13-013	—	—	60°	—	-	P	P	P	P	Partial due to O.D. taper of weld 13-013.	*Note 2	
13	13-013	—	—	30°	—	-	-	-	P	P	Partial due to O.D. taper of weld 13-013.	*Note 2	
13	13-015A	—	—	0°	P	Y	-	-	-	-	Partial due to O.D. taper of weld 13-013.	*Note 2	
13	13-015A	—	—	60°	—	-	Y	P	Y	Y	Partial due to loss of contact with the surface because of 2 ground areas.	*Note 2 - These areas will be covered with a 1/2" transducer.	
13	13-016	—	—	45°	—	-	P	P	P	P	Partial due to O.D. mismatch. Scans 7 & 8 were limited by approx. 15%.	*Note 2	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #13

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
13	13-017	—	—	45°	—	—	P	P	P	P	Partial due to O.D. mismatch. Scan 5 was also restricted by a 2" line. Scans 7 & 8 were limited by about 15%.	*Note 2	
13	13-018	—	—	45°	—	—	P	P	Y	Y	Partial due to O.D. geometry.	*Note 2 - Areas missed will be covered by a 1/2" transducer supplemental examination.	
13	13-018	—	—	45°	—	—	P	P	N	N	Partial due to O.D. geometry.	*Note 2	
13	13-018	—	—	60°	—	—	P	P	P	P	Partial due to O.D. geometry.	*Note 2 - Areas missed shall be scanned with a 1/2" transducer.	
13	13-018	—	—	60°	—	—	P	—	—	—	Partial due to O.D. geometry.	*Note 2 - 1/2" supplemental examination.	
13	13-018	—	—	30°	—	—	P	P	P	P	Partial due to O.D. mismatch.	*Note 2 - 1/2" supplemental examination.	
13	13-019B	—	—	45°	—	—	P	P	Y	Y	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Areas missed shall be scanned with a 1/2" transducer.	
13	13-019B	—	—	45°	—	—	P	P	—	—	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - 1/2" supplemental examination.	
13	13-019B	—	—	60°	—	—	P	P	N	N	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - Areas missed shall be scanned with a 1/2" transducer.	
13	13-019B	—	—	60°	—	—	P	P	—	—	Partial due to O.D. geometry. Approx. 10% loss of contact.	*Note 2 - 1/2" supplemental examination	
13	13-019B	—	—	30°	—	—	P	P	P	P	Partial due to O.D. mismatch.	*Note 2	

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LP&L WATERFORD #3

Zone #13

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# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #14

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans	B Metal	0	2	5	7	8		
14	14-001	—	—	45° L	—	—	P	P	P	P	P	All scans were restricted by O.D. mismatch by pump to safe end weld, and safe end to pipe weld. Scans 7 & 8 were limited by about 20% for the coverage area.	*Note 2
14	14-002	—	—	45° L	—	—	P	P	P	P	P	All scans were restricted by O.D. mismatch by the pipe to safe end weld, and the safe end to pump weld. Scans 7 & 8 were limited by about 30% for the coverage area.	*Note 2
14	14-005	—	—	0°	P	P	—	—	—	—	—	Base metal scan on the 2 side runs off screen because nozzle is close to 5" thick. 0° scan runs off screen because of radius on datum side causing increased metal path and nozzle thickness.	*Note 2
14	14-005	—	—	45°	—	—	P	P	Y	Y	Y	Partial due to weld radius causing the transducer to lift up near the center of the radius and lose sound entry.	*Note 2
14	14-005	—	—	60°	—	—	P	P	Y	Y	Y	Partial due to radius which causes loss of transducer sound entry.	*Note 2
14	14-005	—	—	30°	—	—	P	—	P	P	P	This weld forms a branch connection. The weld crown forms the radius between the R.C. pipe and branch nozzle. Scan 2 wasn't performed because the UT beam is directed away from the weld root. Scans 7 & 8 were limited by the radius of the weld crown.	*Note 2
14	14-006	—	—	45°	—	—	P	P	P	P	P	Small limitation from weld 20-001 and slope of nozzle.	*Note 2



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LP&L WATERFORD #3

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# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #15

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
				B Metal	0	2	5	7	8				
15	15-001	—	—	30°	—	—	P	Y	Y	Scan 5 was restricted by the O.D. slope of the nozzle, but root area coverage was obtained.	*Note 2		
15	15-002	—	—	30°	—	—	P	P	P	Scan 5 was limited by O.D. mismatch between the R.D. pipe and nozzle extension. Good root area coverage was obtained.	*Note 2		
15	15-003UB	—	—	0°	P	P	—	—	—	0° and base metal scans were obstructed by 3 gauges. One in 7 direction from 40" to 42" and from 6 to 1-1/2" on 5 side. One in 7 direction from 10'0" to 10'10" and from 3" to 6" on 5 side. One in 7 direction from 10'10-1/4" to 11'1/4" and from 3" to 6" on 5 side.	*Note 2		
15	15-004A	—	—	0°	Y	P	—	—	—	0° scan was obstructed by 1" instrument connection in 7 direction 7'5" and on 6 of weld.	*Note 2		
15	15-005	—	—	0°	P	P	—	—	—	Nozzle branch	*Note 2		
15	15-005	—	—	45°	—	N	P	P	P	O.D. mismatch of the branch connection. The limitation is the weld radius.	*Note 2		
15	15-005	—	—	60°	—	N	P	P	P	O.D. mismatch of the branch connection. The limitation is the weld radius.	*Note 2		
15	15-005	—	—	30°	—	N	P	P	P	Scan 2 not performed due to beam being directed away from weld root. Scan 5 limited by radius of weld crown between R.C. pipe and branch nozzle. Also true for 7 & 8 scans.	*Note 2		

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #15

ZONE	WELD DESIGN	PT	MT	ULTRASONIC'S								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
15	15-006	---	---	30°	---	-	P	P	P	P	Weld contour. 10% loss of contact.	*Note 2	
15	15-007	---	---	0°	P	P	-	-	-	-	O.D. mismatch of the branch connection. The limitation is the weld radius.	*Note 2	
15	15-007	---	---	45°	---	-	N	P	P	P	O.D. mismatch of the branch connection. The limitation is the weld radius.	*Note 2	
15	15-007	---	---	60°	---	-	N	P	P	P	O.D. mismatch of the branch connection. The limitation is the weld radius.	*Note 2	
15	15-007	---	---	30°	---	-	N	P	P	P	Scan 2 not performed due to beam being directed away from weld root. Scan 5 limited by radius of weld crown between R.C. pipe and branch nozzle. Also true for 7 & 8 scans.	*Note 2	
15	15-008	---	---	45°	---	-	Y	P	Y	Y	Slope of nozzle. Good root area coverage was obtained.	*Note 2	
15	15-009	---	---	45°	---	-	P	P	P	P	Limited by weld #16-001. Good root area coverage was obtained.	*Note 2	
15	15-010	---	---	0°	P	P	-	-	-	-	Nozzle branch.	*Note 2	
15	15-010	---	---	45°	---	-	-	P	P	P	O.D. mismatch of the branch connection. The limitation is the weld radius.	*Note 2	
15	15-010	---	---	30°	---	-	N	P	P	P	Scan 2 not performed due to beam being directed away from weld root. Scan 5 limited by radius of weld crown between R.C. pipe and branch nozzle. Also true for 7 & 8 scans.	*Note 2	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #15

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B	Met	0	2	5	7	8		
15	15-011	—	—	0°	P	P	—	—	—	—	—	Base metal scan was obstructed by 2 instrument connection 1", (1) in 7 direction 21-1/2" and 5" on 5 side, (2) in 7 direction 140" and 5" on 5 side. 0° and base scans were obstructed by 2 branch connections on 5 side, (1) in 7 direction from 68" to 95", (2) in 7 direction from 147" to past datum 13".	*Note 2
15	15-011	—	—	45°	—	—	P	P	P	P	P	All scans limited by mismatch between the pipe and elbow. Also on the scan 5 side by nozzle branch connection. Scan 2 approx. loss is 5% of scan area; scan 5 approx. loss is 10% of scan area; and scans 7 & 8 approx. loss is 10% of scan area.	*Note 2
15	15-011	—	—	60°	—	—	P	P	P	P	P	All scan limited by mismatch between the pipe and elbow. Also on the scan 5 side by nozzle branch connection. Scan 2 approx. loss is 5% of scan area; scan 5 approx. loss is 10% of scan area; scans 7 & 8 approx. loss is 10% of scan area.	*Note 2
15	15-014	—	—	30°	—	—	P	—	P	P	P	O.D. mismatch.	*Note 2
15	15-015	—	—	0°	P	P	—	—	—	—	—	O.D. slope of nozzle.	*Note 2
15	15-015	—	—	45°	—	—	P	Y	P	P	P	Scans 2, 7 & 8 were limited by the O.D. slope of the nozzle at the steam generator. Scans 7 & 8 were limited by approx. 10%, but had good coverage of the root area @ 45°. Scan 2 was limited by approx. 30%.	*Note 2



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LP&L WATERFORD #3

Zone #15

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
15	15-015	—	—	60°	—	—	P	Y	—	—	Scans 2, 7 & 8 were limited by the O.D. slope of the nozzle at the steam generator. Scans 7 & 8 were limited by approx. 10%, but had good coverage of the root area @ 45°. Scan 2 was limited by approx. 30%.	*Note 2	
15	15-015	—	—	30°	—	—	P	—	Y	Y	Scan 5 was not performed because adequate coverage was obtained with the 45° and 60° angles. Scan 2 was limited by the O.D. slope at the nozzle, but root area coverage was obtained. Scans 7 & 8 were limited to a small degree by the O.D. slope. Root area coverage was obtained.	*Note 2	
								</					

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #16

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B	M	C	2	5	7	8		
16	16-001	—	—	45°	—	—	—	P	P	P	P	Partial due to shrinkage at toe of weldment and weld crown. All scans affected. Good root area coverage was obtained.	*Note 2 - Carbon side.
16	16-001	—	—	45°	—	—	—	P	P	P	P	Partial due to shrinkage at toe of weldment and weld crown. All scans affected. Good root area coverage was obtained.	*Note 2 - S.S. side.
16	16-002	—	—	45°	—	—	—	P	P	P	P	Partial due to shrinkage at intrados of elbow on scan 5 side. Good root area coverage was obtained.	*Note 2
16	16-003	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. mismatch at extrados of elbow. Good root area coverage was obtained.	*Note 2
16	16-006	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. mismatch at extrados of elbow. Good root area coverage was obtained.	*Note 2
16	16-007	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. mismatch.	*Note 2
16	16-008	—	—	45°	—	—	—	P	P	P	P	Partial due to O.D. mismatch.	*Note 2
16	16-011	—	—	45°	—	—	—	P	P	P	P	O.D. shrinkage at toe of weld typ. 360° scans 2 & 5. Good root area coverage was obtained.	*Note 2
16	16-016	—	—	45°	—	—	—	P	P	P	P	O.D. shrinkage at toe of weld typ. 360° scan 2 side. Good root area coverage was obtained.	*Note 2
16	16-017	—	—	0°	P	P	—	—	—	—	—	Partial due to approx. 10% loss of contact with the surface as a result of O.D. geometry.	*Note 2

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LP&L WATERFORD #3

Zone #16

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #17

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
17	17-001	—	—	0°	Y	P	-	-	-	-	Partial due to O.D. geometry. Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
17	17-001	—	—	45°	—	-	Y	-	P	P	Partial due to weld contour.	*Notes 2 & 5	
17	17-002	—	—	0°	Y	P	-	-	-	-	Partial due to irregular O.D. geometry of weld crown. Approx. 15% loss of volumetric examination area coverage 360°.	*Note 2	
17	17-002	—	—	45°	—	-	Y	Y	P	P	Partial due to irregular O.D. geometry of weld crown. Approx. 15% loss of volumetric examination area coverage 360°.	*Notes 2 & 5	
17	17-003	—	—	0°	P	Y	-	-	-	-	Partial exam 2 side of weld due to a whip restraint from 0" to 21".	*Note 2	
17	17-003	—	—	45°	—	-	P	Y	Y	Y	Partial exam 2 side of weld due to a whip restraint from 0" to 21".	*Notes 2 & 5	
17	17-005	—	—	0°	Y	P	-	-	-	-	Partial due to O.D. weld geometry for a loss of approx. 10% volumetric examination coverage 360°.	*Note 2	
17	17-005	—	—	45°	—	-	Y	Y	P	P	Partial due to O.D. weld geometry for a loss of 10% volumetric examination area coverage 360°.	*Notes 2 & 5	
17	17-011	—	—	45°	—	-	Y	Y	P	P	Partial due to O.D. geometry. Approx. loss of 5% volumetric examination area coverage 360°.	*Notes 2 & 5	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #17

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
17	17-012	—	—	0°	P	P	-	-	-	-	Partial due to weld contour.	*Note 2	
17	17-013	—	—	0°	Y	P	-	-	-	-	Partial due to weld contour.	*Note 2	
17	17-013	—	—	45°	—	-	Y	Y	P	P	Partial due to O.D. geometry. Approx. 5% loss of volumetric examination area coverage 360°.		
17	17-014	—	—	0°	P	P	-	-	-	-	Partial due to valve body.	*Note 2	
17	17-014	—	—	45°	—	-	P	Y	P	P	Partial due to valve body.	*Notes 2 & 5	
17	17-016	—	—	0°	P	P	-	-	-	-	Base metal scan 2 side only.	*Note 2	
17	17-016	—	—	45°	—	-	Y	N	P	P	No 5 scan due to valve 17-015. 7 & 8 scans loss of approx. 45% coverage due to valve & weld crown, volumetric examination area 360°.	*Notes 2 & 5	
17	17-017	—	—	0°	Y	P	-	-	-	-	Partial due to O.D. geometry. Approx. loss of 10% volumetric examination area coverage 360°.	*Note 2	
17	17-017	—	—	45°	—	-	Y	Y	P	P	Partial due to O.D. geometry. Approx. loss of 10%. Volumetric examination area coverage 360°.	*Notes 2 & 5	
17	17-018	—	—	0°	P	P	-	-	-	-	Partial due to weld contour. Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
17	17-019	—	—	0°	P	P	-	-	-	-	Partial due to weld contour. Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	

