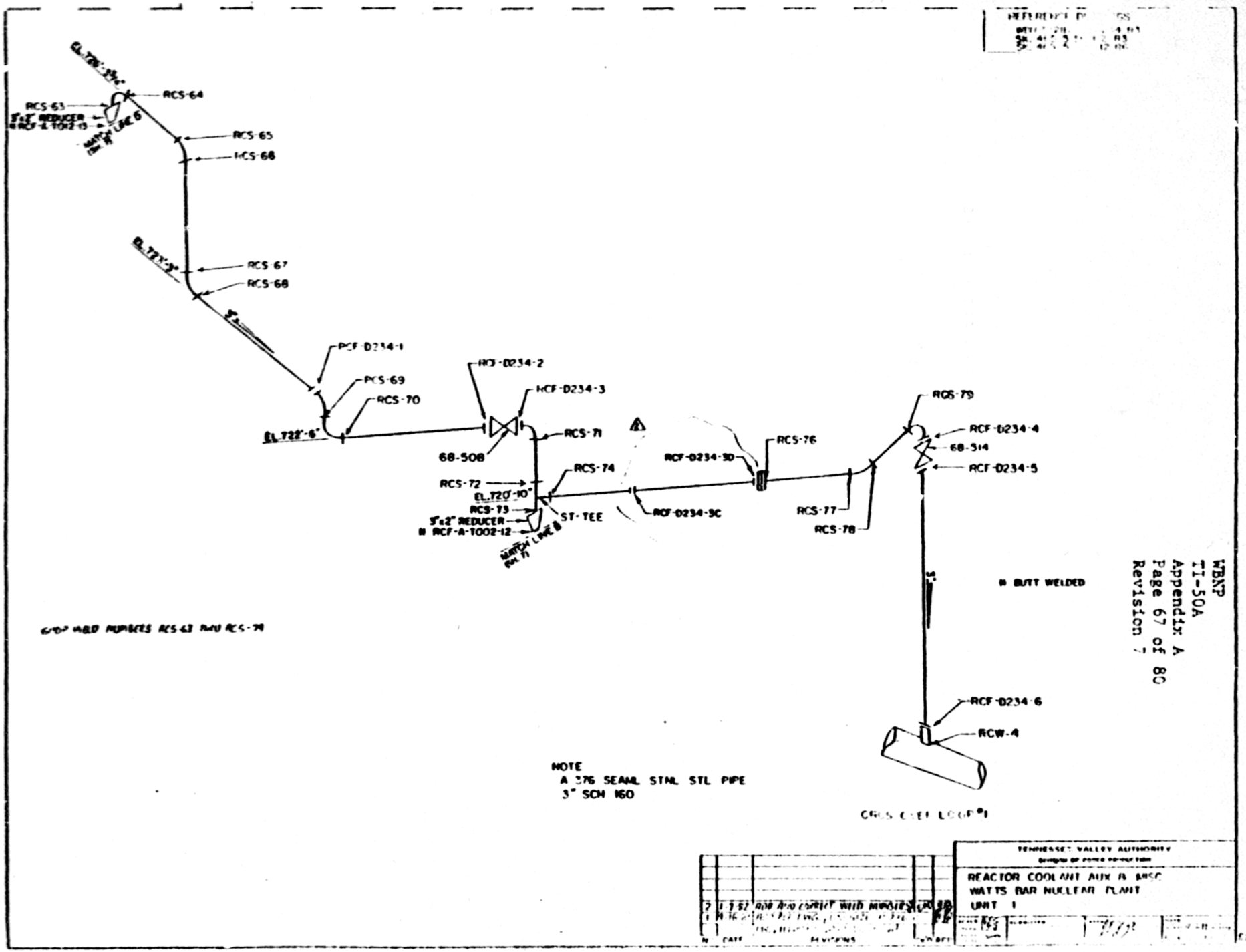
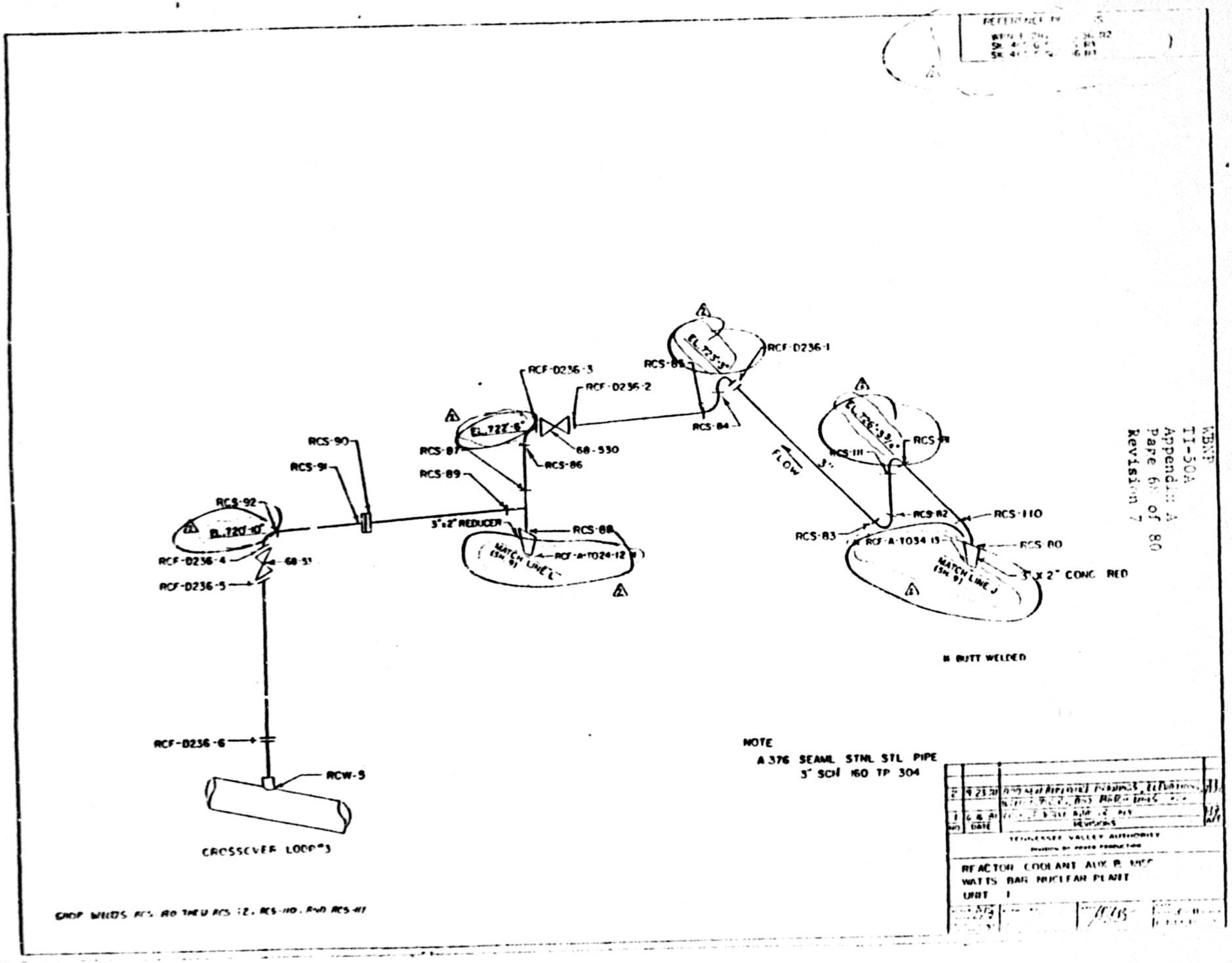
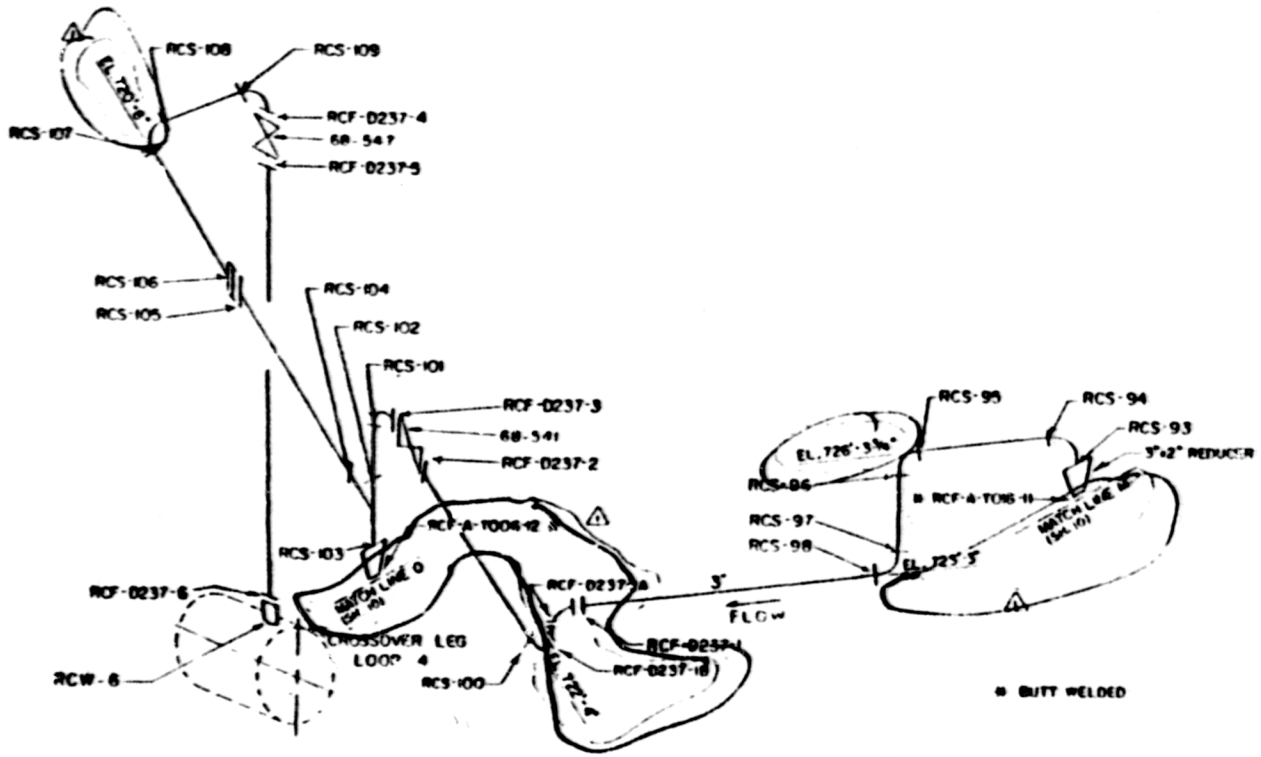


