

CASK TRANSFER FACILITY

Weld Data Sheet - 3115 - Tower

Weld Information Weld ID	Welder, WPS & Weld Material			NDE Information (when required either MT or PT can be used)								
	Welder ID	WPS	Weld Wire ID	VT	Initial	Date	PT	Initial	Date	MT	Initial	Date
1/8" Fillets	F	81 REV 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	E	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	K	81 REV 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
3/16" Fillets	E	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	F	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"				X	SND		n/a			n/a		
1/4" Fillets	E	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	F	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	K	81 REV 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
5/16" Fillets	K	81 REV 1	Lot 5705	X	SND	9/20/00	n/a			n/a		

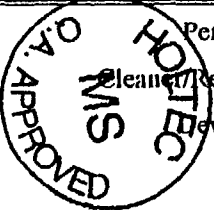
Page 2-37

C.10 22

NDE Materials

Penetrant _____ Batch _____ MT Yoke S/N _____
 Cleaner/Remover _____ Batch _____ Powder _____
 Developer _____ Batch _____

NDE Procedures: VT - HSP-211 Rev. 1/2 PT - HSP-201 Rev. ___ MT - HSP-204 Rev. ___



All Completed Welds must be stamped.

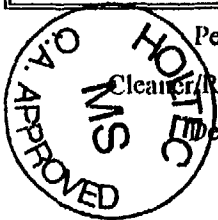
Prepared by: *[Signature]*
 Approved by: *[Signature]*
 Date: 8/16/01

CASK TRAN. R FACILITY

Weld Data Sheet - 3115 - Tower

Weld Information Weld ID	Welder, WPS & Weld Material			NDE Information (when required either MT or PT can be used)								
	Welder ID	WPS	Weld Wire ID	VT	Initial	Date	PT	Initial	Date	MT	Initial	Date
5/16" Fillets	E	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	F	81 Rev 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
1" Plug Welds	E	81 REV 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"	F	81 REV 1	Lot 5705	X	SND	9/20/00	n/a			n/a		
"				X			n/a			n/a		
Full Penetration Welds	E	81 Rev 1	Lot 5705	X	SND	9/20/00	X			X	SND	9/20/00
"	F	81 Rev 1	Lot 5705	X	SND	9/20/00				X	SND	9/20/00
"	K	81 REV 1	Lot 5705	X	SND	9/20/00				X	SND	9/20/00

NDE Materials



Penetrant _____
 Cleaner/Remover _____
 Developer _____

Batch _____
 Batch _____
 Batch _____

MT Yoke S/N 53530
 Powder Dry-Red
 Batch 9914054

NDE Procedures: VT - HSP-211 Rev. 12 PT - HSP-201 Rev. MT - HSP-204 Rev. 1

Prepared by: [Signature]

Approved by: [Signature] 8/11

Page 2-38

56

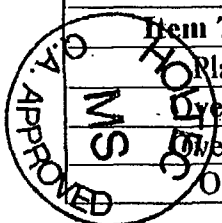
**CASK TRANSFER UTILITY FABRICATION
INSPECTION PLAN - 3115 Rev 0**

SUB ASSEMBLY: TOWER

DRAWINGS: 3115 Sheets 1 thru 4

Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
Component Inspection				
Item 70 (2 reqd)				
Plate Thickness	0.75"	WJS 8/1/00 Same-as	26' TAPE # 5332003	WJS 8/1/00
Overall Width of U	24.00"	WJS	↓	WJS ↓
Overall Depth of U	48.00"	WJS	↓	WJS ↓
Overall Length	519.25" +/- 0.25"			
Front and Back, Notch Size	21.75" x 0.75"			
Distance of first hole from edge	15.25"	WJS Same -OK	26' TAPE # 5332003	WJS 8/1/00
Vertical Spacing of Hole Centers	12.00"	WJS	↓	WJS ↓
Horizontal Spacing of Holes	24.00"	WJS	↓	WJS ↓
Horizontal Spacing of Holes about CL	12.00"	WJS	↓	WJS ↓
Number of Holes	84			
Dia of Hole	1.00"	WJS	26' TAPE # 5332003	WJS 8/1/00
Item 71 (2 reqd)				
Plate Thickness	0.75"	WJS Same -OK	26' TAPE # 5332003	WJS 8/1/00
Overall Width of U	24.00"	WJS	↓	WJS ↓
Overall Depth of U	48.00"	WJS	↓	WJS ↓
Overall Length	519.25" +/- 0.25"			WJS ↓