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LP&L WATERFORD #3

Zone #17

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #17

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans	B Metal	0	2	5	7	8		
17	17-032	—	—	45°	—	—	—	Y	P	P	P	Partial due to tee configuration and weld contour.	*Notes 2 & 5
17	17-033	—	—	0°	P	P	—	—	—	—	—	Partial due to reducer configuration and weld contour.	*Note 2
17	17-033	—	—	45°	—	—	—	P	Y	P	P	Partial due to reducer configuration and weld contour.	*Notes 2 & 5
17	17-034	—	—	0°	P	P	—	—	—	—	—	Partial due to reducer configuration and weld contour.	*Note 2
17	17-057	—	—	0°	Y	P	—	—	—	—	—	Partial due to O.D. weld crown. Approx. 5% loss of volumetric examination area coverage 360°.	*Note 2
17	17-057	—	—	45°	—	—	—	Y	Y	P	P	Partial due to O.D. weld crown. Approx. 5% loss of volumetric examination area coverage 360°.	*Notes 2 & 5
17	17-058	—	—	0°	P	P	—	—	—	—	—	Partial due to valve body, 2 side only.	*Note 2
17	17-058	—	—	45°	—	—	—	N	Y	P	P	Partial due to valve body, 2 side only.	*Notes 2 & 5
17	17-061	—	—	0°	P	P	—	—	—	—	—	Partial due to valve body and weld crown. Base metal scan partial on 2 side only.	*Note 4
17	17-061	—	—	45°	—	—	—	Y	N	P	P	Partial due to valve body and weld crown. 5 scan was not performed due to valve body.	*Notes 4 & 5
17	17-065	—	—	0°	P	P	—	—	—	—	—	Partial due to O.D. geometry.	*Note 4 - Carbon steel and weld metal calibration.

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LP&L WATERFORD #3

Zone #17

[illegible]



# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #18

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
18	18-001	—	—	0°	Y	P	—	—	—	—	Partial due to O.D. weld geometry, 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-002	—	—	0°	P	P	—	—	—	—	Partial due to weld contour, Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-003	—	—	0°	P	P	—	—	—	—	Partial due to weld contour, Approx. 10% loss of examination coverage 360°.	*Note 2	
18	18-004	—	—	0°	Y	P	—	—	—	—	Partial due to O.D. geometry for approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-004	—	—	45°	—	—	Y	Y	P	P	Partial due to O.D. geometry for approx. 10% loss of volumetric examination area coverage 360°.	*Notes 2 & 5	
18	18-005	—	—	0°	P	P	—	—	—	—	Partial due to weld contour, Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-006	—	—	0°	P	P	—	—	—	—	Partial due to weld contour, Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-008	—	—	0°	P	P	—	—	—	—	Partial of 0° due to weld contour, partial of base metal due to valve body configuration, Approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-008	—	—	45°	—	—	N	Y	Y	Y	No due to valve body configuration.	*Notes 2 & 5	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #18

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
18	18-010	—	—	0°	P	P	—	—	—	—	Partial due to valve body.	*Note 2	
18	18-010	—	—	45°	—	—	Y	N	P	P	Partial of 7 & 8 and no of 5 due to valve body,	*Notes 2 & 5	
18	18-012	—	—	0°	Y	P	—	—	—	—	Partial due to weld crown for approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-012	—	—	45°	—	—	Y	Y	P	P	Partial due to weld crown for approx. 10% loss of volumetric examination area coverage 360°.	*Notes 2 & 5	
18	18-013	—	—	0°	P	Y	—	—	—	—	Partial due to whip restraint on 5 side from 0" to 3-1/2" and from 37" to 40".	*Note 2	
18	18-013	—	—	45°	—	—	Y	P	Y	Y	Partial due to whip restraint on 5 scan from 0" to 3-1/2" and from 37" to 40".	*Notes 2 & 5	
18	18-014	—	—	0°	Y	P	—	—	—	—	Partial due to weld crown for approx. 10% loss of volumetric examination area coverage 360°.	*Note 2	
18	18-014	—	—	45°	—	—	Y	Y	P	P	Partial due to weld crown for approx. 10% loss of volumetric examination area coverage 360°.	*Notes 2 & 5	
18	18-018	—	—	0°	P	P	—	—	—	—	Partial on 2 side due to geometry of tee from 0" to 7-1/2" and 31" to 40".	*Note 2	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #18

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans	B Metal	0	2	5	7	8		
18	18-018	—	—	45°	—	—	P	Y	P	P		Partial on 2 side from 0" to 7-1/2" and 31" to 40" due to tee geometry, 2, 7 & 8 scans.	*Notes 2 & 5
18	18-019	—	—	0°	P	P	—	—	—	—	—	Partial due to tee body on 5 side of base metal and weld contour and tee body on 2 side of 0° scan.	*Note 2
18	18-019	—	—	45°	—	—	Y	N	Y	Y		No on 5 scan due to tee body.	*Notes 2 & 5
18	18-020	—	—	0°	P	P	—	—	—	—	—	Partial due to valve body on 2 side of base metal and 0°. Also weld contour on 0°.	*Note 2
18	18-020	—	—	45°	—	—	N	Y	Y	Y		No on 2 side due to valve body configuration.	*Notes 2 & 5
18	18-022	—	—	0°	P	P	—	—	—	—	—	Partial due to valve and weld crown on 5 side. Loss of 45% volumetric examination area coverage 360°.	*Note 2
18	18-022	—	—	45°	—	—	Y	N	P	P		No on 5 scan due to valve body. Approx. 45% loss of volumetric examination area coverage 360°.	*Notes 2 & 5
18	18-023	—	—	0°	P	P	—	—	—	—	—	Partial on base metal due to valve on 2 side 360°. Partial of base metal, 5 side, due to restraint 3" from toe of weld 360°. Partial 0° scan due to valve body and weld crown.	*Note 2
18	18-023	—	—	45°	—	—	P	P	P	P		Partial on 2 scan due to valve body 360°. 5 scan due to whip restraint 3" from toe of weld 360°. 7 & 8 scans due to geometry and weld crown 360°.	*Note 2 - Elbow examined with .25" transducer from 5 side to insure maximum possible coverage.



# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #2

Zone #18

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B	Met	0	2	5	7	8		
18	18-025	—	—	0°	P	P	—	—	—	—	—	Partial due to tee body configuration on upper half of valve on base metal scan on 5 side. Partial on 0° scan due to weld transition. 10% loss of volumetric examination area coverage.	*Note 2
18	18-025	—	—	45°	—	—	—	Y	P	P	P	Partial on 5, 7 & 8 due to valve body configuration on the upper half of tee. Approx. 25% loss of volumetric examination area coverage.	*Notes 2 & 5
18	18-026	—	—	0°	P	Y	—	—	—	—	—	Partial due to O.D. geometry of reducer. Also 0" to 10" and from 30.5" to 40.5" due to whip restraint 1" from toe of weld on 2 side only.	*Note 2
18	18-026	—	—	45°	—	—	—	P	P	Y	Y	Partial on 2 scan due to O.D. geometry of reducer. Partial on 5 scan from 0" to 10" and 30.5" to 40.5" due to whip restraint 1" from tee.	*Notes 2 & 6
18	18-027	—	—	0°	P	Y	—	—	—	—	—	Partial due to reducer taper on 5 side only.	*Note 2
18	18-027	—	—	45°	—	—	—	Y	N	P	P	Reducer taper on 5 side only.	*Notes 2 & 5
18	18-029	—	—	45°	—	—	—	P	Y	P	P	Elbow intradose causing 15% loss of coverage on 2 side only.	*Notes 2 & 5
18	18-030	—	—	45°	—	—	—	Y	P	P	P	Elbow intradose causing 15% loss of coverage on 5 side only.	*Notes 2 & 5
18	18-031	—	—	45°	—	—	—	P	Y	P	P	Elbow intradose causing 15% loss of coverage on 2 side only.	*Notes 2 & 5



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #18

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	S C A N S								
					B Metal	0	2	5	7	8			
18	18-032	---	---	45°	---	-	Y	P	P	P	Elbow intrados causing 15% loss of coverage on 5 side only.	*Notes 2 & 5	
18	18-033	---	---	45°	---	-	P	Y	P	P	Elbow intrados causing 15% loss of coverage on 2 side only.	*Notes 2 & 5	
18	18-035	---	---	45°	---	-	Y	P	P	P	Elbow intrados causing 15% loss of coverage on 5 side only.	*Notes 2 & 5	
18	18-039	---	---	45°	---	-	Y	P	P	P	Elbow intrados causing 15% loss of coverage on 5 side only.	*Notes 2 & 5	
18	18-041	---	---	0°	Y	P	-	-	-	-	Partial due to weld transition, approx. 10% loss of coverage 360°.	*Note 2	
18	18-042	---	---	0°	Y	P	-	-	-	-	Partial due to weld contour 360°.	*Note 2	
18	18-042	---	---	45°	---	-	N	P	P	P	No on 2 scan due to valve body configuration. Partial on 5 scan due to branch connection. Partial on 7 & 8 scans due to valve body configuration on the 2 side only.	*Note 2	
18	18-055	---	---	0°	P	P	-	-	-	-	Partial on 0° and base metal scans due to weld crown and valve. 5 side of base metal unable to be examined.	*Note 4	
18	18-055	---	---	45°	---	-	Y	N	P	P	No 5 scan due to valve. Partial on 7 & 8 scans due to valve and weld crown. Approx. 25% loss of volumetric examination area coverage 360°.	*Notes 4 & 5	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #18

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN	SE	B Metal	0	2	5	7	8		
18	18-056	—	—	0°	Y	P	-	-	-	-	-	Partial due to weld crown, loss of approx. 10% coverage 360°.	*Note 4
18	18-056	—	—	45°	—	-	Y	Y	P	P	P	Partial on 7 & 8 scan due to weld crown, loss of approx. 10% of coverage 360°.	*Notes 4 & 5
18	18-058	—	—	0°	Y	P	-	-	-	-	-	Partial due to weld crown, loss of approx. 15% of coverage 360°.	*Note 4
18	18-058	—	—	45°	—	-	Y	Y	P	P	P	Partial on 7 & 8 scans due to weld crown, loss of approx. 15% of coverage 360°.	*Notes 4 & 5
18	18-059	—	—	0°	Y	P	-	-	-	-	-	Partial due to weld crown, loss of approx. 10% of coverage 360°.	*Note 4
18	18-059	—	—	45°	—	-	Y	Y	P	P	P	Partial on 7 & 8 scans due to weld crown, loss of approx. 10% of coverage 360°.	*Notes 4 & 5
18	18-060	—	—	0°	Y	P	-	-	-	-	-	Partial due to weld geometry, loss of approx. 5% coverage 360°.	*Note 4
18	18-060	—	—	45°	—	-	Y	Y	P	P	P	Partial on 7 & 8 scans due to weld geometry, loss of approx. 5% coverage 360°.	*Notes 4 & 5
18	18-061	—	—	0°	P	P	-	-	-	-	-	Partial due to weld geometry for 0° scan and reducer configuration for base metal on 2 side only.	*Note 4
18	18-061	—	—	45°	—	-	P	Y	P	P	P	Partial on 2 scan due to reducer. Partial on 7 & 8 due to weld geometry.	*Notes 4 & 5

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LP&L WATERFORD #3

Zone #18

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# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #19

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
19	19-001	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of volumetric examination area coverage due to weld contour.	*Note 2	
19	19-002	—	—	0°	P	Y	—	—	—	—	Base metal scan partial due to a whip restraint from 21" to 38-1/2". The whip restraint is 1-1/2" from the toe of the weld.	*Note 2	
19	19-002	—	—	45°	—	—	Y	P	P	P	Partial due to a whip restraint from 21" to 38-1/2". The whip restraint is 1-1/2" from the toe of the weld.	*Notes 2 & 5	
19	19-006	—	—	0°	P	Y	—	—	—	—	Partial due to a valve on the 2 side.	*Note 2	
19	19-006	—	—	45°	—	—	P	Y	P	P	Partial due to valve on the 2 side and O.D. weld prep.	*Notes 2 & 5	
19	19-008	—	—	0°	P	Y	—	—	—	—	Partial due to the valve on the 5 side.	*Note 2	
19	19-008	—	—	45°	—	—	Y	N	P	P	Partial due to the valve on the 5 side.	*Notes 2 & 5	
19	19-020	—	—	0°	P	P	—	—	—	—	Partial due to the branch radius of tee.	*Note 2	
19	19-020	—	—	45°	—	—	Y	P	P	P	Partial due to the configuration of the tee. Only approx. 15% to 20% of the circumference for the appropriate scans was lost.	*Notes 2 & 5	
19	19-021	—	—	0°	P	P	—	—	—	—	Partial due to the branch radius of the tee.	*Note 2	
19	19-021	—	—	45°	—	—	P	Y	P	P	Partial due to the configuration of the tee. Only approx. 15% to 20% of the circumference for the appropriate scans was lost.	*Notes 2 & 5	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scons Parallel  
7 & 8 Scons Circumferential