WBNP
TI-50A
Appendix A
Page 67 of 80
Revision 7


RCF-D236-1
RCS-85
RCS-84
RCF-D236-3
RCF-D236-2
EL. 722'-6"
68-530
RCS-86
RCS-87
RCS-89
RCS-90
RCS-91
RCS-92
EL. 720'-10"
RCF-D236-4
68-53
RCF-D236-5
3"x2" REDUCER
RCS-88
MATCH LINE L (SH. 9)
RCF-A-T024-12
FLOW
3"
RCS-111
RCS-82
RCS-110
RCS-83
RCF-A-T034-13
RCS-80
MATCH LINE J (SH. 9)
3" X 2" CONC RED
BUTT WELDED
RCF-D236-6
RCW-5
CROSSOVER LOOP #3
NOTE
A 376 SEAML STNL STL PIPE
3" SCH 160 TP 304
TENNESSEE VALLEY AUTHORITY
REACTOR COOLANT AUX B MISC
WATTS BAR NUCLEAR PLANT
UNIT 1



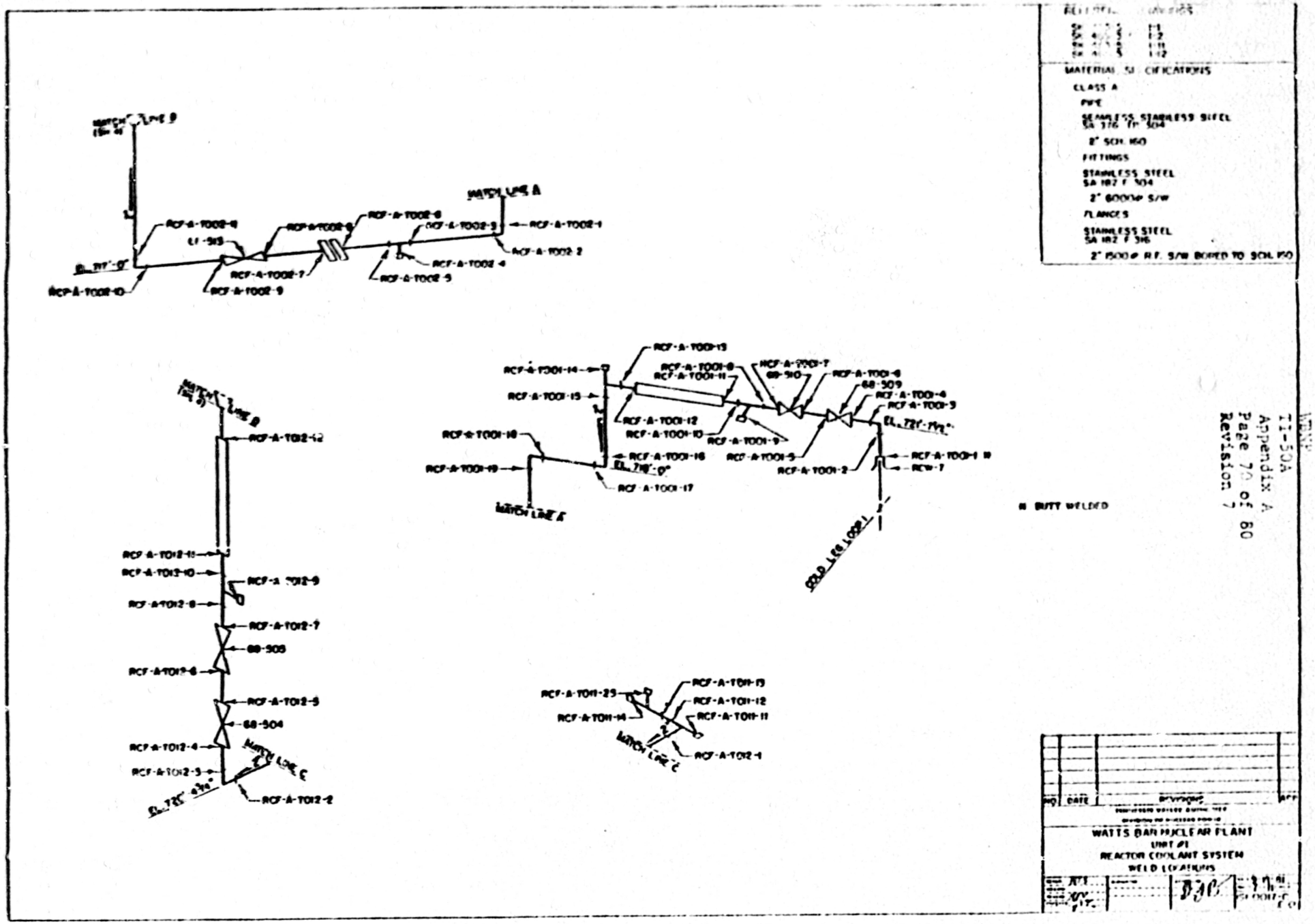
NOTE
A 376 SEAML STNL STL PIPE
3" SCH 160 TP 304