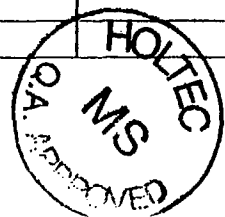
Page 2-39



**CASK TRANSFER I LITY FABRICATION
INSPECTION PLAN - 3115 Rev 0**

Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
Item 71 (continued)				
Front and Back, Notch Size	21.75" x 0.75"	Same - OK	26" TAPE 5332008	SKD 9/15/00
Distance of first hole from edge	15.25"	WS 8/1/00 SAME	26" TAPE 5332003	WS 8/1/00
Vertical Spacing of Hole Centers	12.00"	WS 8/1/00		WS 8/1/00
Horizontal Spacing of Holes	24.00"	WS 8/1/00		WS 8/1/00
Horizontal Spacing of Holes about CL	12.00"	WS 8/1/00		WS 8/1/00
Number of Holes	84			
Dia of Hole	1.00"	WS 8/1/00		WS 8/1/00
Item 72 (4 reqd)				
Dia of hole	10.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Distance from bottom edge	13.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Displacement of hole from the center line	6.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Orientation	2 pieces - holes on the right side	Same - OK	26" TAPE 5332008	SKD 8/7/00
	2 pieces - holes on the left side	Same - OK	26" TAPE 5332008	SKD 8/7/00
Overall Length	230.00" +/- 0.25"	Same - OK	26" TAPE 5332008	SKD 8/7/00
Item 73 (4 reqd)				
Dia of hole	10.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Distance from bottom edge	13.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Displacement of hole from the center line	6.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Overall Length	81.00" +/- 0.25"	Same - OK	26" TAPE 5332008	SKD 8/28/00
Item 74 (4 reqd)				
Length	96.00"	Same - OK	26" TAPE 5332008	SKD 8/28/00

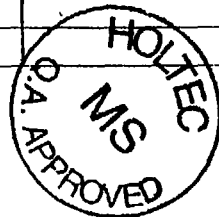
Page 2-40



**CASK TRANSFER I UTILITY FABRICATION
INSPECTION PLAN - 3115 Rev 0**

Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
Item 74 (continued)				
Width	72.00"	Same - OK	26' TAPR 5332008	5/1/00 SMD
Dia of Hole	10.00"	Same - OK	26' TAPR 5332008	5/28/00 SMD
Distance from Bottom Edge	13.00"	Same - OK	26' TAPR 5332008	5/28/00 SMD
Distance from either long Edge	36.00"	Same - OK	26' TAPR 5332008	5/28/00 SMD
Item 75 (2 reqd)				
Length	60.00"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Width	48.00"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Hole Dia	7.50"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Distance from Center Line	12.00"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Distance from edge	30.00"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Holes along Edges, dia	1.63"	Same - OK	26' TAPR 5332008	9/16/00 SMD
No. of holes per end	8	Same - OK	26' TAPR 5332008	9/16/00 SMD
Spacing between holes	6.00"	Same - OK	26' TAPR 5332008	9/16/00 SMD
Displacement of CL of holes from end	3.00"	Same - OK	26' TAPR 5332008	9/16/00 SMD
Rectangular Holes (2)	4.41" x 8.16"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Displacement from Edge	9.04"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Displacement from CL	5.05"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Radius at corners	0.13"	Same - OK	26' TAPR 5332008	9/7/00 SMD
Item 76 (4 reqd)				
Plate thickness	1.00"	Same - OK	26' TAPR 5332008	SMD 8/16/00
Overall Length	54.75"	Same - OK	26' TAPR 5332008	SMD 8/16/00
Shorter Length	46.75"	Same - OK	26' TAPR 5332008	SMD 8/16/00
Width	25.00"	Same - OK	26' TAPR 5332008	SMD 8/16/00
Corner Radius (2)	2.25"	Same - OK	26' TAPR 5332008	SMD 8/16/00
Corner Radius (2)	3.00"	Same - OK	26' TAPR 5332008	SMD 8/16/00
Dia of Hole	2.88"	Same - OK	26' TAPR 5332008	SMD 8/16/00