LP&L WATERFORD #3

Zone #19

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
19	19-023	—	—	0°	Y	P	-	-	-	-	0° scan partial due to the weld contour causing loss of contact 360°.	*Note 2	
19	19-024	—	—	0°	P	P	-	-	-	-	Partial due to the valve body on the 2 side and the contour of the weld causing loss of contact.	*Note 2	
19	19-024	—	—	45°	—	-	N	Y	Y	Y	Partial due to the valve on the 2 side.	*Notes 2 & 5	
19	19-026	—	—	0°	P	P	-	-	-	-	Partial due to the valve body on the 5 side.	*Note 2	
19	19-026	—	—	45°	—	-	N	Y	P	P	Partial due to the valve body on the 5 side.	*Notes 2 & 5	
19	19-027	—	—	0°	P	P	-	-	-	-	Partial due to the valve body on the 2 side.	*Note 2	
19	19-027	—	—	45°	—	-	Y	N	P	P	Partial due to the valve body on the 2 side.	*Notes 2 & 5	
19	19-029	—	—	0°	P	P	-	-	-	-	Partial due to the body of tee.	*Note 2	
19	19-029	—	—	45°	—	-	P	Y	P	P	Partial due to the tee configuration. Most of the 2 scan was lost. Only about 10% to 15% of the weld was examined with the 2 scan.	*Notes 2 & 5	
19	19-030	—	—	0°	P	P	-	-	-	-	Partial due to the O.D. slope of reducer.	*Note 2	
19	19-030	—	—	45°	—	-	Y	P	P	P	Partial due to the O.D. slope of the reducer.	*Notes 2 & 5	
19	19-031	—	—	0°	P	Y	-	-	-	-	Partial due to the slope of the reducer.	*Note 2	
19	19-031	—	—	45°	—	-	P	Y	P	P	Partial due to the slope of the reducer.	*Notes 2 & 5	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #19

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8	Metol	0	2	5	7	8		
19	19-032	—	—	45°	—	—	—	Y	P	P	P	Partial due to elbow intradose causing loss of contact.	*Notes 2 & 5
19	19-034	—	—	45°	—	—	—	Y	P	P	P	Partial due to elbow intradose causing loss of contact.	*Notes 2 & 5
19	19-037	—	—	45°	—	—	—	P	Y	P	P	Partial due to elbow intradose causing loss of contact.	*Notes 2 & 5
19	19-038	—	—	0°	P	—	Y	—	—	—	—	Partial due to 8" x 8" x 3" tee connection.	*Note 2
19	19-038	—	—	45°	—	—	—	Y	P	P	P	Partial due to 8" x 8" x 3" tee connection, Scan 5 was obstructed for approx. 4".	*Notes 2 & 5
19	19-040	—	—	45°	—	—	—	Y	P	P	P	Partial due to elbow intradose causing loss of contact.	*Notes 2 & 5
19	19-041	—	—	45°	—	—	—	P	Y	P	P	Partial due to elbow intradose causing loss of contact.	*Notes 2 & 5
19	19-042	—	—	0°	P	—	Y	—	—	—	—	Partial due to the valve body on the 2 side.	*Note 2
19	19-042	—	—	45°	—	—	—	Y	N	P	P	Partial due to the valve body on the 2 side.	*Notes 2 & 5
19	19-054	—	—	0°	P	—	P	—	—	—	—	Partial due to the valve body on the 2 side. Also due to the weld crown causing loss of contact.	*Note 4
19	19-054	—	—	45°	—	—	—	Y	N	P	P	Partial due to the valve body on the 2 side.	*Notes 4 & 5

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LP&L WATERFORD #3

Zone #19

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED	
				SCAN ANGLE	S C A N S									
					B Metal	0	2	5	7	8				
20	20-001			0°	P	P						Partial due to the weld contour, also due to the contour of the reducer.	*Note 2	
20	20-001			45°			Y	P	Y	Y		Partial due to the contour of the reducer.	*Notes 2 & 5	
20	20-006			0°	Y	P						Partial due to intermittent loss of contact as a result of O.D. geometry for a loss of approx. 10% volumetric examination area coverage 360°.	*Note 2	
20	20-006			45°			Y	Y	P	P		Partial due to O.D. geometry causing loss of contact. Approx. 10% loss of volumetric examination coverage 360°.	*Notes 2 & 5	
20	20-009			0°	Y	P						Partial due to the weld transition causing loss of contact 360°.	*Note 2	
20	20-010			45°			Y	Y	P	P		Partial due to weld crown causing approx. 10% loss of volumetric examination coverage.	*Notes 2 & 5	
20	20-011			0°	Y	P						Partial due to intermittent loss of contact as a result of O.D. geometry, for a loss of approx. 22% volumetric examination area coverage 360°.	*Note 2	
20	20-011			45°			Y	P	P	P		Scan 5 had a loss of contact with the surface as a result of elbow intrados in the 7 direction from 27" to 33" for a loss of approx. 50%; scans 7 & 8 were obstructed by O.D. geometry for a loss of approx. 22% volumetric examination coverage 360°.	*Notes 2 & 5	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
20	20-012	—	—	0°	Y	P	—	—	—	—	Partial due to intermittent loss of contact with the surface as a result of O.D. weld geometry, for a loss of approx. 16% volumetric examination coverage 360°.	*Note 2	
20	20-012	—	—	45°	—	—	P	Y	P	P	Scan 2 had loss of contact with the surface as a result of elbow intradose in the 7 direction from 27" to 33" for a loss of approx. 50%, Scans 7 & 8 were obstructed by O.D. weld geometry for a loss of approx. 16% volumetric examination area coverage 360°.	*Notes 2 & 5	
20	20-013	—	—	0°	Y	P	—	—	—	—	Intermittent loss of contact with the surface as a result of O.D. geometry, for a loss of approx. 13% volumetric examination coverage 360°.	*Note 2	
20	20-014	—	—	0°	P	P	—	—	—	—	Partial due to the weld contour causing loss of contact, Approx. 10% loss of volumetric examination coverage 360°.	*Note 2	
20	20-015	—	—	0°	P	P	—	—	—	—	4-1/2" permanent restraint located at 0°.	*Note 2	
20	20-015	—	—	45°	—	—	P	P	P	P	4-1/2" permanent restraint located at 0°.	*Note 2	
20	20-016	—	—	0°	P	P	—	—	—	—	Partial due to the valve body configuration on the 2 side and due to the weld contour causing loss of contact. Approx. 35% loss of volumetric examination area coverage 360°.	*Note 2	
20	20-016	—	—	45°	—	—	N	Y	P	P	Partial due to the valve body configuration on the 2 side and due to the weld contour causing loss of contact. Approx. 50% loss of volumetric examination area coverage 360°.	*Notes 2 & 5	

# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED	
				SCAN ANGLE	B Metal	0	2	5	7	8				
20	20-018	—	—	0°	P	P							Had intermittent loss of contact with the surface as a result of O.D. weld geometry and valve 20-017 for a loss of approx. 50% in 0° scan, and 2 side only for base metal scan.	*Note 2
20	20-018	—	—	45°			Y	P	P	P			Had intermittent loss of contact with the surface as a result of O.D. weld geometry and valve 20-017. Scan 5 was obstructed for a loss of approx. 75%; scans 7 & 8 were obstructed for a loss of approx. 50%.	*Notes 2 & 5
20	20-019	—	—	0°	Y	P							Had intermittent loss of contact with the surface as a result of O.D. weld geometry, for a loss of approx. 22%.	*Note 2
20	20-019	—	—	45°			P	Y	P	P			Had intermittent loss of contact with the surface as a result of O.D. weld geometry and elbow intradose. 2 scan was obstructed by elbow in the 7 direction from 36" through past 0 datum 2" for a loss of approx. 50%; scans 7 & 8 were obstructed by O.D. weld geometry for a loss of approx. 22%.	*Notes 2 & 5
20	20-020	—	—	0°	Y	P							Had intermittent loss of contact with the surface as a result of O.D. weld geometry, for a loss of approx. 22%.	*Note 2
20	20-020	—	—	45°			Y	P	P	P			Had intermittent loss of contact with the surface as a result of O.D. weld geometry and elbow intradose. Scan 5 was obstructed by elbow intradose from 18" through 22" for a loss of approx. 50%; Scans 7 & 8 were obstructed by O.D. weld geometry for a loss of approx. 22% of volumetric examination area coverage.	*Notes 2 & 5

# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8	Metals	0	2	5	7	8		
20	20-021	—	—	0°	Y	P	—	—	—	—	Had intermittent loss of contact with the surface as a result of O.D. weld geometry, for a loss of approx. 19% of the volumetric examination area coverage.	*Note 2	
20	20-021	—	—	45°	—	—	P	Y	P	P	Had intermittent loss of contact with the surface as a result of O.D. weld geometry and elbow intrados. 2 scan was obstructed by elbow intrados in the 7 direction for 24" through 28" for a loss of approx. 50%; scans 7 & 8 were obstructed by O.D. weld geometry for a loss of approx. 19%.	*Notes 2 & 5	
20	20-022	—	—	0°	Y	P	—	—	—	—	Had intermittent loss of contact with the surface as a result of O.D. weld geometry for a loss of approx. 11% of the volumetric examination area coverage 360°.	*Note 2	
20	20-022	—	—	45°	—	—	Y	P	P	P	Had intermittent loss of contact with the surface as a result of O.D. weld geometry and elbow intrados. 5 scan was obstructed by elbow intrados in the 7 direction from 38" through past datum 2" for a loss of approx. 50%; scans 7 & 8 were obstructed by O.D. weld geometry for a loss of approx. 11%.	*Notes 2 & 5	
20	20-025	—	—	0°	P	P	—	—	—	—	Had intermittent loss of contact with the surface as a result of O.D. weld geometry and tee; scan 0° loss of approx. 35%, base metal loss of approx. 25%.	*Note 2	



# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scan	0	2	5	7	8			
20	20-025	—	—	45°	—	—	P	Y	P	P		2 scan was obstructed by tee connection for a loss of approx. 50% coverage; 7 & 8 scans had a loss of approx. 35% coverage due to O.D. weld geometry and tee connection.	*Notes 2 & 5
20	20-026	—	—	0°	P	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry and tee. Scan 0° loss of approx. 50%, base metal scan loss of approx. 25%.	*Note 2
20	20-026	—	—	45°	—	—	Y	P	P	P		5 scan was obstructed by a tee connection for a loss of approx. 95% coverage. 7 & 8 scans had a loss of approx. 50% coverage due to O.D. weld geometry, and the connection.	*Notes 2 & 5
20	20-027	—	—	0°	P	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry and valve 20-028. Scan 0° loss of approx. 50%, base metal scan was examined on the 5 side only.	*Note 2
20	20-027	—	—	45°	—	—	N	Y	P	P		2 scan was obstructed totally by valve 20-028. 7 & 8 scans had a loss of approx. 50% coverage due to O.D. weld geometry, and valve 20-028.	*Notes 2 & 5
20	20-029	—	—	0°	P	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry and valve 20-028. Scan 0° loss of approx. 50%, base metal examined on 2 side only.	*Note 2



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
20	20-029	—	—	45°	—		Y	N	P	P		5 scan was obstructed totally by valve 20-028. 7 & 8 scans had a loss of approx. 50% coverage due to O.D. weld geometry, and valve 20-028.	*Notes 2 & 5
20	20-030	—	—	0°	Y	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry; scan 0° loss of approx. 16%.	*Note 2
20	20-030	—	—	45°	—	—	Y	Y	P	P		7 & 8 scans had a loss of approx. 16% coverage due to O.D. weld geometry.	*Notes 2 & 5
20	20-031	—	—	0°	Y	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry; scan 0° loss of approx. 22%.	*Note 2
20	20-031	—	—	45°	—	—	Y	Y	P	P		7 & 8 scans had a loss of approx. 22% coverage due to O.D. weld geometry.	*Notes 2 & 5
20	20-032	—	—	0°	P	Y	—	—	—	—		Partial due to valve on the 2 side causing approx. 10% loss of examination area coverage 360°.	*Note 2
20	20-032	—	—	45°	—	—	N	Y	P	P		Partial due to valve on the 2 side causing approx. 40% loss of the volumetric examination area coverage 360°.	*Notes 2 & 5
20	20-034	—	—	0°	P	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry and tee; scan 0° loss of approx. 35%, base metal loss of approx. 25%.	*Note 2

# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	1	2	5	7	8		
20	20-034	—	—	45°	—	—	P	Y	P	P		5 scan was obstructed by tee connection for a loss of approx. 35% coverage due to O.D. weld geometry and tee connection.	*Notes 2 & 5
20	20-035	—	—	0°	P	P	—	—	—	—		Had intermittent loss of contact with the surface as a result of O.D. weld geometry and reducer. Scan 0° loss of approx. 35%. base metal examined on 5 side only.	*Note 2
20	20-035	—	—	45°	—	—	P	Y	P	P		2 scan was obstructed by 12" x 8" reducer for a loss of approx. 75% coverage; scans 7 & 8 had a loss of approx. 35% due to the O.D. weld geometry and reducer.	*Notes 2 & 5
20	20-036	—	—	0°	P	P	—	—	—	—		0° scan had a partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld, and due to 12" x 8" reducer on 5 side which begins approx. 1/4" from the toe of the weld. Base metal scan could not be performed on the 5 side due to 12" x 8" reducer.	*Note 2
20	20-036	—	—	45°	—	—	Y	P	P	P		Partial due to 12" x 8" reducer and weld crown causing loss of contact.	*Notes 2 & 5
20	20-037	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Mel	0	2	5	7	8			
20	20-037	—	—	45°	P	—	P	Y	P	P		2 scan had partial loss of contact due to elbow intrados. 7 & 8 scans had partial loss of contact due to O.D. weld geometry.	*Notes 2 & 5
20	20-038	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2
20	20-038	—	—	45°	—	—	Y	P	P	P		5 scan had partial loss of contact due to elbow intrados. 7 & 8 scans had partial loss of contact due to O.D. weld geometry.	*Notes 2 & 5
20	20-039	—	—	0°	Y	P	—	—	—	—		0° scan had a partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2
20	20-039	—	—	45°	—	—	P	Y	P	P		2 scan had partial loss of contact due to elbow intrados. 7 & 8 scans had partial loss of contact due to O.D. weld geometry.	*Notes 2 & 5
20	20-040	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld.	*Note 2
2-	20-040	—	—	45°	—	—	Y	P	P	P		5 scan had partial loss of contact due to elbow intrados. 7 & 8 scans had partial loss of contact due to O.D. weld geometry.	*Notes 2 & 5
20	20-041	—	—	0°	P	P	—	—	—	—		Partial loss of contact due to O.D. weld geometry.	*Note 2