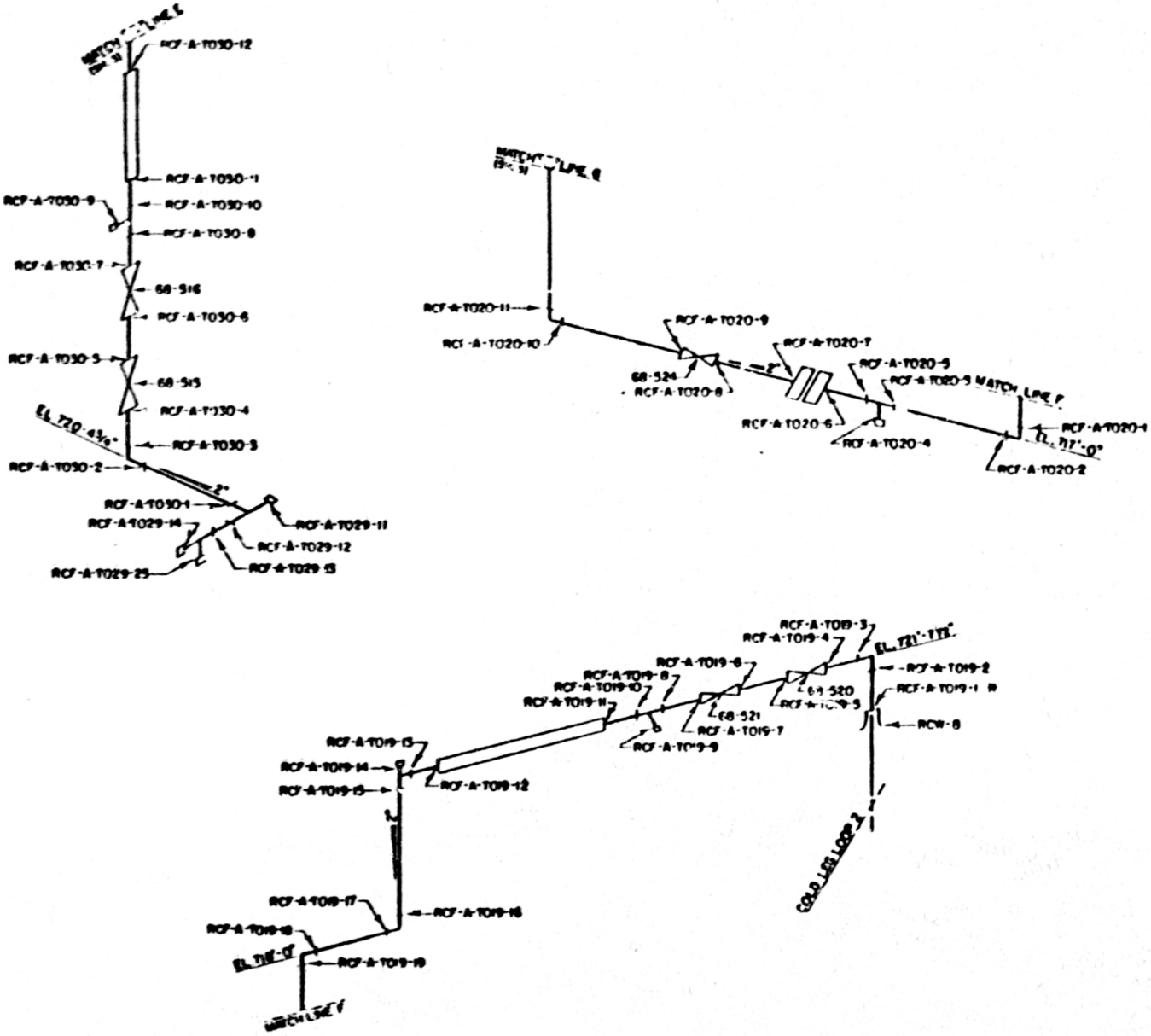
SHOP WELDS RCS-93 THRU RCS-98, RCS-100 THRU RCS-109

NO.	DATE	REVISIONS	BY
1	9 29 [illegible]	[illegible]	[illegible]