Page 2-41

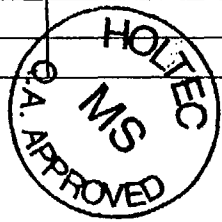


CASK TRANSFER I LITY FABRICATION
INSPECTION PLAN - 3115 Rev 0

0 0 0
0 0 0

Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
Item 76 (continued)				
Displacement of Hole from long edge	3.00"	Same - OK	26" TAPE 5332008	SAD 8/16/00
Displacement from short edge	51.75"	Same - OK	26" TAPE 5332008	SAD 8/16/00
Item 77 (4 reqd)				
Plate Thickness	0.75"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Overall Length	49.00"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Overall Width	25.00"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Corner Radius (2)	2.75"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Item 81 (2 reqd)				
Plate thickness	0.75"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Overall Length	46.50"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Overall Width	23.25"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Corner Radius(2)	1.375"	Same - OK	26" TAPE 5332008	8/29/00 SAD
No. of Holes	4	Same - OK	26" TAPE 5332008	8/29/00 SAD
Dia of Holes	0.56"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Spacing along length	16.00"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Displacement from CL along Length	3.00"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Spacing along Width	9.00"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Displacement from CL along width	4.50"	Same - OK	26" TAPE 5332008	8/29/00 SAD
Item 91 (2 reqd)				
OD	8.63" +/- 0.03"	8.429" / 8.63"	3 1/2" Caliper 975 7004	9/18/00 JLS
Bolt Circle Diameter	5.31" +/- 0.03"	5.253" / 5.320"	6" Caliper BCO 23946	9/18/00
No. of threaded Holes	6			9/18/00 JLS
Threads	1-8 UNC equally Spaced	Same - OK	Thread Gauge 712 005	9/18/00 JLS
Thickness	3.00" +/- 0.03"	3.06" / 3.15"	1" Caliper BCO 23946	9/18/00 JLS
Chamfer	0.63" x 45°	Same - OK	6" Steel Rule	9/18/00 JLS