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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
20	20-041	—	—	45°	—	—	Y	Y	P	P		Partial loss of contact due to O.D. weld geometry. Approx. loss of 10% coverage 360°.	*Notes 2 & 5
20	20-042	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact due to O.D. weld geometry on sides 2 & 5 of the weld.	*Note 2
20	20-043	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact due to O.D. weld geometry on sides 2 & 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2
20	20-044	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2
20	20-045	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2
20	20-046	—	—	0°	Y	P	—	—	—	—		0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2
20	20-053	—	—	0°	Y	P	—	—	—	—		Partial due to weld crown causing loss of contact. Approx. 10% loss of coverage 360°.	*Note 2
20	20-053	—	—	45°	—	—	Y	Y	P	P		Partial due to weld crown causing loss of contact. Approx. 10% loss of coverage 360°.	*Notes 2 & 5



# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #20

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B	Metol	0	2	5	7	8		
20	20-056	—	—	0°	Y	P	—	—	—	—	0° scan partial due to the weld contour and the valve configuration on the 2 side.	*Note 2	
20	20-056	—	—	45°	—	—	N	Y	P	P	Valve on the 2 side and weld contour causing approx. 45% loss of coverage 360°.	*Notes 2 & 5	
20	20-067	—	—	0°	Y	P	—	—	—	—	0° scan had partial loss of contact with the surface due to O.D. weld geometry on sides 2 and 5 of the weld. Approx. 10% loss of coverage 360°.	*Note 2	
20	20-070	—	—	0°	P	P	—	—	—	—	Partial due to the valve on the 5 side and transition of the weld causing loss of contact.	*Note 4	
20	20-070	—	—	45°	—	—	Y	N	P	P	Valve on the 5 side and transition of the weld causing loss of contact for an approx. loss of 45% volumetric examination area coverage 360°.	*Notes 4 & 5	
20	20-071	—	—	0°	Y	P	—	—	—	—	Partial due to the weld transition causing loss of contact. Approx. 10% loss of coverage 360°.	*Note 4	
20	20-072	—	—	0°	P	P	—	—	—	—	Base metal scan partial due to the transition of the reducer on the 2 side; 0° scan partial due to the O.D. weld geometry causing loss of contact on the 2 & 5 side of the weld.	*Note 4	
20	20-072	—	—	45°	—	—	N	Y	P	P	2 scan partial due to the transition of the reducer on the 2 side, 7 & 8 scans partial due to O.D. weld geometry causing loss of contact on the 2 & 5 side of the weld.	*Notes 4 & 5	

## Zone #20

**NOTE: 2 & 3 Score Parallel!  
7 & 8 Score Circumferential**

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #21

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
21	21-004	---	---	0°	Y	P	-	-	-	-	-	Approx. 15% loss of coverage due to weld crown 360°.	*Note 2
21	21-004	---	---	45°	---	-	Y	Y	P	P	-	Approx. 15% loss of coverage due to weld crown 360°.	*Notes 2 & 5
21	21-005	---	---	0°	Y	P	-	-	-	-	-	Approx. 15% loss of coverage due to weld crown 360°.	*Note 2
21	21-005	---	---	45°	---	-	Y	Y	P	P	-	Approx. 15% loss of coverage due to weld crown 360°.	*Notes 2 & 5
21	21-018	---	---	0°	Y	P	-	-	-	-	-	Approx. 10% loss of coverage due to weld transition 360°.	*Note 2
21	21-030	---	---	0°	P	Y	-	-	-	-	-	Partial due to the sweepolet radius on the 2 side 360°.	*Note 2
21	21-030	---	---	45°	---	-	P	Y	P	P	-	Partial due to sweepolet radius on 2 side only, approx. 50% loss of coverage 360°.	*Notes 2 & 5
21	21-066	---	---	0°	P	P	-	-	-	-	-	Base metal scan 5 side only. No 2 scan due to valve 21-067. Approx. 45% loss of coverage due to weld crown and valve.	*Note 2
21	21-066	---	---	45°	---	-	N	Y	P	P	-	No 2 scan due to valve 21-067. Approx. 45% loss of coverage due to weld crown and valve, 360°.	*Notes 2 & 5
21	21-068	---	---	0°	P	P	-	-	-	-	-	Base metal scan 2 side only. No 5 scan due to valve 21-067. Approx. 45% loss of coverage due to weld crown and valve, 360°.	*Note 2

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LP&L WATERFORD #3

Zone #21

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# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #22

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS	B Metal	0	2	5	7	8		
22	22-001	---	---	0°	Y	P	-	-	-	-	-	Approx. 10% loss of coverage due to weld transition.	*Note 2
22	22-004	P	---	---	---	---	-	-	-	-	-	Area not covered from zero datum to 22-1/2" in 7 direction because of restraint.	*Note 2
22	22-004	---	---	0°	P	P	-	-	-	-	-	Base metal no coverage on 2 side from datum to 22-1/8" in 7 direction. Approx. 90% loss of coverage from datum to 22-1/8" in 7 direction. Approx. 5% loss of coverage from 22-1/8" to datum.	*Note 2
22	22-004	---	---	45°	---	-	P	P	P	P	P	2 scan no from datum to 22-1/8" in 7 direction. Approx. 10% loss of coverage from datum to 22-18" for 5 scan. Approx. 90% loss of coverage from datum to 22-1/8" for 7 & 8 scans; approx. 5% from 22-1/8" to datum.	*Note 2
22	22-015	---	---	0°	Y	P	-	-	-	-	-	Approx. 10% loss of coverage due to weld transition 360°.	*Note 2
22	22-017	---	---	0°	Y	P	-	-	-	-	-	Approx. 10% loss of coverage due to weld transition 360°.	*Note 2
22	22-021	---	---	0°	Y	P	-	-	-	-	-	Approx. 10% loss of coverage due to weld transition 360°.	*Note 2
22	22-023	P	---	---	---	---	-	-	-	-	-	Due to welded restraint on 5 side - 360°; on 2 side from 2" to 25.5" in 7 direction.	*Notes 2 & 6

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone 522

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
22	22-023	—	—	0°	P	Y						Approx. 10% loss of coverage due to weld contour 360°.	*Note 2
22	22-024	P	—	—	—	—	—	—	—	—		Due to welded restraint area not examined from 2" (7 side) to 25.5" (7 side).	*Notes 2 & 6
22	22-024	—	—	0°	Y	P						Approx. 10% loss of coverage due to weld contour 360°.	*Note 2
22	22-027	—	—	0°	P	Y						Slope of branch connection on 2 side 360°.	*Note 2
22	22-027	—	—	45°	—	N	Y	P	P			Branch connection on 2 side, approx. 50% loss of coverage 360°.	*Notes 2 & 5
22	22-053	—	—	0°	P	P						Approx. 10% loss of coverage due to weld contour 360°.	*Note 2
22	22-053	—	—	45°	—	N	Y	Y	Y			No due to valve body configuration, approx. 45% loss of coverage 360° on 2 side.	*Notes 2 & 5
22	22-055	—	—	0°	P	P						Approx. 10% loss of coverage due to weld contour 360°.	*Note 2
22	22-055	—	—	45°	—	Y	N	Y	Y			No due to valve body configuration on 5 side causing approx. 45% loss of coverage 360°.	*Notes 2 & 5
22	22-057	—	—	0°	P	Y						Branch connection causing partial of base metal on 2 side for an approx. loss of 45% coverage 360°.	*Note 2
22	22-057	—	—	45°	—	N	Y	P	P			Branch connection causing partial of base metal and weld on 2 side with an approx. loss of 50% coverage.	*Notes 2 & 5

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LP&L WATERFORD #3

Zone #22

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 3 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #25

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
25	25-009	—	—	0°	Y	P	—	—	—	—	Approx. 25% loss of contact due to O.D. weld geometry 360°.	*Note 2	
25	25-009	—	—	45°	—	—	P	Y	Y	Y	Approx. 30% loss of coverage due to inside radius of tee joint configuration for approx. 140°.	*Notes 2 & 5	
25	25-015	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 2	
25	25-015	—	—	45°	—	—	Y	P	Y	Y	Approx. 30% loss of contact due to inside radius of tee joint configuration for approx. 140°.	*Notes 2 & 5	
25	25-016	—	—	0°	P	P	—	—	—	—	Approx. 20% loss of contact due to O.D. weld geometry and valve on 2 side 360°.	*Note 2	
25	25-016	—	—	45°	—	—	N	Y	P	P	Approx. 30% loss of contact due to valve body configuration.	*Notes 2 & 5	
25	25-018	—	—	0°	P	P	—	—	—	—	Approx. 20% loss of contact due to O.D. weld geometry; valve on 5 side.	*Note 2	
25	25-018	—	—	45°	—	—	Y	N	P	P	Approx. 20% loss of coverage due to valve body configuration 360° on 5 side.	*Notes 2 & 5	
25	25-019	—	—	0°	Y	P	—	—	—	—	Approx. 25% loss of contact due to O.D. weld geometry 360°.	*Notes 2 & 5	
25	25-020	—	—	0°	Y	P	—	—	—	—	Approx. 25% loss of contact due to O.D. weld geometry 360°.	*Note 2	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scons Parallel  
7 & 8 Scons Circumferential

LP&L WATERFORD #3

Zone #25

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	S C O N S								
					B Metal	0	2	5	7	8			
25	25-021	—	—	45°	—	—	P	Y	Y	Y	Approx. 2% loss of contact due to tee branch on 2 side.	*Notes 2 & 5	
25	25-022	—	—	45°	—	—	Y	P	Y	Y	Approx. 5% loss of contact due to tee branch on 5 side.	*Notes 2 & 5	
25	25-023	—	—	0°	Y	P	—	—	—	—	Approx. 20% loss of contact due to O.D. weld geometry 360°.	*Note 2	
25	25-024	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact due to weld crown 360°.	*Note 2	
25	25-024	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact due to weld crown 360°.	*Notes 2 & 5	
25	25-026	—	—	45°	—	—	P	Y	Y	Y	Approx. 2.5% loss of contact due to intradose of elbow on 2 side only approx, 90°.	*Notes 2 & 5	
25	25-027	—	—	45°	—	—	Y	P	Y	Y	Approx. 25% loss of contact due to intradose of elbow on 5 side approx, 90°.	*Notes 2 & 5	
25	25-028	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact due to weld crown and nozzle configuration on 2 side 360°.	*Note 2	
25	25-028	—	—	45°	—	—	P	Y	P	P	Approx. 10% loss of contact due to weld crown and nozzle configuration 360°.	*Notes 2 & 5	
25	25-029	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact due to weld crown and nozzle configuration 360°.	*Note 2	
25	25-029	—	—	45°	—	—	P	P	P	P	Approx. 10% loss of contact due to weld crown and nozzle configuration 360°.	*Notes 2 & 5	

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Zone #25

[illegible]

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scons Parallel  
7 & 8 Scons Circumferential

LP&L WATERFORD #3

Zone #26

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED	
				SCAN ANGLE	S C O N S									
					B Metal	0	2	5	7	8				
26	26-001	—	—	45°	—	—	P	Y	Y	Y	Approx. 20% loss of contact due to nozzle configuration 360°.	*Notes 2 & 5		
26	26-001	—	—	60°	—	—	P	Y	Y	Y	Approx. 20% loss of contact due to nozzle configuration 360°.	*Notes 2 & 5		
26	26-002	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact due to toe of weld 360°.	*Note 2		
26	26-002	—	—	45°	—	—	Y	P	P	P	Approx. 20% loss of contact due to toe of weld and reducer bevel on 5 side 360°.	*Notes 2 & 5		
26	26-003	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact due to toe of weld 360°.	*Note 2		
26	26-003	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact due to toe of weld 360°.	*Notes 2 & 5		
26	26-004	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 2		
26	26-004	—	—	45°	—	—	P	Y	P	P	Approx. 10% loss of contact at toe of weld and flange bevel 360°.	*Notes 2 & 5		
26	26-006	—	—	45°	—	—	P	Y	Y	Y	Approx. 25% loss of coverage due to nozzle configuration 360°.	*Notes 2 & 5		
26	26-006	—	—	60°	—	—	P	Y	Y	Y	Approx. 25% loss due to nozzle configuration 360°.	*Notes 2 & 5		
26	26-007	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 2		

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LP&L WATERFORD #3

Zone #26

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
26	26-007	—	—	45°	—	Y	P	P	P	P	Approx. 10% loss of coverage at toe of weld and reducer bevel 360°.	*Notes 2 & 5	
26	26-008	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 2	
26	26-008	—	—	45°	—	—	P	Y	P	P	Approx. 10% loss of contact at toe of weld and weld 26-009 1-1/2" away on 2 side 360°.	*Notes 2 & 5	
26	26-009	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 2	
26	26-009	—	—	45°	—	—	P	P	P	P	Approx. 10% loss of contact at toe of weld and flange bevel on 2 side; weld 26-008 1-1/2" away 5 side.	*Note 2	
26	26-010	—	—	45°	—	—	P	Y	Y	Y	Approx. 25% loss of coverage due to nozzle configuration 360°.	*Notes 2 & 5	
26	26-010	—	—	60°	—	—	P	Y	Y	Y	Approx. 25% loss of contact due to nozzle configuration 360°.	*Notes 2 & 5	
26	26-011	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 2	
26	26-011	—	—	45°	—	—	P	P	P	P	Approx. 10% loss of contact at toe of weld; reducer bevel 5 side; end cap 2 side.	*Note 2	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scons Parallel  
7 & 8 Scons Circumferential