TENNESSEE VALLEY AUTHORITY
DIVISION OF POWER PRODUCTION

REACTOR COOLANT AUX & MSC
WATTS BAR NUCLEAR PLANT
UNIT 1


MATERIAL SPECIFICATIONS
CLASS A
PIPE
SEAMLESS STAINLESS STEEL
SA 376 TP 304
2" SCH. 160
FITTINGS
STAINLESS STEEL
SA 182 F 304
2" 6000# S/W
FLANGES
STAINLESS STEEL
SA 182 F 316
2" 1500# R.F. S/W BORED TO SCH. 160
MATCH LINE A
MATCH LINE B
MATCH LINE C
RCF-A-T002-1
RCF-A-T002-2
RCF-A-T002-3
RCF-A-T002-4
RCF-A-T002-5
RCF-A-T002-6
RCF-A-T002-7
RCF-A-T002-8
RCF-A-T002-9
RCF-A-T002-10
RCF-A-T002-11
RCF-A-T002-12
RCF-A-T002-2
RCF-A-T002-3
RCF-A-T002-4
RCF-A-T002-5
RCF-A-T002-6
RCF-A-T002-7
RCF-A-T002-8
RCF-A-T002-9
RCF-A-T002-10
RCF-A-T002-11
RCF-A-T002-12
RCF-A-T001-1
RCF-A-T001-2
RCF-A-T001-3
RCF-A-T001-4
RCF-A-T001-5
RCF-A-T001-6
RCF-A-T001-7
RCF-A-T001-8
RCF-A-T001-9
RCF-A-T001-10
RCF-A-T001-11
RCF-A-T001-12
RCF-A-T001-13
RCF-A-T001-14
RCF-A-T001-15
RCF-A-T001-16
RCF-A-T001-17
RCF-A-T001-18
RCF-A-T001-19
RCW-7
68-509
68-510
68-504
68-505
RCF-A-T011-11
RCF-A-T011-12
RCF-A-T011-13
RCF-A-T011-14
RCF-A-T011-25
RCF-A-T012-1
RCF-A-T012-2
RCF-A-T012-3
RCF-A-T012-4
RCF-A-T012-5
RCF-A-T012-6
RCF-A-T012-7
RCF-A-T012-8
RCF-A-T012-9
RCF-A-T012-10
RCF-A-T012-11
RCF-A-T012-12
COLD LEG LOOP 1
N BUTT WELDED
NO
DATE
REVISIONS
WATTS BAR NUCLEAR PLANT
UNIT #1
REACTOR COOLANT SYSTEM
WELD LOCATIONS