Page 2-42

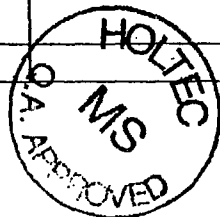


40

CASK TRANSFER I CITY FABRICATION
INSPECTION PLAN - 3115 Rev 0

Page 2-43

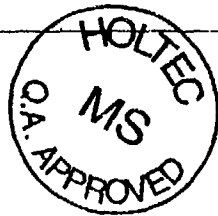
Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
Item 92 (2 reqd)				
Thickness	0.75" Nylon	Same - OK	26" TAPE 5332008	SAD 8/10/00
Length	40.00"	Same - OK	26" TAPE 5332008	SAD 8/10/00
Width	16.00"	Same - OK	26" TAPE 5332008	SAD 8/10/00
Hole Size	8.75"	Same - OK	26" TAPE 5332008	SAD 9/18/00
Displacement from Edges	8" x 20"	Same - OK	26" TAPE 5332008	7/18/00 SAD
Item 93 (2 reqd)				
Thickness	1.00"	Same - OK	26" TAPE 5332008	SAD 9/18/00
OD	9.5"	Same - OK	26" TAPE 5332008	SAD 9/18/00
Bolt Circle Dia	5.31"	Same - OK	6" Calliper 80023946	SAD 9/18/00
Dia of Holes	1.13"	Same - OK	6" Calliper 80023946	SAD 9/18/00
Spacing of Holes	Equally Spaced	Same - OK	26" TAPE 5332008	SAD 9/18/00
Item 97 (2 reqd)				
Angle Size	8" x 6" x 3/4"	Same - OK	26" TAPE 5332008	SAD 9/15/00
Length	48.00"	Same - OK	26" TAPE 5332008	SAD 9/15/00
Hole CL, from edges	3.00" x 6.00"	Same - OK	26" TAPE 5332008	SAD 9/15/00
No. of Holes	8	OK	—	SAD 9/15/00
Dia of Holes	1.63"	Same - OK	6" Calliper 80023946	SAD 9/15/00
Spacing of Holes	Equally Spaced	Same - OK	26" TAPE 5332008	SAD 9/15/00
Distance of end holes from edges	3.00"	Same - OK	26" TAPE 5332008	SAD 9/15/00
Item 120 (2 reqd)				
Thickness	0.75"	Same - OK	26" TAPE 5333008	SAD 8/11/00
Length	15.00"	↓	↓	↓
Width	18.00"	↓	↓	↓
No. Slotted Holes	4	OK	—	SAD 9/14/00
Size of slotted holes	0.56" x 3.00"	Same - OK	6" Calliper 80023946	SAD 9/14/00
Displacement of Slotted Holes from CL	8.00" x 4.50"	Same - OK	26" TAPE 5332008	SAD 9/14/00
No. of Tapped Holes	4	OK	—	SAD 9/14/00



**CASK TRANSFER FACILITY FABRICATION
INSPECTION PLAN - 3115 Rev 0**

Page 2-44

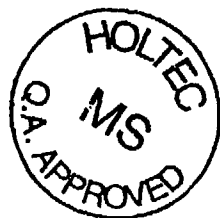
Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
Item 120 (continued)				
Thread size	1/2 - 13 UNC	OK	TCS 002	SND 9/10/00
Displacement of Threaded Holes from CL	3.00" x 5.00"	Same - OK	26" TAPE 5332005 ALU TAPE	SND 9/10/00
Item 121 (2 reqd)				
Thickness	0.50"	Same - OK	26" TAPE 5332005	SND 9/18/00
Length	12.00"	Same - OK	26" TAPE 5332005	SND 9/18/00
Width	11.00"	Same - OK	26" TAPE 5332005	SND 9/18/00
No. Slotted Holes	4	OK	—	SND 9/18/00
Size of slotted holes	0.56" x 3.00"	OK	6" caliper 12023846	SND 9/18/00
Displacement of Slotted Holes from CL	5.00" x 3.00"	OK	26" TAPE 5332005	SND 9/18/00
Item 173 (2 reqd)				
Dia of Pipe	10.00"	OK	26" TAPE 5332005	SND 9/10/00
Schedule of pipe	120	OK	6" caliper 12023846	SND 9/10/00
No of tapped holes	3	OK	—	SND 9/10/00
Thread size	3/8 - 16 UNC	NIFS	—	—
Fit-up Inspection				
SECTION J				
Flanges of Items 70 and 71	Level	OK	shop level	SND 9/10/00
Item 79 to Item 70, from CL of Tower	6.75"	Same - OK	26" TAPE 5332005	SND 9/10/00
Orientation of Item 79	Parallel to CL of Tower	OK	Square & 26" TAPE 5332005	SND 9/19/00
SECTION F				
Distance between the two Item 78s	6.13" +/- 0.03"	OK	24" caliper 3757005	SND 9/18/00
Distance of CL of Slide Angle Guides from CL of Tower	12.00" +/- 0.06"	OK	24" caliper 3757005	SND 9/18/00