LP&L WATERFORD #3

Zone #41

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scons	B	1	2	5	7	8		
41	41-001	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of coverage due to weld transition 360°.	*Note 4
41	41-002	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of contact due to O.D. weld crown 360°.	*Note 4
41	41-003	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of contact due to O.D. weld crown 360°.	*Note 4
41	41-006	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 4
41	41-008	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of contact due to O.D. weld crown 360°.	*Note 4
41	41-010	—	—	0°	Y	P	—	—	—	—	—	Approx. 8% loss of contact due to O.D. weld geometry 360°.	*Note 4
41	41-011	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of coverage due to O.D. weld geometry 360°.	*Note 4
41	41-016	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of coverage due to O.D. weld geometry 360°.	*Note 4
41	41-019	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of coverage due to weld crown 360°.	*Note 4
41	41-019	—	—	45°	—	P	P	P	P	P	P	Partial with 45° on 5 side due to numerous laminations from 62-3/4" to 124-1/4".	*Note 4
41	41-020	—	—	45°	—	P	Y	Y	Y	Y	Y	Face of penetration causing partial on 2 side for a loss of approx. 25% coverage 360°.	*Notes 4 & 5

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LP&L WATERFORD #3

Zone #41

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #42

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B	Met	0	2	5	7	8		
42	42-001	—	—	0°	Y	P						Approx. 10% loss of coverage due to weld transition 360°.	*Note 4
42	42-001	—	—	45°			P	P	P	P		Approx. 10% loss of coverage due to weld transition 360°.	*Notes 4 & 5
42	42-005	—	—	0°	P	Y						Approx. 25% loss of coverage due to slope of elbow reducer on 2 side & 7°.	*Note 4
42	42-005	—	—	45°			P	Y	Y	Y		Approx. 25% loss of coverage due to slope of elbow reducer 360°.	*Notes 4 & 5
42	42-011	—	—	0°	P	P						Approx. 10% loss of coverage due to weld crown 360°.	*Note 4
42	42-011	—	—	45°			Y	Y	P	P		Approx. 10% loss of coverage due to weld crown 360°.	*Notes 4 & 5
42	42-019	—	—	0°	P	V						Approx. 10% loss of coverage due to branch connection.	*Note 4
42	42-019	—	—	45°			P	Y	P	P		Approx. 10% loss of coverage due to branch connection and weld crown.	*Notes 4 & 5
42	42-023	—	—	0°;45°	N	N	N	N	N	N	N	Inaccessible due to penetration design.	*Notes 3 & 6
42	42-024	—	—	0°	P	P						Approx. 10% loss of coverage due to weld transition 360°.	*Note 4
42	42-024	—	—	45°			P	P	P	P		Approx. 10% loss of contact due to weld transition 360°.	*Notes 4 & 5

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #43

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
43	43-001	—	—	0°	P	P	—	—	—	—		Partial due to 2" pipe approx. .9" from toe of weld causing approx. 15% loss of coverage at 180° from datum.	*Note 4
43	43-001	—	—	45°	—	—	—	P	N	P	P	Partial due to 2" pipe approx. .9" from toe of weld; 180° no 5 side.	*Notes 4 & 5 - 5 scan to be examined with 60° due to 15° slope.
43	43-001	—	—	60°	—	—	—	—	Y	P	P	No 2 side.	2 side previously examined with 45° transducer.
43	43-002	—	—	0°	Y	P	—	—	—	—		Approx. 10% loss of contact due to weld crown 360°.	*Note 4
43	43-004	—	—	45°	—	—	—	N	Y	P	P	Approx. 10% loss of coverage 360° due to pipe schedule change.	*Notes 4 & 5 - 2 side examined with calibration block UT-128.
43	43-006	—	—	0°	P	P	—	—	—	—		Approx. 40% loss of coverage due to part configuration.	*Note 4
43	43-006	—	—	45°	—	—	—	Y	N	P	P	Approx. 40% loss of coverage due to part configuration 360°.	*Notes 4 & 5
43	43-013	—	—	0°	P	P	—	—	—	—		Approx. 40% loss of coverage due to part configuration 360° on 2 side only.	*Note 4
43	43-013	—	—	45°	—	—	—	Y	N	P	P	Approx. 40% loss of coverage due to part configuration 360°.	*Notes 4 & 5
43	43-022	—	—	0°	P	P	—	—	—	—		Approx. 40% loss of coverage due to part configuration on 2 side only.	*Note 4
43	43-022	—	—	45°	—	—	—	Y	N	P	P	Approx. 40% loss of coverage due to part configuration 360°.	*Notes 4 & 5



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #43

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED	
				SCAN ANGLE	SCANS									
					B Metal	0	2	5	7	8				
43	43-029	—	—	0°	P	P	-	-	-	-	Approx. 40% loss of coverage due to part configuration 360°.	*Note 4		
43	43-029	—	—	45°	—	-	Y	N	P	P	Approx. 40% loss of contact due to part configuration 360°.	*Notes 4 & 5		
43	43-035	—	—	0°	Y	P	-	-	-	-	Approx. 10% loss of coverage due to weld contour 360°.	*Note 4		
43	43-035	—	—	45°	—	-	Y	Y	P	P	Approx. 10% loss of coverage due to weld contour 360°.	*Notes 4 & 5		
43	43-037	—	—	0°	P	P	-	-	-	-	Approx. 40% loss of coverage due to part configuration 360° on 2 side.	*Note 4		
43	43-037	—	—	45°	—	-	Y	N	P	P	Approx. 40% loss of coverage due to part configuration 360°.	*Notes 4 & 5		
43	43-048	—	—	0°	P	P	-	-	-	-	Approx. 10% loss of contact at toe of weld due to weld contour 360°.	*Note 4		
43	43-048	—	—	45°	—	-	Y	Y	P	P	Approx. 10% loss of contact at toe of weld due to weld contour 360°.	*Notes 4 & 5		
43	43-050	—	—	0°	P	P	-	-	-	-	Approx. 40% loss of contact due to part configuration 360° on 2 side.	*Note 4		
43	43-050	—	—	45°	—	-	Y	N	P	P	Approx. 40% loss of coverage due to part configuration 360°.	*Note 4		
43	43-056	—	—	0°	P	P	-	-	-	-	Approx. 40% loss of coverage due to thickness change on 5 side for 360°.	*Note 4		

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Zone #43

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
43	43-056	—	—	45°	—	—	Y	N	P	P	Approx. 40% loss of coverage due to thickness change 360°.	*Notes 4 & 5	
43	43-060	—	—	0°	P	P	—	—	—	—	Approx. 50% loss of coverage due to thickness change on 2 side.	*Note 4	
43	43-060	—	—	45°	—	—	N	Y	Y	Y	Approx. 50% loss of coverage due to thickness change and part configuration 360°.	*Note 4	
43	43-062	—	—	0°	P	P	—	—	—	—	Partial due to header on 5 side.	*Note 4	
43	43-062	—	—	45°	—	—	Y	N	P	P	Partial due to header on 5 side.	*Note 4	
43	43-063	—	—	45°	—	—	P	Y	P	P	Approx. 20% loss of contact due to weld contour and reducer configuration 360°.	*Notes 4 & 5	
43	43-067	—	—	45°	—	—	Y	P	P	P	Approx. 20% loss of contact due to weld contour and reducer configuration 360°.	*Notes 4 & 5	
43	43-068	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact due to O.D. mismatch.	*Note 4	
43	43-068	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact due to weld contour 360°.	*Notes 4 & 5	
43	43-069	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact due to weld contour 360°.	*Notes 4 & 5	
43	43-070	—	—	0°	P	P	—	—	—	—	Approx. 25% loss of contact due to valve and liftoff at toe of weld 360°.	*Note 4	

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Zone #43

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
43	43-070	—	—	45°	—	—	N	Y	P	P	Approx. 45° loss of contact due to valve and liftoff at toe of weld 360°.	*Notes 4 & 5	
43	43-079	—	—	0°	P	P	—	—	—	—	Approx. 50% loss of contact due to bevel on 5 side; 5 side only 360°.	*Notes 4 & 5 - 2 side to be examined with UT-127	
43	43-079	—	—	0°	P	P	—	—	—	—	2 side only 360°.	*Note 4 - 5 side to be examined with UT-128,	
43	43-079	—	—	45°	—	—	Y	N	P	P	2 side only 360°.	*Notes 4 & 5 - 5 side to be examined with UT-128	
43	43-079	—	—	45°	—	—	P	P	P	P	Approx. 40% loss of contact due to bevel on 5 side; 5 side only.	*Notes 4 & 5 - 2 side to be examined with UT-127	
43	43-082	—	—	0°	P	P	—	—	—	—	Par due to valve configuration on 2 side. Approx. 40% loss of coverage 360°.	*Note 4	
43	43-082	—	—	45°	—	—	N	Y	P	P	Par due to valve configuration on 2 side. Approx. 40% loss of coverage 360°.	*Notes 4 & 5	
43	43-089	—	—	0°	P	P	—	—	—	—	Par due to valve on 5 side. Approx. 40% loss of coverage 360°.	*Note 4	
43	43-089	—	—	45°	—	—	Y	N	P	P	No and par due to valve configuration on 5 side. Approx. 40% loss of coverage 360°.	*Notes 4 & 5	



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LP&L WATERFORD #3

Zone #44

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
44	44-003	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Note 4	
44	44-003	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Notes 4 & 5	
44	44-005	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Note 4	
44	44-005	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Notes 4 & 5	
44	44-007	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Note 4	
44	44-007	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Notes 4 & 5	
44	44-008	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Note 4	
44	44-008	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Notes 4 & 5	
44	44-010A	—	—	0°	P	P	—	—	—	—	Saddle support from 12" to 18" in 7 direction.	*Note 4	
44	44-010A	—	—	45°	—	—	P	P	P	P	Saddle support from 12" to 18" in 7 direction.	*Note 4	
44	44-011	—	—	0°	P	P	—	—	—	—	Approx. 40% loss of coverage due to part configuration 360°.	*Note 4	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #44

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	8	Metrol	0	2	5	7	8		
44	44-011	—	—	45°	—	—	—	Y	N	P	P	Approx. 40% loss of contact due to part configuration 360°.	*Note 4
44	44-018	—	—	0°	P	P	—	—	—	—	—	Approx. 40% loss of coverage due to part configuration 360°.	*Note 4
44	44-018	—	—	45°	—	—	—	P	P	P	P	Approx. 40% loss of contact due to part configuration 360°.	*Note 4
44	44-027	—	—	0°	P	P	—	—	—	—	—	Approx. 25% loss of coverage due to part configuration 360° on 5 side only.	*Note 4
44	44-027	—	—	45°	—	—	—	Y	N	P	P	Approx. 25% loss of coverage due to part configuration 360°.	*Notes 4 & 5
44	44-034	—	—	0°	P	P	—	—	—	—	—	Approx. 25% loss of coverage due to part configuration 360°.	*Note 4
44	44-034	—	—	45°	—	—	—	Y	N	P	P	Approx. 25% loss of contact due to part configuration 360°.	*Notes 4 & 5
44	44-042	—	—	0°	P	P	—	—	—	—	—	Approx. 25% loss of coverage due to part configuration 360°.	*Note 4
44	44-042	—	—	45°	—	—	—	Y	N	P	P	Approx. 25% loss of coverage due to part configuration 360°.	*Notes 4 & 5
44	44-055A	—	—	45°	—	—	—	P	P	P	P	Par due to weld support in center of weld; .75" from g	*Notes 4 & 5
44	44-055A-085	—	—	0°	P	P	—	—	—	—	—	Scans are par on 8 side due to configuration and thickness. Approx. 30% loss of coverage.	*Note 4

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #44

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	1	2	5	7	8		
44	44-055A-085	—	—	45°	—	—	P	P	P	P	P	Scans are per on 8 side due to configuration and thickness. Approx. 30% loss of coverage.	*Notes 4 & 5
44	44-056	—	—	0°	P	P	—	—	—	—	—	Approx. 25% loss of coverage due to part configuration 360° on 5 side only.	*Note 4
44	44-056	—	—	45°	—	—	Y	N	P	P	P	Approx. 25% loss of coverage due to part configuration 360°.	*Notes 4 & 5
44	44-062	—	—	0°	P	P	—	—	—	—	—	Approx. 50% loss of coverage due to thickness change 360° on 5 side only.	*Note 4
44	44-062	—	—	45°	—	—	Y	N	P	P	P	Approx. 40% loss of coverage due to thickness change 360°.	*Notes 4 & 5
44	44-063	—	—	0°	P	P	—	—	—	—	—	Approx. 50% loss of coverage due to thickness change 360° on 2 side.	*Note 4
44	44-063	—	—	45°	—	—	N	Y	Y	Y	Y	Approx. 40% loss of coverage due to thickness change 360°.	*Notes 4 & 5
44	44-068	—	—	0°	P	P	—	—	—	—	—	Partial due to extruded header. Approx. 25% loss of coverage on 5 side only.	*Note 4
44	44-068	—	—	45°	—	—	Y	N	P	P	P	Partial due to extruded header. Approx. 25% loss of coverage 360°.	*Notes 4 & 5
44	44-073	—	—	0°	Y	P	—	—	—	—	—	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 4
44	44-073	—	—	45°	—	—	Y	Y	P	P	P	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Notes 4 & 5