N BUTT WELDED

MATERIAL [illegible] FEATURES

CLASS A

PIPE

SEAMLESS STAINLESS STEEL
SA 376 TP 304

2" SCH 160

FITTINGS

STAINLESS STEEL
SA 182 F 304

2" 6000# S/W

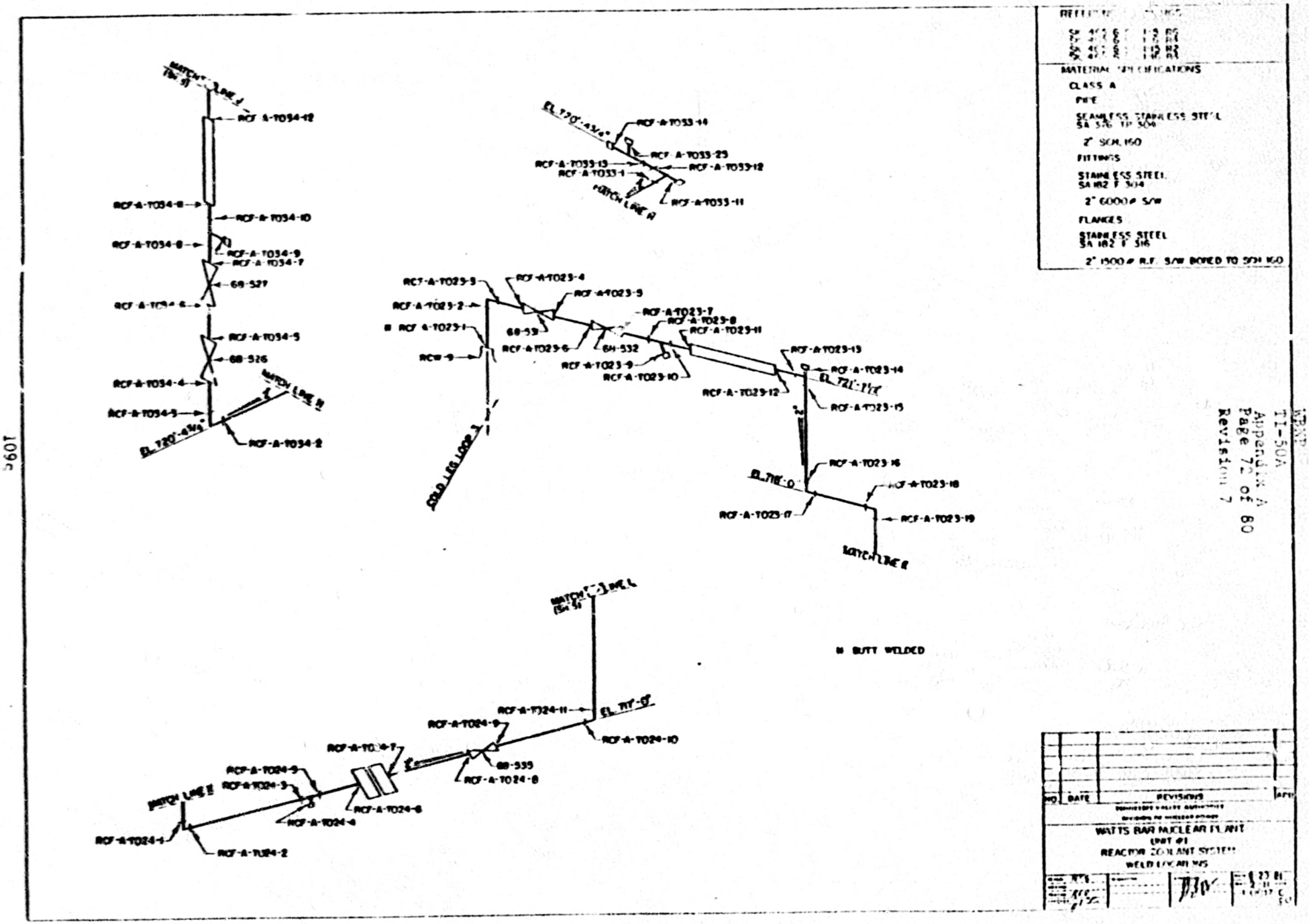
FLANGES

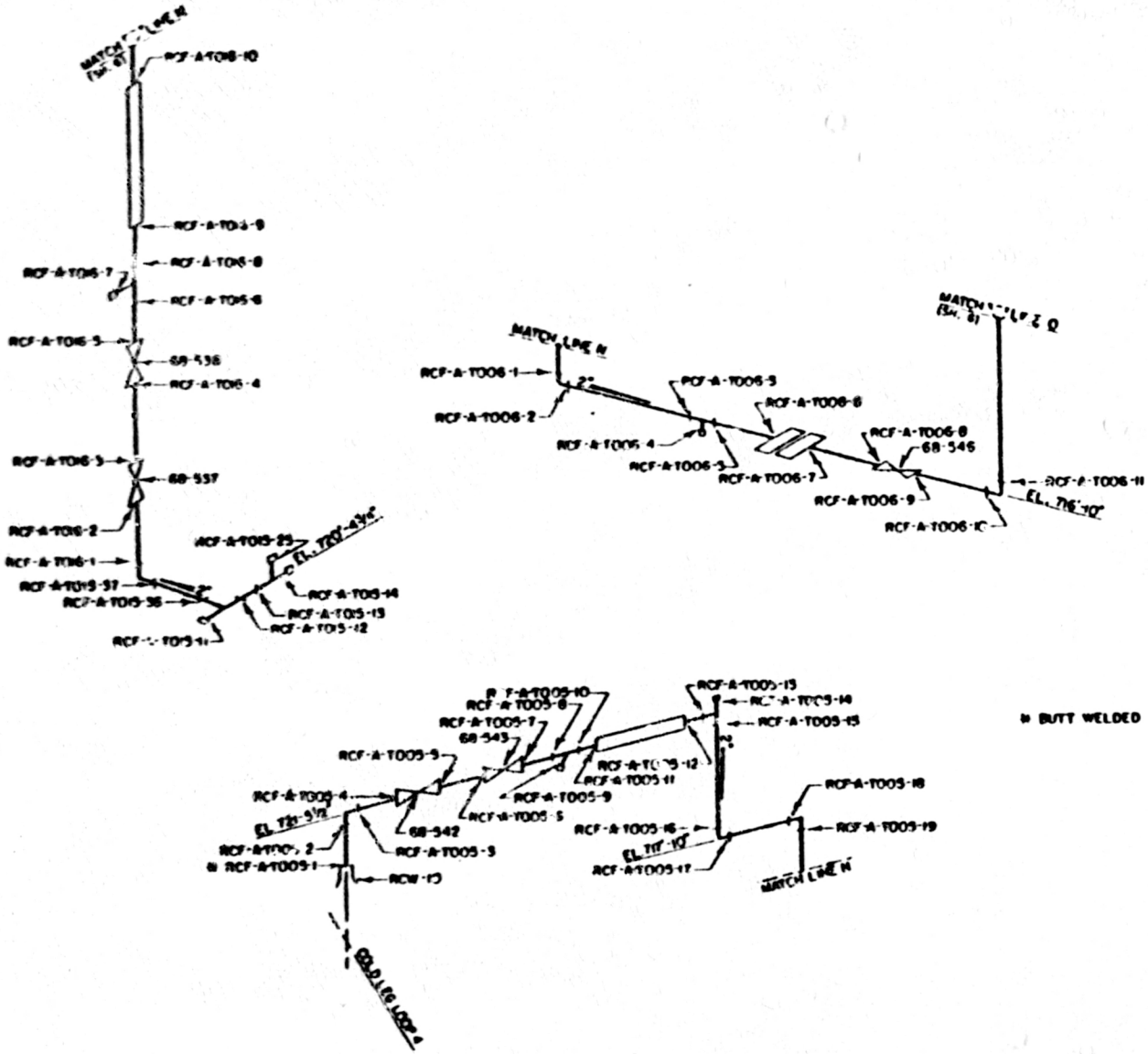
STAINLESS STEEL
SA 182 F 316

2" 1500# R.F. S/W BORED TO SCH 160

NO.	DATE	REVISIONS	APP.

WATTS BAR NUCLEAR PLANT
UNIT #1
REACTOR COOLANT SYSTEM
WELD LOCATIONS


MATERIAL SPECIFICATIONS
CLASS A
PIPE
SEAMLESS STAINLESS STEEL
SA 376 TP 304
2" SCH 160
FITTINGS
STAINLESS STEEL
SA 182 F 304
2" 6000# S/W
FLANGES
STAINLESS STEEL
SA 182 F 316
2" 1500# R.F. S/W BORED TO SCH 160
RCF-A-T034-12
RCF-A-T034-11
RCF-A-T034-10
RCF-A-T034-9
RCF-A-T034-8
RCF-A-T034-7
68-527
RCF-A-T034-6
RCF-A-T034-5
68-526
RCF-A-T034-4
RCF-A-T034-3
RCF-A-T034-2
MATCH LINE H
EL 720'-4 3/4"
RCF-A-T033-14
RCF-A-T033-25
RCF-A-T033-13
RCF-A-T033-12
RCF-A-T033-1
RCF-A-T033-11
RCF-A-T023-3
RCF-A-T023-4
RCF-A-T023-5
RCF-A-T023-2
RCF-A-T023-1
RCW-9
68-531
RCF-A-T023-6
68-532
RCF-A-T023-7
RCF-A-T023-8
RCF-A-T023-11
RCF-A-T023-9
RCF-A-T023-10
RCF-A-T023-12
RCF-A-T023-13
RCF-A-T023-14
RCF-A-T023-15
RCF-A-T023-16
RCF-A-T023-18
RCF-A-T023-17
RCF-A-T023-19
COLD LEG LOOP 3
MATCH LINE R
MATCH LINE L
EL 717'-0"
RCF-A-T024-11
RCF-A-T024-10
RCF-A-T024-9
RCF-A-T024-7
68-535
RCF-A-T024-8
RCF-A-T024-5
RCF-A-T024-3
RCF-A-T024-6
RCF-A-T024-4
RCF-A-T024-1
RCF-A-T024-2
BUTT WELDED
NO
DATE
REVISIONS
WATTS BAR NUCLEAR PLANT
UNIT #1
REACTOR COOLANT SYSTEM
WELD LOCATIONS