**CASK TRANSFER FACILITY FABRICATION
INSPECTION PLAN - 3115 Rev 0**

Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
SECTION E				
Overall Depth of tower	96.00"	96.25 (see pic)	26" TAP 5332008	SN 9/19/00
Overall Width of Tower	48.00"	48.50 (see pic)	26" TAP 5332008	SN 9/19/00
Distance of Item 74 from edges	12.00"	OK	26" TAP 5332008	SN 9/19/00
Weld Inspection				
SECTION H				
Item 70 to Item 71	1" Plug Weld	OK	N/A	SN 9/13/00
No. of Plug welds	84	OK	-	SN 9/13/00
Item 70 to Item 71 (two sides)	1/8" flair, 4 - 12	OK	Fillet gauge	SN 9/19/00
Step welding, Item 79 to item 70	1/8" fillet, 2 - 6	OK	Fillet gauge	SN 9/19/00
Item 77 (2) to Item 70 and 71	1/4" fillet both sides	OK	Fillet gauge	SN 9/19/00
SECTION G				
Item 76 (2) to Items 70/71	1/4" fillet both sides	OK	Fillet gauge	SN 9/12/00
SECTION F				
Item 73 (2) to Items 70/71	5/16" fillet, 8 - 12, inside	OK	Fillet gauge	SN 9/12/00
Item 81 to Item 70 (Top side only)	1/4" fillet	OK	Fillet gauge	SN 9/12/00
Item 72 (2) to 70/71	5/16" fillet, 8 - 12, inside	OK	Fillet gauge	SN 9/20/00
Step welding, Item 78 (4) to item 71	1/4" fillet, 4 - 10	OK	Fillet gauge	SN 9/20/00
SECTION E				
Item 74 to Item 70	3/16" fillet, 8 - 12, inside	OK	Fillet gauge	SN 9/20/00
Item 74 to Item 71	3/16" fillet, 8 - 12, inside	OK	Fillet gauge	SN 9/20/00
Item 74 to Item 72	5/16" fillet, 8 - 12	OK	Fillet gauge	SN 9/20/00

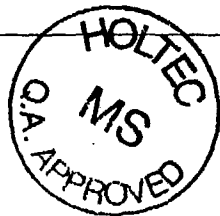
Page 2-45



CASK TRANSFER I TOWER FABRICATION
INSPECTION PLAN - 3115 Rev 0

Item No	Dimensional Requirement	Measured Dimension	Equipment Used	Inspector/Date
ELEVATION M				
All U Section Seam Welds	45° min bevel, 3/4" full pen butt ground flush	OK	—	SND 9/20/00
DETAIL 1				
Item 121 to Item 126	Tack weld as required	N/A	—	SND 9/20/00
DETAIL 2				
Item 91 to Item 75	Bevel Item 91, full pen ground flush	OK	—	SND 9/20/00
Item 178 to Item 75	Tack in 4 places	OK	—	SND 9/20/00
Item 97 (2) to items 70/71	1/2" fillet both sides	OK	Pilot gauge	SND 9/20/00
Final Inspection				
SECTION J				
Flanges of Items 70 and 71	Level	OK	Level	SND 9/20/00
Item 79 to Item 70, from CL of Tower	6.75"	OK	26" TAPE 5332008	SND 9/20/00
Orientation of Item 79	Parallel to CL of Tower	OK	58mm - 26" TAPE 5332008	SND 9/20/00
SECTION F				
Distance between the two Item 78s	6.13" +/- 0.03"	OK	24" caliper 3757005	SND 9/20/00
Distance of CL of Slide Angle Guides from CL of Tower	12.00" +/- 0.06"	OK	24" caliper 3757005	SND 9/20/00
SECTION E				
Overall Depth of tower	96.00"	96.25 (see 60)	26" TAPE 5332008	SND 9/20/00
Overall Width of Tower	48.00"	48.50 (see 60)	26" TAPE 5332008	SND 9/20/00
Distance of Item 74 from edges	12.00"	OK	26" TAPE 5332008	SND 9/20/00

Page 2-46



44