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #44

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
44	44-074	—	—	0°	Y	P	-	-	-	-	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 4	
44	44-074	—	—	45°	—	-	Y	Y	P	P	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Notes 4 & 5	
44	44-075	—	—	0°	Y	P	-	-	-	-	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 4	
44	44-075	—	—	45°	—	-	Y	Y	P	P	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Notes 4 & 5	
44	44-076	—	—	0°	P	P	-	-	-	-	Approx. 40% loss of coverage due to valve body configuration on 2 side.	*Note 4	
44	44-076	—	—	45°	—	-	P	Y	Y	Y	Approx. 40% loss of coverage due to valve body configuration 360°.	*Notes 4 & 5	
44	44-087	—	—	0°	Y	P	-	-	-	-	Approx. 10% loss of coverage at toe of weld due to weld crown 360°.	*Note 4	
44	44-087	—	—	45°	—	-	Y	Y	P	P	Approx. 10% loss of contact at toe of weld due to weld crown 360°.	*Notes 4 & 5	
44	44-089	—	—	0°	Y	P	-	-	-	-	Approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 4	
44	44-089	—	—	45°	—	-	Y	Y	P	P	Approx. 10% loss of coverage due to O.D. weld geometry 360°.	*Notes 4 & 5	
44	44-093	—	—	0°	P	P	-	-	-	-	Approx. 40% loss of coverage due to valve configuration 360°.	*Note 4	

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Zone #44

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Zone #45

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LP&L WATERFORD #3

Zone #46

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
46	46-012	—	—	0°	Y	P	—	—	—	—	Approx. 12% loss of contact due to O.D. weld geometry 360°.	*Note 4	
46	46-012	—	—	45°	—	—	Y	Y	P	P	Approx. 12% loss of coverage due to O.D. weld geometry 360°.	*Notes 4 & 5	
46	46-014	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact due to the weld transition 360°.	*Note 4	
46	46-015	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact due to weld transition 360°.	*Note 4	
46	46-016	—	—	0°	Y	P	—	—	—	—	Approx. 10% loss of contact due to weld transition 360°.	*Note 4	
46	46-019	—	—	0°;45°	N	N	N	N	N	N	Examination could not be performed due to penetration design.	*Note 6	
46	46-021	—	—	0°	P	P	—	—	—	—	5 side base metal could not be performed and all other scans were limited because of the nozzle radius. Approx. 50% loss of coverage 360°.	*Note 4	
46	46-021	—	—	30° RL	—	—	P	N	P	P	5 side base metal and 5 scan could not be performed. Approx. 75% loss of coverage due to nozzle radius 360°.	*Note 4	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #47

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	SCANS							
						0	2	5	7	8			
47	47-001	—	—	0°	Y	P	-	-	-	-	Partial due to the weld crown. Approx. 10% loss of coverage 360°.	*Note 4	
47	47-002	—	—	0°	Y	P	-	-	-	-	Partial due to the weld crown. Approx. 10% loss of coverage 360°.	*Note 4	
47	47-005	—	—	0°	P	P	-	-	-	-	Partial base metal scan due to valve, sweepolet. Partial 0° scan due to the weld crown. Approx. loss of coverage 40%.	*Note 4	
47	47-005	—	—	45°	—	-	N	P	P	P	Partial on 5 scan due to sweepolet. Partial on 7 & 8 scan due to valve.	*Note 4	
47	47-007	—	—	0°	P	P	-	-	-	-	Partial base metal scan due to valve. Partial 0° scan due to weld crown 360°.	*Note 4	
47	47-007	—	—	45°	—	-	Y	N	P	P	Partial on 7 & 8 scan due to the valve configuration 360°.	*Notes 4 & 5	
47	47-009	—	—	0°	P	P	-	-	-	-	Partial on the base metal scan due to the valve. Partial on the 0° scan due to the weld crown 360°.	*Note 4	
47	47-009	—	—	45°	—	-	N	Y	P	P	No and partial due to the valve configuration 360°.	*Notes 4 & 5	
47	47-034	—	—	0°	P	P	-	-	-	-	Partial on the base metal scan due to the valve. Partial on the 0° scan due to the weld crown 360°.	*Note 4	
47	47-034	—	—	45°	—	-	Y	N	P	P	No and partial due to the valve for a loss of approx. 40% coverage 360°.	*Notes 4 & 5	

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LP&L WATERFORD #3

Zone #47

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# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #48

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
48	48-001	—	—	0°	Y	P	-	-	-	-	Partial due to the weld transition on the 5 side.	*Note 4	
48	48-005	—	—	0°	P	P	-	-	-	-	Partial due to valve body on the 2 side.	*Note 4	
48	48-005	—	—	45°	—	-	N	Y	P	P	No and partial due to the valve body on the 2 side. Approx. 40% loss of coverage 360°.	*Notes 4 & 5	
48	48-007	—	—	0°	P	P	-	-	-	-	Partial base metal scan due to the valve. Approx. 30% loss of coverage 360°.	*Note 4	
48	48-007	—	—	45°	—	-	Y	N	P	P	Partial and no due to valve configuration. Approx. 40% loss of coverage 360°.	*Notes 4 & 5	
48	48-009	—	—	0°	P	P	-	-	-	-	Partial base metal scan due to valve. Partial on 0° scan due to weld contour 360°.	*Note 4	
48	48-009	—	—	45°	—	-	N	Y	P	P	Partial and no due to valve configuration 360°. Approx. 40% loss of coverage.	*Notes 4 & 5	
48	48-035	—	—	0°	Y	P	-	-	-	-	Partial due to weld crown; approx. 10% not covered 360°.	*Note 4	
48	48-035	—	—	45°	—	-	Y	Y	P	P	Partial due to weld crown; approx. 10% not covered 360°.	*Notes 4 & 5	
48	48-036	—	—	0°	P	P	-	-	-	-	Partial base metal scan due to valve. Partial 0° scan due to weld crown.	*Note 4	
48	48-036	—	—	45°	—	-	Y	N	P	P	Partial and no due to valve causing approx. 40% loss of coverage 360° on 5 side.	*Notes 4 & 5	

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LP & L WATERFORD #3

Zone #48

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LP&L WATERFORD #3

Zone #49

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	S E C T I O N S								
					B	Metals	1	2	5	7	8		
49	49-014	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown; approx. 10% of weld not covered 360°.	*Note 4
49	49-015	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown; approx. 10% of weld not covered 360°.	*Note 4
49	49-020	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown; approx. 10% of weld not covered 360°.	*Note 4
49	49-029	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown; approx. 10% of weld not covered due to loss of contact 360°.	*Note 4
49	49-032	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown; approx. 5% of weld not covered due to loss of contact 360°.	*Note 4
49	49-041	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown; approx. 10% of weld not covered due to loss of contact 360°.	*Note 4
49	49-055	Y	—	—	—	—	—	—	—	—	—	Partial due to whip restraint 7" area, 27" through 34" from datum.	
49	49-059	—	—	45°	—	—	Y	Y	P	P	—	Partial due to the weld contour causing loss of contact on the 5 side 360°. Approx. 10% of inspection partial.	*Notes 4 & 5

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #50

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
50	50-015	—	—	0°	Y	P	—	—	—	—	Partial due to O.D. weld geometry causing 5% loss of contact 360°.	*Note 4	
50	50-015	—	—	45°	—	—	Y	Y	P	P	Partial due to O.D. weld geometry causing 5% loss of contact 360°.	*Notes 4 & 5	
50	50-023	—	—	0°	P	P	—	—	—	—	Base metal scan partial on the 5 side due to a 1" branch connection from 43" to 1" (44" circumference). 0° scan had approx. 5% loss of contact due to O.D. weld geometry.	*Note 4	
50	50-023	—	—	45°	—	—	Y	Y	P	P	Approximate 8% loss of contact due to O.D. weld geometry 360°.	*Notes 4 & 5	
50	50-040	—	—	0°	Y	P	—	—	—	—	0° scan had approx. 5% loss of contact due to O.D. weld geometry 360°.	*Note 4	
50	50-040	—	—	45°	—	—	Y	Y	P	P	Approx. 8% loss of contact due to O.D. weld geometry 360°.	*Notes 4 & 5	
50	50-045	—	—	0°	Y	P	—	—	—	—	Partial; approx. 10% loss of contact due to O.D. weld geometry 360°.	*Note 4	
50	50-045	—	—	45°	—	—	Y	Y	P	P	Partial; approx. 10% loss of contact due to O.D. weld geometry.	*Notes 4 & 5	
50	50-072	Y	—	—	—	—	—	—	—	—	Partial due to welded support limiting accessibility; area approx. 7", 26" through 33" from datum.	Permanent partial due to support configuration.	



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 3 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #51

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
51	51-004	—	—	0°	P	P	-	-	-	-	Partial due to tee configuration on the 2 side	*Note 4	
51	51-004	—	—	45°	—	-	N	Y	P	P	Partial due to the tee connection along the toe of the weld on the 2 side.	*Notes 4 & 5	
51	51-005	—	—	0°	P	P	-	-	-	-	Partial due to 14" x 14" x 6" tee; base metal examined on the 2 side only. 0° scan performed on weld crown and 2 side of H.A.Z.	*Note 4	
51	51-005	—	—	45°	—	-	P	N	P	P	Partial due to 14" x 14" x 6" tee; 2 scan, partial from datum to 3" and 18" through 21" from datum due to elbow intrados. 7 & 8 scans only performed on the weld and 2 side of H.A.Z.	*Note 4	
51	51-009	—	—	0°	P	P	-	-	-	-	Partial due to tee configuration on the 5 side.	*Note 4	
51	51-009	—	—	45°	—	-	Y	N	P	P	Partial due to the tee configuration along the toe of the weld on the 5 side.	*Notes 4 & 5	
51	51-010	—	—	0°	P	P	-	-	-	-	Partial due to 6 welded lugs on the 5 side, 3/4" from the weld, 2-1/4" wide. Approx. 5% of the 0° scan and 20% of the base metal scan not covered.	*Note 4	
51	51-010	—	—	45°	—	-	Y	P	Y	Y	Partial due to 6 welded lugs on the 5 side, 3/4" from the weld, 2-1/4" wide. Approx. 70% in front of the lugs not covered.	*Notes 4 & 5	
51	51-013	—	—	0°	Y	P	-	-	-	-	Partial due to the weld transition causing loss of contact; approx, 10% loss of coverage 360°.	*Note 4	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #51

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
51	51-014-900	—	—	0°	Y	P	-	-	-	-	Partial due to the weld toe causing approx. 15% loss of contact 360°.	*Note 4	
51	51-015	N	—	—	N	N	N	N	N	N	Relief request.	*Note 6	
51	51-016-900	—	—	0°	P	P	-	-	-	-	Partial on the 0° scan due to the weld transition causing loss of contact; approx. 10% of the weld. Partial also due to the slope from the penetration causing loss of back reflection. Slope begins approx. 1" from the toe of the weld.	*Note 4	
51	51-016-900	—	—	45°	—	-	Y	P	Y	Y	Partial due to the slope from the penetration beginning approx. 1" from the toe of the weld on the 5 side.	*Notes 4 & 5	
51	51-017	—	—	0°	Y	P	-	-	-	-	Partial due to the weld transition causing loss of contact; approx. 10% not covered.	*Note 4	
51	51-018-900	—	—	0°	P	P	-	-	-	-	Partial due to the valve body on the 2 side.	*Note 4	
51	51-018-900	—	—	45°	—	-	N	Y	P	P	Partial due to the valve body on the 2 side.	*Notes 4 & 5	
51	51-020	—	—	0°	P	P	-	-	-	-	Partial due to the valve configuration on the 5 side.	*Note 4	
51	51-020	—	—	45°	—	-	Y	N	P	P	Partial due to the valve configuration along the toe of the weld on the 5 side 360°.	*Notes 4 & 5	
51	51-025	—	—	0°	Y	P	-	-	-	-	Partial due to the weld crown; approx. 10% loss of contact at the toe of the weld.	*Note 4	

# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #51

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	Scans	B Metal	0	2	5	7	8		
51	51-025	—	—	45°	—	—	Y	Y	Y	P	P	Partial due to O.D. weld geometry; approx. 10% loss of contact 360°.	*Notes 4 & 5
51	51-026	—	—	0°	P	P	—	—	—	—	—	Partial on the base metal scan due to a gouge 3/8" x 5/32", located 5-1/2" from 0° and 2" from centerline on the 5 side causing loss of contact in that area.	*Note 4
51	51-027	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown causing loss of contact; approx. 5% at the toe of the weld.	*Note 4
51	51-027	—	—	45°	—	—	Y	Y	Y	P	P	Partial due to O.D. weld geometry causing approx. 5% loss of contact 360°.	*Notes 4 & 5
51	51-028	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown causing approx. 5% loss of contact at the toe of the weld.	*Note 4
51	51-028	—	—	45°	—	—	Y	Y	Y	P	P	Partial due to O.D. weld geometry causing approx. 5% loss of contact 360°.	*Notes 4 & 5
51	51-029	—	—	0°	P	P	—	—	—	—	—	Partial due to a restraint on the 2 side from 10" to 13" and from 32-3/4" to 35-3/4", also on the 5 side 7-1/2" to 15-1/4" and from 20-1/2" to 25-1/2" and from 3" to 37-3/4". Partial also due to the weld crown; approx. 10% loss of contact at the toe of the weld.	*Note 4
51	51-029	—	—	45°	—	—	P	P	P	P	P	Partial due to restraint around the inspection area. 2 scan 9-3/4" to 12-1/4" and 32" to 35". 5 scan 8" to 14-1/2". 20" to 24" and 30" to 36-1/2". 7 & 8 scan, missing 1/2" of far H.A.Z. (H.A.Z.=1") on the 5 side; missing the weld and H.A.Z. on the 2 side; 7 & 8 scan	*Note 4