MATERIAL SPECIFICATIONS

CLASS A

PIPE

SEAMLESS STAINLESS STEEL
SA 376 TP 304

2" SCH 160

FITTINGS

STAINLESS STEEL
SA 182 F 304

2" 6000# S/W

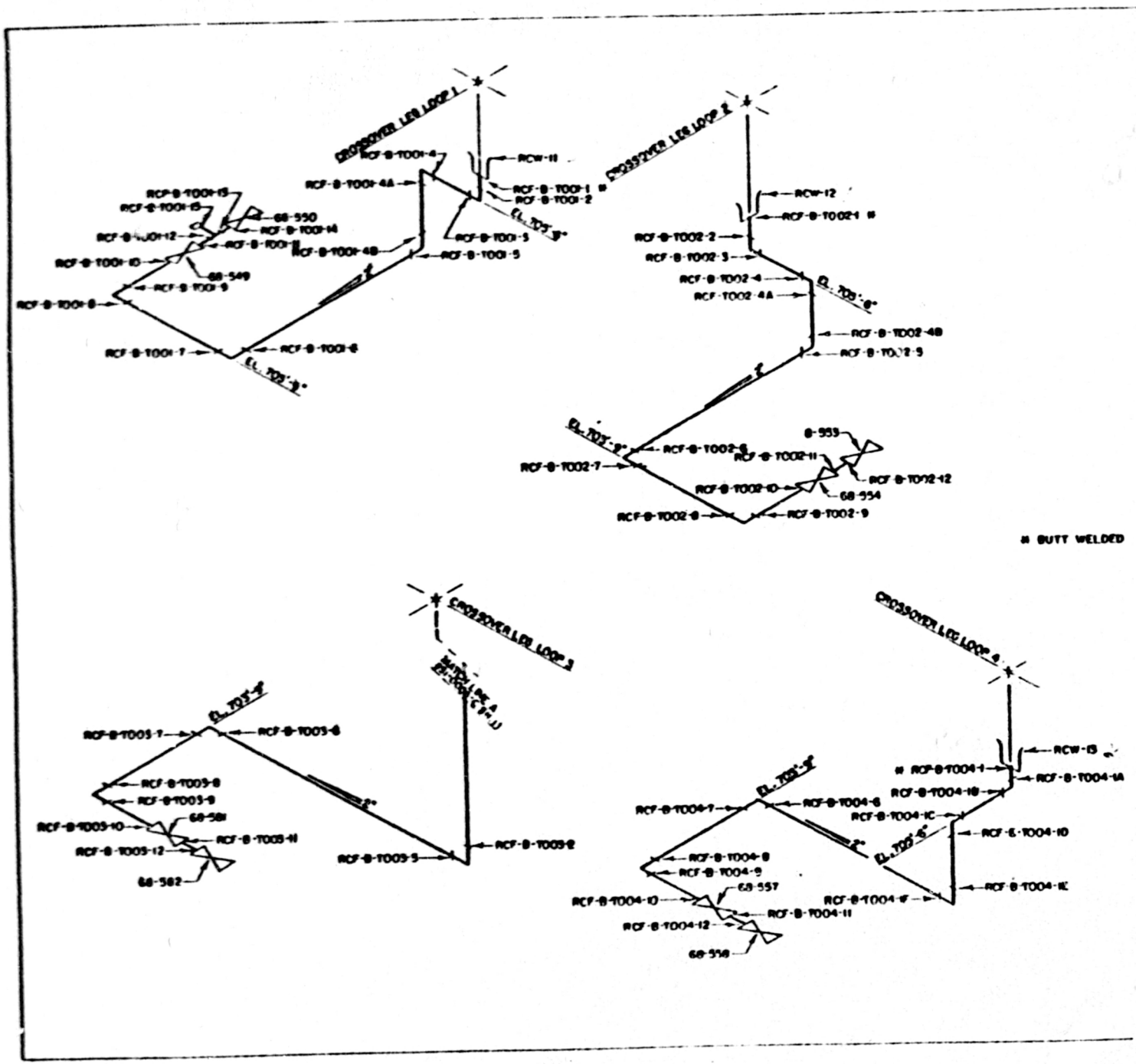
FLANGES

STAINLESS STEEL
SA 182 F 316

2" 1500# R.F. S/W BORED TO SCH 160

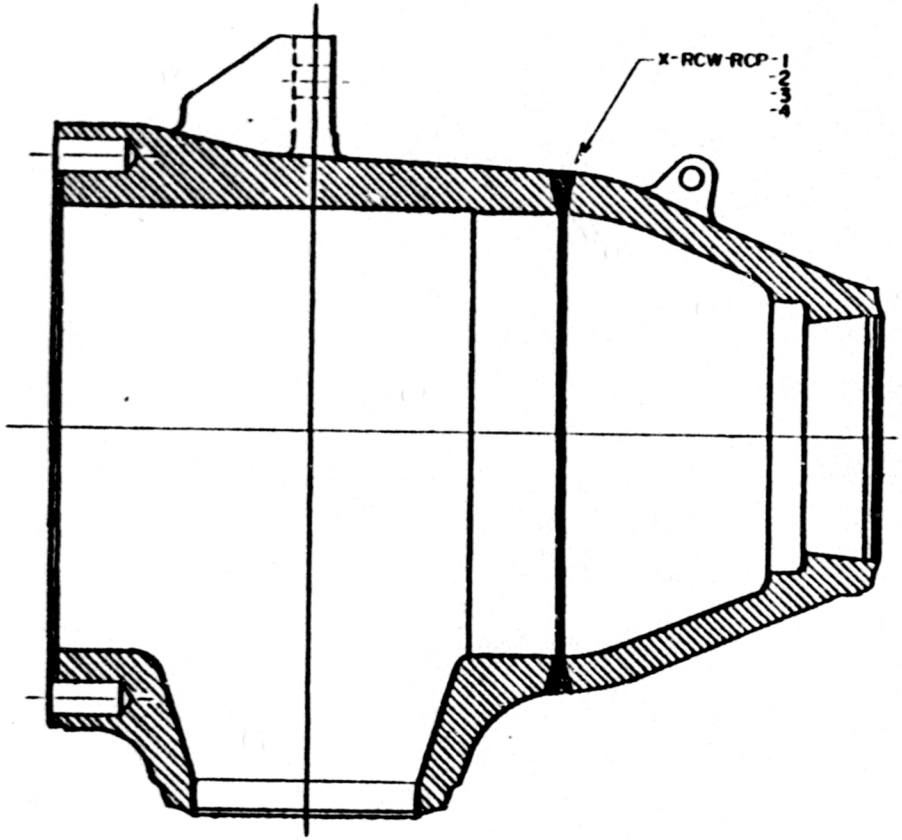
NO	DATE	REVISIONS	APP

WATTS BAR NUCLEAR PLANT
UNIT #1
REACTOR COOLANT SYSTEM
WELD LOCATIONS


CROSSOVER LEG LOOP 1
CROSSOVER LEG LOOP 2
CROSSOVER LEG LOOP 3
CROSSOVER LEG LOOP 4
RCW-11
RCW-12
RCW-13
RCW-15
RCF-B-T001-1 #
RCF-B-T001-2
RCF-B-T001-3
RCF-B-T001-4
RCF-B-T001-4A
RCF-B-T001-4B
RCF-B-T001-5
RCF-B-T001-6
RCF-B-T001-7
RCF-B-T001-8
RCF-B-T001-9
RCF-B-T001-10
RCF-B-T001-11
RCF-B-T001-12
RCF-B-T001-14
RCF-B-T001-15
68-549
68-550
RCF-B-T002-1 #
RCF-B-T002-2
RCF-B-T002-3
RCF-B-T002-4
RCF-B-T002-4A
RCF-B-T002-4B
RCF-B-T002-5
RCF-B-T002-6
RCF-B-T002-7
RCF-B-T002-8
RCF-B-T002-9
RCF-B-T002-10
RCF-B-T002-11
RCF-B-T002-12
68-554
B-553
RCF-B-T003-1
RCF-B-T003-2
RCF-B-T003-5
RCF-B-T003-6
RCF-B-T003-7
RCF-B-T003-8
RCF-B-T003-9
RCF-B-T003-10
RCF-B-T003-11
RCF-B-T003-12
68-581
68-582
RCF-B-T004-1 #
RCF-B-T004-1A
RCF-B-T004-1B
RCF-B-T004-1C
RCF-B-T004-1D
RCF-B-T004-1E
RCF-B-T004-1F
RCF-B-T004-6
RCF-B-T004-7
RCF-B-T004-8
RCF-B-T004-9
RCF-B-T004-10
RCF-B-T004-11
RCF-B-T004-12
68-557
68-558
EL. 705'-9"
2"
BUTT WELDED
MATERIAL SPECIFICATIONS
CLASS A
PIPE
SEAMLESS STAINLESS STEEL
SA 376 TP 304
2" SCH. 160
FITTINGS
STAINLESS STEEL
SA 182 F 304
2" 6000# S/W
REVISIONS
WATTS BAR NUCLEAR PLANT
UNIT #1
REACTOR COOLANT SYSTEM
WELD LOCATIONS