(continued)



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LP&L WATERFORD #3

Zone #51

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
cont'd	51-029											approx. 5% loss of contact due to O.D. weld geometry.	
51	51-030	—	—	0°	Y	P	—	—	—	—	—	Partial due to the weld crown causing approx. 5% loss of contact at the toe of the weld	*Note 4
51	51-030	—	—	45°	—	—	Y	Y	P	P	—	Partial due to O.D. weld geometry causing approx. 5% loss of contact 360°.	*Notes 4 & 5
51	51-033	—	—	0°	P	P	—	—	—	—	—	Partial due to the valve on 2 side only	*Note 4
51	51-033	—	—	45°	—	—	N	Y	P	P	—	Partial due to the valve on the 2 side 360°	*Notes 4 & 5
51	51-036	—	—	0°	Y	P	—	—	—	—	—	Partial due to weld crown causing approx. 5% loss of contact at the toe of the weld.	*Note 4
51	51-048	—	—	0°	Y	P	—	—	—	—	—	Partial due to weld crown approx. 5% loss of coverage 360°	*Note 4
51	51-WS-4	Y	—	—	—	—	—	—	—	—	—	Partial exam due to bleedout caused by carbon steel shim positioned flush with support lug.	*Note 4
									</				



# SUMMARY SHEET - PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #52

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					0 Metal	0	2	5	7	8			
52	52-004	—	—	0°	P	P	-	-	-	-	Partial due to the tee configuration on the 2 side.	*Note 4	
52	52-004	—	—	45°	—	-	N	Y	P	P	Partial due to the tee connection on the 2 side.	*Notes 4 & 5	
52	52-005	—	—	0°	Y	P	-	-	-	-	Partial due to the weld contour and tee on the 5 side.	*Note 4	
52	52-005	—	—	45°	—	-	Y	N	P	P	Partial due to the weld contour and tee on the 5 side.	*Notes 4 & 5	
52	52-009	—	—	0°	P	P	-	-	-	-	Partial due to the tee body on the 5 side. Partial on the 0° scan due to the weld transition causing approx. 10% loss of contact.	*Note 4	
52	52-009	—	—	45°	—	-	Y	N	P	P	Partial due to the tee body on the 5 side.	*Notes 4 & 5	
52	52-010	—	—	0°	Y	P	-	-	-	-	Partial due to the weld transition causing approx. 10% loss of contact.	*Note 4	
52	52-015-900	—	—	0°	Y	P	-	-	-	-	Partial due to the weld toe; approx. 25% not covered.	*Note 4	
52	52-016	—	—	—	N	N	N	N	N	N	Inaccessible.	*Note 6	
52	52-017-900	—	—	0°	P	Y	-	-	-	-	Partial due to the penetration level on the 5 side, 2" from the toe of the weld.	*Note 4	
52	52-017-900	—	—	45°	—	-	Y	P	Y	Y	Partial due to the penetration bevel 1" from the toe of the weld on the 5 side, 360°.	*Note 4 & 5	

# SUMMARY SHEET - PARTIAL EXAM

Page 2 of 3

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #52

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	P	Metol	0	2	5	7	8		
52	52-018	—	—	45°	—	—	—	Y	Y	P	P	Partial due to loss of contact of the tee of the weld, approx. 10%.	*Notes 4 & 5
52	52-019-900	—	—	0°	P	P	—	—	—	—	—	Partial due to the valve on the 2 side.	*Note 4
52	52-019-900	—	—	45°	—	—	—	N	Y	P	P	Partial due to the valve on the 2 side.	*Notes 4 & 5
52	52-021	—	—	0°	P	P	—	—	—	—	—	Partial due to the weld transition causing loss of contact approx. 10%. Partial also due to the valve body on the 5 side.	*Note 4
52	52-021	—	—	45°	—	—	—	Y	N	P	P	Partial due to the valve body on the 5 side.	*Notes 4 & 5
52	52-026	—	—	0°	P	P	—	—	—	—	—	Partial due to the tee connection on the 2 side, Partial also due to the weld crown, approx. 10% loss of contact at the toe of the weld.	*Note 4
52	52-026	—	—	45°	—	—	—	N	Y	P	P	Partial due to the tee connection on the 2 side.	*Notes 4 & 5
52	52-027	—	—	0°	P	P	—	—	—	—	—	Partial due to the tee connection on the 5 side and weld crown causing loss of contact on the 2 side.	*Note 4
52	52-027	—	—	45°	—	—	—	P	N	P	P	Partial due to the tee connection on the 5 side and weld crown causing loss of contact on the 2 side.	*Notes 4 & 5
52	52-041	—	—	0°	P	P	—	—	—	—	—	Partial due to tee on the 5 side and weld crown causing approx. 5% loss of contact.	*Note 4

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LP&L WATERFORD #3

Zone #52

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LP&L WATERFORD #3

Zone #53

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
53	53-058	—	—	0°	P	P	—	—	—	—	Partial due to the flange on the 2 side,	*Note 4	
53	53-058	—	—	45°	—	—	N	P	P	P	Partial due to the reducer configuration, approx. 10% not covered,	*Note 4	
53	53-065	—	—	0°	Y	P	—	—	—	—	Partial due to the weld crown causing loss of contact, approx. 10% not covered,	*Note 4	
53	53-068	—	—	0°	P	P	—	—	—	—	Partial due to support from 0" to 2" and from 32" to 34" on the 5 and 2 side of the weld. Partial due to the weld crown; approx. 40% not covered at the toe of the weld and support.	*Note 4	
53	53-068	—	—	45°	—	—	Y	Y	P	P	Partial due to the weld crown; approx. 20% not covered.	*Notes 4 & 5	
53	53-079	—	—	0°	P	P	—	—	—	—	0° scan due to weld crown; base metal due to SDCHX.	*Note 4	
53	53-079	—	—	45°	—	—	P	P	P	P	2, 7 & 8 scans due to SDCHX. 5 scan due to SDCHX.	*Note 4	
53	53-080	—	—	0°	P	P	—	—	—	—	0° scan due to weld contour. Base metal due to SDCHX.	*Note 4	
53	53-080	—	—	45°	—	—	P	P	P	P	5, 7 & 8 scans due to weld contour. 2 scan due to SDCHX.	*Note 4	



## Page 1 of 1

LP&L WATERFORD #3

Zone #54

[illegible]

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LP&L WATERFORD #3

Zone #55

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
55	55-018	—	—	0°	Y	P	—	—	—	—	Partial due to the weld crown, approx. 5% not covered due to loss of contact at the toe of the weld.	*Note 4	
55	55-023	—	—	0°	Y	P	—	—	—	—	Partial due to the weld crown, approx. 5% not covered due to loss of contact at the toe of the weld.	*Note 4	
55	55-040	—	—	0°	P	P	—	—	—	—	Partial due to valve body on the 5 side 360°, 1" drain line at 180°, reducer configuration 260°, loss of contact at the toe 360°.	*Note 4	
55	55-040	—	—	45°	—	—	P	N	P	P	Partial due to valve body on the 5 side 360°, 1" drain line at 180°, reducer configuration 360°, loss of contact at the toe 360°.	*Note 4	
55	55-042	—	—	0°	P	Y	—	—	—	—	Partial due to 1" sweepolet on the 5 side 180°.	*Note 4	
55	55-042	—	—	45°	—	—	Y	P	Y	Y	Partial due to O.D. weld taper and 1" sweepolet on the 5 side.	*Notes 4 & 5	
55	55-048	—	—	0°	P	Y	—	—	—	—	Partial due to the O.D. taper on the 2 side.	*Note 4	
55	55-048	—	—	45°	—	—	P	Y	Y	Y	Partial due to the O.D. taper on the 2 side.	*Notes 4 & 5	
55	55-049	N	—	—	—	—	—	—	—	—	Relief request	*Note 6	
55	55-050	—	—	0°	Y	P	—	—	—	—	Partial due to the weld transition causing loss of contact.	*Note 4	

# SUMMARY SHEET - PARTIAL EXAM

Page 2 of 3

NOTE: 2 & 3 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #55

ZONE	WELD DESIGN	PT	MT	ULTRASONICS									PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SECTIONS									
					B Metal	0	2	5	7	8				
55	55-051	—	—	0°	P	P	-	-	-	-	-	Partial due to the valve configuration on the 2 side.	*Note 4	
55	55-051	—	—	45°	—	-	N	Y	P	P	-	Partial due to the valve along the toe of the weld on the 2 side.	*Notes 4 & 5	
55	55-054	—	—	0°	P	P	-	-	-	-	-	Partial due to loss of contact of the toe of weld 360°; approx. 10% not covered.	*Note 4	
55	55-054	—	—	45°	—	-	Y	Y	P	P	-	Partial due to loss of contact at the toe of the weld 360°; approx. 10% not covered.	*Notes 4 & 5	
55	55-066	—	—	0°	P	P	-	-	-	-	-	Partial due to the valve on the 2 side 360°, reducer configuration 360°, loss of contact at toe 360°.	*Note 4	
55	55-066	—	—	45°	—	-	N	P	P	P	-	Partial due to the valve on the 2 side 360°, reducer configuration 360°, loss of contact at the toe 360°.	*Note 4	
55	55-068	—	—	0°	P	P	-	-	-	-	-	Partial due to valve body on the 5 side 360°, reducer configuration 360°, loss of contact at the toe of the weld 360°.	*Note 4	
55	55-068	—	—	45°	—	-	P	N	P	P	-	Partial due to the valve body on the 5 side 360°, reducer configuration 360°, loss of contact of the toe of the weld 360°.	*Note 4	
55	55-070	—	—	0°	P	Y	-	-	-	-	-	Partial due to 1" sweepolet 180° on the 5 side.	*Note 4	

## Page 3 of 3

LP&L WATERFORD #3

Zone #55

[illegible]



# SUMMARY SHEET - PARTIAL EXAM

Page 1 of 3

NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #56

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8			
56	56-008	—	—	0°	Y	P	—	—	—	—		Partial due to the weld crown, approx. 5% not covered due to loss of contact.	*Note 4
56	56-021	—	—	0°	Y	P	—	—	—	—		Partial due to the weld crown, approx. 10% not covered due to loss of contact at the toe of the weld.	*Note 4
56	56-025	—	—	0°	Y	P	—	—	—	—		Partial due to the weld crown, approx. 5% not covered due to loss of contact at the toe of the weld.	*Note 4
56	56-030	—	—	0°	Y	P	—	—	—	—		Partial due to weld crown causing approx. 5% loss of contact.	*Note 4
56	56-030	—	—	45°	—	—	Y	Y	P	P		Partial due to weld crown causing approx. 5% loss of contact.	*Notes 4 & 5
56	56-038	—	—	0°	P	P	—	—	—	—		Partial due to valve body on the 2 side, 1" drain line at 180°, and loss of contact at the toe of the weld.	*Note 4
56	56-038	—	—	45°	—	—	N	P	P	P		Partial due to valve body on the 2 side, 1" drain line at 180°, and loss of contact at the toe of the weld.	*Note 4
56	56-040	—	—	0°	P	P	—	—	—	—		Partial due to valve body on the 5 side, 1" drain line 180°, reducer configuration and loss of contact at the toe of the weld.	*Note 4
56	56-040	—	—	45°	—	—	P	N	P	P		Partial due to valve body on 5 side, 1" drain line at 180°, reducer configuration and loss of contact at toe of weld.	*Note 4

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LP&L WATERFORD #3

Zone #56

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
56	56-042	—	—	0°	P	Y	-	-	-	-	Partial on 5 side due to 1" sweepolet at 180°.	*Note 4	
56	56-042	—	—	45°	—	-	P	P	P	P	Partial due to reducer and 1" sweepolet on 5 side, weld crown 360°.	*Notes 4 & 5	
56	56-047	—	—	0°	P	P	-	-	-	-	Partial on base metal scan due to penetration on the 2 side. Partial on 0° scan due to weld transition causing loss of contact of approx. 10%.	*Note 4	
56	56-047	—	—	45°	—	-	N	Y	Y	Y	No on the 2 scan due to the penetration.	*Notes 4 & 5	
56	56-048	N	—	—	N	N	N	N	N	N	Inaccessible (penetration)	*Note 6	
56	56-049	—	—	0°	Y	P	-	-	-	-	Partial due to the weld geometry causing loss of contact of approx. 10%.	*Note 4	
56	56-050	—	—	0°	P	P	-	-	-	-	Partial due to valve configuration on the 2 side.	*Note 4	
56	56-050	—	—	45°	—	-	N	Y	P	P	No and partials due to the valve along the toe of the weld on the 2 side 360°.	*Notes 4 & 5	
56	56-064	—	—	0°	Y	P	-	-	-	-	Partial due to the weld crown, approx. 5% not covered due to loss of contact at toe of weld.	*Note 4	
56	56-070	—	—	0°	P	P	-	-	-	-	Partial due to valve body on 5 side, drain line at 180°, reducer configuration causing loss of contact at toe of weld.	*Note 4	
				</									

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LP&L WATERFORD #3

Zone #56

ZONE	WELD DESIGN	PT	MT	ULTRASONICS							PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	B Metal	0	2	5	7	8		
56	56-070	—	—	45°	—	P	N	P	P	Partial due to valve body on 5 side, drain line at 180°, reducer configuration causing loss of contact at the toe of the weld.	*Notes 4 & 5	
56	56-072	—	—	0°	P	Y	—	—	—	Partial due to sweepolet on the 5 side at 180°	*Note 4	
56	56-072	—	—	45°	—	Y	P	Y	Y	Partial due to reducer and sweepolet on the 5 side.	*Notes 4 & 5	
56	56-077	—	—	0°	P	Y	—	—	—	Partial due to penetration on the 2 side.	*Note 4	
56	56-077	—	—	45°	—	P	Y	Y	Y	Partial due to penetration on 2 side.	*Notes 4 & 5	
56	56-078	N	—	—	N	N	N	N	N	Inaccessible (penetration)	*Note 6	
56	56-080	—	—	0°	P	P	—	—	—	Partial due to valve configuration on the 2 side 360°.	*Note 4	
56	56-080	—	—	45°	—	N	P	P	P	Partials due to valve along the toe of the weld and weld crown 360°.	*Note 4	