NOTES

1. REPLACE THE X IN THE WELD NUMBER WITH THE APPROPRIATE UNIT NUMBER.

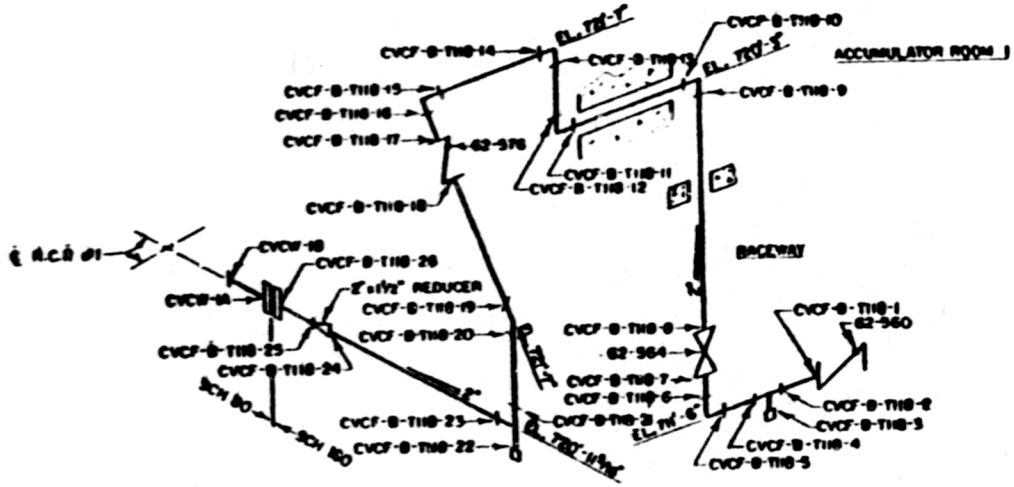


TENNESSEE VALLEY AUTHORITY
DIVISION OF NUCLEAR POWER

WATTS BAR NUCLEAR PLANT
UNITS #1 & #2
REACTOR COOLANT PUMP CASING
WELD LOCATIONS

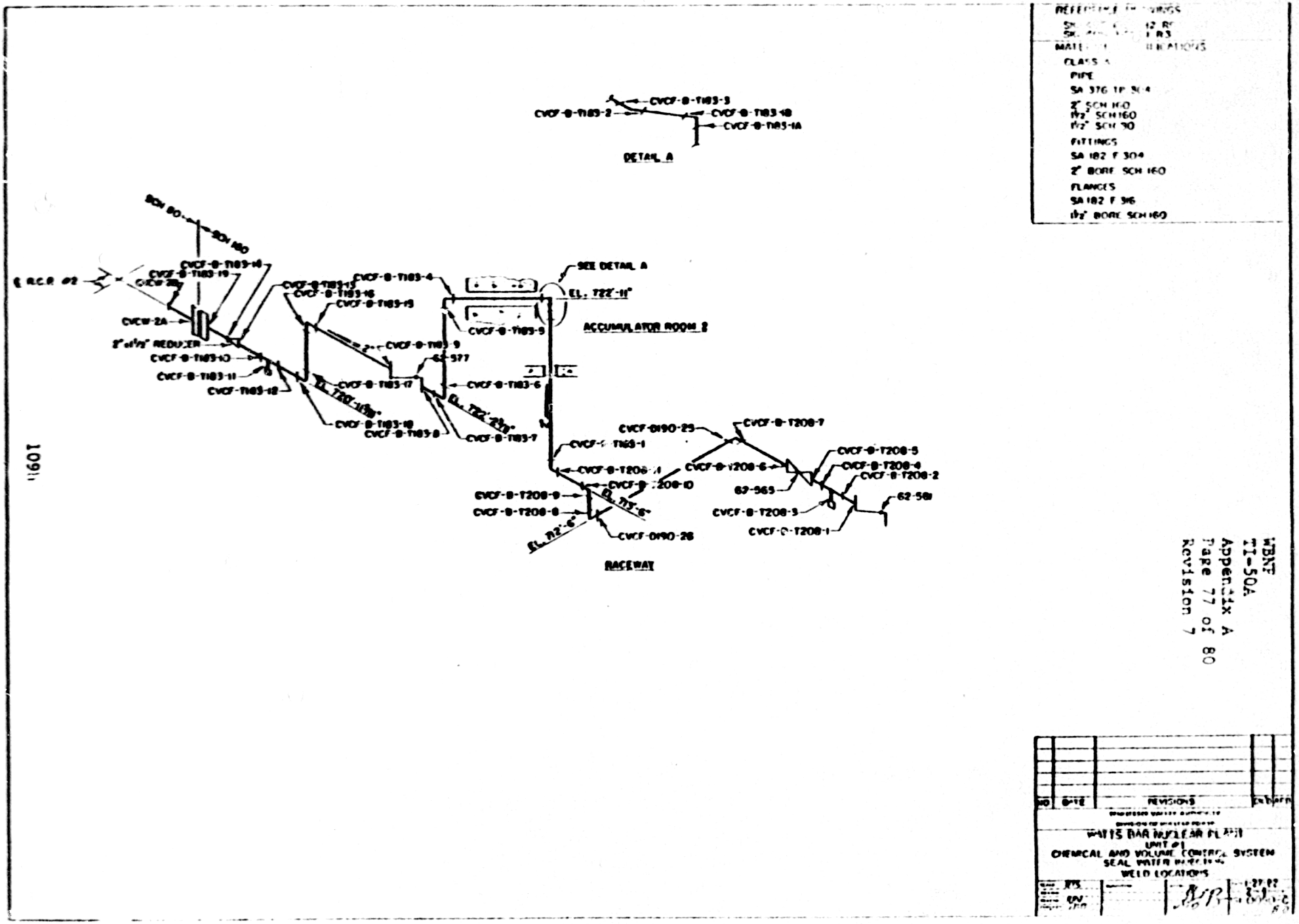
SCALE NTS | DRAWN | APPROVED | DATE 1/8/82 | SHEET 1 OF 1 | 0048-A | R0

REFERENCE [illegible]
[illegible]
MATERIAL [illegible]
CLASS A
PIPE
SA 376 TP 30
2" SCH 160
1½" SCH 160
1½" SCH 80
FITTINGS
SA 182 F 304
2" BORE SCH 160
FLANGES
SA 182 F 316
1½" BORE SCH 160



NO.	DATE	REVISIONS	[illegible]

WATTS BAR NUCLEAR PLANT
UNIT #1
CHEMICAL AND VOLUME CONTROL SYSTEM
SEAL WATER INJECTION
(FIELD LOCATIONS)


REFERENCE DRAWINGS
MATERIAL
CLASS A
PIPE
SA 376 TP 304
2" SCH 160
1½" SCH 160
1½" SCH 80
FITTINGS
SA 182 F 304
2" BORE SCH 160
FLANGES
SA 182 F 316
1½" BORE SCH 160
DETAIL A
CVCF-0-T183-3
CVCF-0-T183-2
CVCF-0-T183-1B
CVCF-0-T183-1A
SCH 80
SCH 160
CVCF-0-T183-14
CVCF-0-T183-19
CVCF-2A
2" x 1½" REDUCER
CVCF-0-T183-10
CVCF-0-T183-11
CVCF-T183-12
CVCF-0-T183-13
CVCF-0-T183-16
CVCF-0-T183-15
CVCF-0-T183-4
CVCF-0-T183-9
62-577
CVCF-0-T183-17
CVCF-0-T183-18
CVCF-0-T183-8
CVCF-0-T183-6
CVCF-0-T183-7
SEE DETAIL A
EL. 722'-11"
ACCUMULATOR ROOM 2
CVCF-0-T183-5
CVCF-0190-25
CVCF-0-T208-7
CVCF-0-T208-5
CVCF-0-T208-6
CVCF-0-T208-4
CVCF-0-T208-2
62-565
62-561
CVCF-0-T208-3
CVCF-0-T208-1
CVCF-0-T208-9
CVCF-0-T208-8
CVCF-0190-26
RACEWAY
NO. DATE REVISIONS
WATTS BAR NUCLEAR PLANT
UNIT #1
CHEMICAL AND VOLUME CONTROL SYSTEM
SEAL WATER INJECTION
WELD LOCATIONS