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LP&L WATERFORD #3

Zone #57

[illegible]



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LP&L WATERFORD #3

Zone #58

[illegible]

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LP&L WATERFORD #3

Zone #60

[illegible]

# SUMMARY SHEET- PARTIAL EXAM

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NOTE: 2 & 5 Scans Parallel  
7 & 8 Scans Circumferential

LP&L WATERFORD #3

Zone #61

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
61	61-041	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 4	
61	61-041	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact at toe of weld 360°.	*Notes 4 & 5	
61	61-042	—	—	0°	P	P	—	—	—	—	Approx. 10% loss of contact at toe of weld 360°.	*Note 4	
61	61-042	—	—	45°	—	—	Y	Y	P	P	Approx. 10% loss of contact at toe of weld 360°.	*Notes 4 & 5	
61	61-046	—	—	0°	Y	P	—	—	—	—	Approx. 5% loss of contact at toe of weld 360°.	*Note 4	
61	61-047	—	—	0°	Y	P	—	—	—	—	Approx. 5% loss of contact at toe of weld 360°.	*Note 4	
61	61-051	—	—	0°	P	P	—	—	—	—	Approx. 30% loss of contact due to tee configuration on 5 side.	*Note 4	
61	61-051	—	—	45°	—	—	Y	N	P	P	Approx. 30% loss of contact due to tee configuration.	*Notes 4 & 5	
61	61-071	—	—	0°	P	P	—	—	—	—	Approx. 40% loss of coverage due to 8" reducer to flange weld configuration 360°.	*Note 4	
61	61-071	—	—	45°	—	—	P	P	P	P	Approx. 40% loss of coverage due to 8" reducer to flange weld configuration.	*Note 4	
61	61-073	—	—	0°	P	P	—	—	—	—	Approx. 5% loss of contact at toe of weld 360°.	*Note 4	

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**NOTE: 2 & 5 Scales Parallel  
7 & 8 Scales Circumferential**

Zone #61

[illegible]



## Page 1 of 1

LP&L WATERFORD #3

Zone #62

ZONE	WELD DESIGN	PT	MT	ULTRASONICS								PARTIAL DESCRIPTION	COMMENTS OR ALTERNATE EXAMS CONSIDERED
				SCAN ANGLE	SCANS								
					B Metal	0	2	5	7	8			
62	62-047	—	—	0°	—	P	—	—	—	—	Approx. 30% loss of contact due to tee configuration.	*Note 4	
62	62-047	—	—	45°	—	—	Y	N	Y	Y	Approx. 20% loss of contact due to tee configuration.	*Notes 4 & 5	
62	62-075	—	—	0°	P	P	—	—	—	—	Approx. 30% loss of contact due to tee	*Note 4	
62	62-075	—	—	45°	—	—	Y	N	P	P	Approx. 20% loss of contact due to tee connection.	*Notes 4 & 5	
62	62-078	—	—	0°	P	P	—	—	—	—	Valve on 2 side, partial due to weld crown. Approx. 30% loss of contact at toe and on surface of weld.	*Note 4	
62	62-078	—	—	45°	—	—	N	Y	P	P	Valve along toe of weld 2 side. Approx. 30% loss of coverage.	*Notes 4 & 5	
62	62-089	—	—	0°	P	P	—	—	—	—	Flange on 2 side.	*Note 4	
62	62-089	—	—	45°	—	—	N	Y	P	P	Flange on 2 side.	*Notes 4 & 5	
62	62-094	—	—	0°	P	P	—	—	—	—	Partial due to 1" line.	*Note 4	
62	62-098	—	—	0°	P	P	—	—	—	—	Tee on 5 side.	*Note 4	
62	62-098	—	—	45°	—	—	Y	P	P	P	Approx. 30% loss of contact due to tee connection on 5 side.	*Notes 4 & 5	

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LP&L WATERFORD #3

Zone #64

[illegible]

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LP&L WATERFORD #3

Zone #65

[illegible]

- Note 1 The volume required to be examined by ASME, Section XI, 1977 edition, with addenda through Summer, 1978, figure LWB-2500-8 could not be examined.
- Note 2 The volume required to be examined by ASME, Section XI, 1977 edition, with addenda through Summer, 1978, figure LWB-2500-8 could only be partially examined.
- Note 3 The volume required to be examined by ASME, Section XI, 1977 Edition, with addenda through Summer, 1978, figure LWC-2520-7 could not be examined.
- Note 4 The volume required to be examined by ASME, Section XI, 1977 edition, with addenda through Summer, 1978, figure LWC-2520-8 could only be partially examined.
- Note 5 The volume required to be examined by inservice examination by ASME, Section XI, 1977 edition, with addenda through Summer, 1978 (i.e. the lower 1/3T) can be completely examined.
- Note 6 Relief Request submitted for this item.

"Y" Yes, 100% coverage  
"N" No examination performed  
"P" Partial examination  
"\_" Does not apply



**TITLE**

Legend for Partial Examination Summary Sheets





**LOUISIANA**  
POWER & LIGHT

WATERFORD 3 SES  
PRESERVICE INSPECTION PROGRAM

REQUEST FOR RELIEF

RELIEF REQUEST NO:

PSI-02

COMPONENT/ITEM/SYSTEM:	CODE CLASS:	CODE CATEGORY:	ITEM NO:	PARAGRAPH:
Pressurizer Surge Line Weld No. 16-012: Inaccessible Weld; No Exam Performed	1	B-J	B9.11	IWB-2200 IWB-2500

CODE REQUIREMENT:

All required examinations shall be completed prior to initial plant startup. Components shall be examined and tested as specified in Table IWB-2500-1. Table IWB-2500-1, Item B9.11 requires a surface and volumetric exam for the subject weld.

BASIS/JUSTIFICATION:

Weld no. 16-012 is located approximately midway through a 4-foot thick concrete wall, enclosing the pressurizer. Insufficient clearance exists between the pipe and the wall bore to permit the insertion of examination materials or equipment.

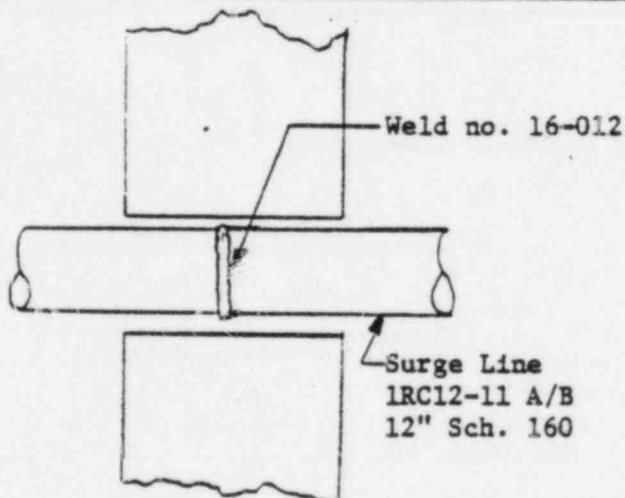
ALTERNATIVE EXAMINATION(S):

ASME Section III NDE records are available for this weld under weld designation number CE 209-751.

SCHEDULE FOR IMPLEMENTATION:

N/A

COMMENTS/SKETCHES:



ATTACHMENT(S):      Yes   X   No



**LOUISIANA**  
POWER & LIGHT

WATERFORD 3 SES  
PRESERVICE INSPECTION PROGRAM

REQUEST FOR RELIEF

RELIEF REQUEST NO:

PSI-03

COMPONENT/ITEM/SYSTEM:	CODE CLASS:	CODE CATEGORY:	ITEM NO:	PARAGRAPH:
Pressure Retaining Welds in Piping: Volumetric Sampling vs. Surface Examinations of Safety Injection Suction Piping Welds	2	C-F	C5.11	IWC-2200 & 2500
<b>CODE REQUIREMENT:</b> All required examinations shall be completed prior to initial plant startup. Components shall be examined and tested as specified in Table IWC-1220 1. Table IWC-1220-1 requires surface examination of the subject welds.				
<b>BASIS/JUSTIFICATION:</b> Relief is requested from the surface examination requirement based on the following: A. Design pressure/temperature is specified as 160 psig/250°F, based on accident conditions. However, for all other operating conditions, the pressure and temperature will approximately equal to ambient. Therefore, the exemption of IWC-1220(a) of the 1974 Edition through Summer 1975 Addenda is cited. ★				
<b>ALTERNATIVE EXAMINATION(S):</b> A ten (10) percent volumetric sampling, using ultrasonic techniques, has been applied to welds in the safety injection suction lines. Details are available in the PSI Program submittal, dated January 28, 1983				
<b>SCHEDULE FOR IMPLEMENTATION:</b> Preservice Inspection				
<b>COMMENTS/SKETCHES:</b> ★ B. This piping is susceptible to intergranular attack (IGSCC) since it normally contains stagnant borated water and is fabricated from 304 stainless. Therefore, ultrasonic inspection would be more relevant for these welds.				

ATTACHMENT(S):           Yes        X   No



**LOUISIANA**  
POWER & LIGHT

WATERFORD 3 SES  
PRESERVICE INSPECTION PROGRAM

REQUEST FOR RELIEF

RELIEF REQUEST NO:

PSI-04

COMPONENT/ITEM/SYSTEM:	CODE CLASS:	CODE CATEGORY:	ITEM NO:	PARAGRAPH:
Pressure Retaining Welds in Piping: Inaccessible Welds in Containment Penetrations	2	C-F	C5.11 C5.21	IWC-2200 & 2500

CODE REQUIREMENT:

All required examinations shall be completed prior to initial plant startup. Components shall be examined and tested as specified in Table IWC-2500-1. Item C5.11 requires surface examination; item C5.21 requires surface and volumetric exams.

BASIS/JUSTIFICATION:

- A. The subject welds are totally enclosed in guard pipes and are completely inaccessible. The design/pressure and temperature of the guard pipes are equal to the maximum operating pressure and temperature of the enclosed pipes.
- B. An augmented ISI Program has been instituted to ensure the structural integrity of high-energy fluid piping greater than 4-inch NPS penetrating containment.

ALTERNATIVE EXAMINATION(S):

Refer to the Preservice Inspection Program submittal, dated January 28, 1983 for detailed information regarding the Waterford 3 Augmented ISI Program.

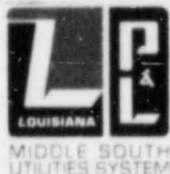
SCHEDULE FOR IMPLEMENTATION:

N/A

COMMENTS/SKETCHES:

N/A

ATTACHMENT(S): ☐ Yes ☒ No



**LOUISIANA**  
POWER & LIGHT

WATERFORD 3 SES  
PRESERVICE INSPECTION PROGRAM

REQUEST FOR RELIEF

RELIEF REQUEST NO:

PSI-05

COMPONENT/ITEM/SYSTEM:	CODE CLASS:	CODE CATEGORY:	ITEM NO:	PARAGRAPH:
Pressure Retaining Nozzle Welds in Vessels: Inaccessible Welds in Shutdown Cooling Heat Exchangers (SCHX'S)	2	C-B	C2.20	IWC-2000 & 2500

CODE REQUIREMENT:

All required examinations shall be completed prior to initial plant startup. Components shall be examined and tested as specified in Table IWC-2500-1. Surface and volumetric examinations are required.

BASIS/JUSTIFICATION:

A reinforcing collar has been welded to the heat exchanger shell and the nozzle body, making the subject welds completely inaccessible.

ALTERNATIVE EXAMINATION(S):

- A. ASME Section III NDE records are available on file.
- B. A surface examination was performed on all collar-to-nozzle and collar-to-shell welds.

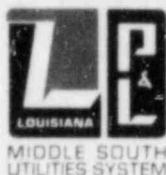
SCHEDULE FOR IMPLEMENTATION:

Preservice Inspection

COMMENTS/SKETCHES:

ATTACHMENT(S):         Yes      X   No





**LOUISIANA**  
POWER & LIGHT

WATERFORD 3 SES  
PRESERVICE INSPECTION PROGRAM

REQUEST FOR RELIEF

RELIEF REQUEST NO:

PSI-06

COMPONENT/ITEM/SYSTEM:	CODE CLASS:	CODE CATEGORY:	ITEM NO:	PARAGRAPH:
-----SEE BELOW-----				IWB-2200 & 2500 IWC-2200 & 2500

CODE REQUIREMENT:

All required examinations shall be completed prior to initial plant startup. Components shall be examined and tested as specified in Tables IWB-2500-1 and IWC-2500-1.

BASIS/JUSTIFICATION:

Relief is requested from the requirements to perform the examinations listed below in the "Comments/Sketches" section during PSI. Credit will be taken for ASME Section III Shop or Construction NDE reports, as indicated.

ALTERNATIVE EXAMINATION(S):

See below

SCHEDULE FOR IMPLEMENTATION:

N/A

COMMENTS/SKETCHES:

<u>Item</u>	<u>Class</u>	<u>Category</u>	<u>Item</u>	<u>Required Method (XI)</u>	<u>Exam(s) Performed (III)</u>
Reactor Coolant Pump Casing Welds	1	B-L-1	B12.10	Vol. & Surf.	RT, PT
Reactor Coolant Pump Studs	1	B-G-1	B6.190	Vol. & Surf.	MT*

\*A volumetric examination (UT) was performed during PSI

ATTACHMENT(S):         Yes      X   No