MATERIAL SPECIFICATIONS

CLASS A

PIPE

SA 376 TP 304

2" SCH 160

1½" SCH 160

1½" SCH 80

FITTINGS

SA 182 F 304

2" BORE SCH 160

FLANGES

SA 182 F 316

1½" BORE SCH 160

NO.	DATE	REVISIONS	BY	CHK

TENNESSEE VALLEY AUTHORITY

DIVISION OF NUCLEAR POWER

WATTS BAR NUCLEAR PLANT

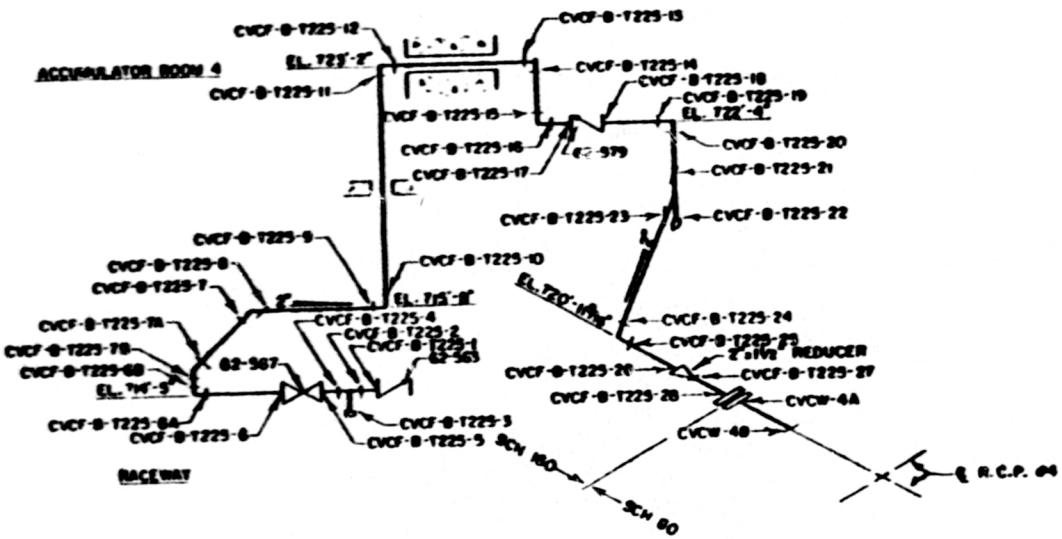
UNIT #1

CHEMICAL AND VOLUME CONTROL SYSTEM

SEAL WATER INJECTION

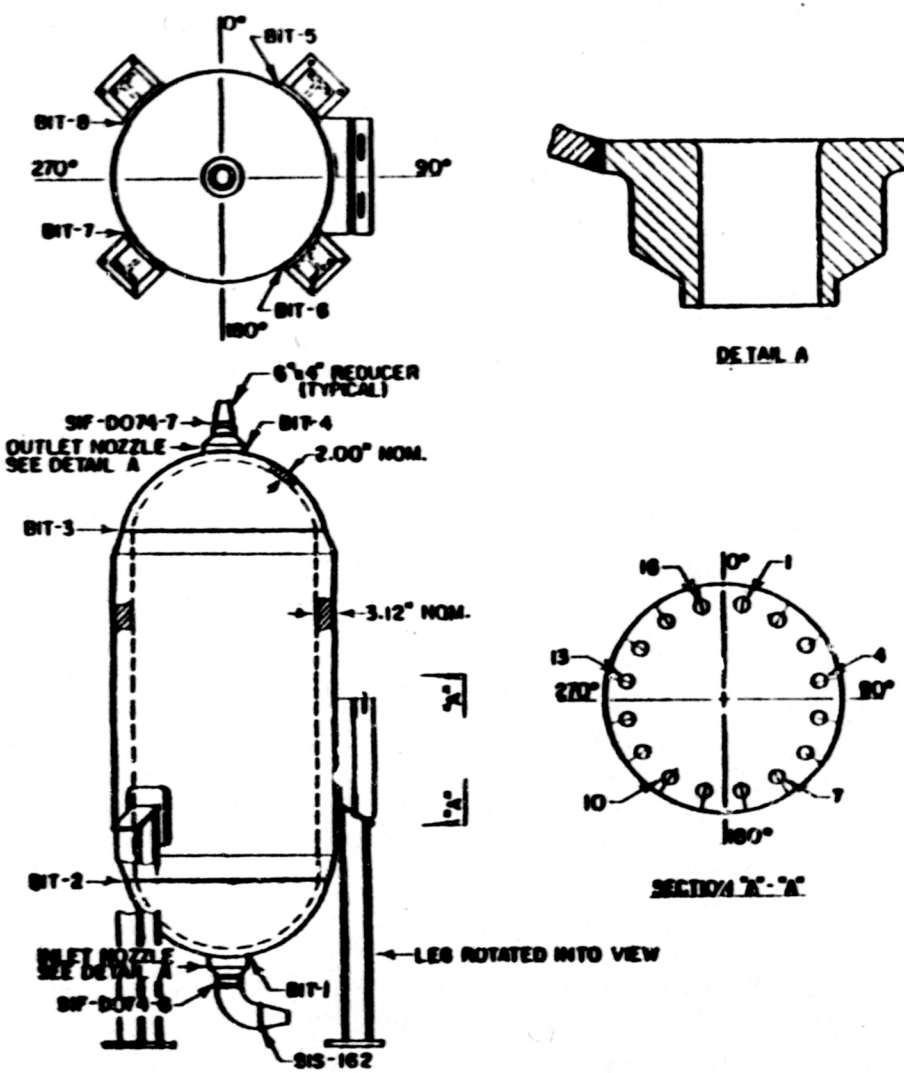
WELD LOCATIONS

REFERENCE DRAWINGS
SK 40[illegible]
MATERIAL SPECIFICATIONS
CLASS A
PIPE
SA 376 TP 304
2" SCH 160
1½" SCH 160
1½" SCH 80
FITTINGS
SA 182 F 304
2" BORE SCH 160
FLANGES
1½" BORE SCH 160



NO.	DATE	REVISIONS	BY	CHK

WATTS BAR NUCLEAR PLANT
UNIT #1
CHEMICAL AND VOLUME CONTROL SYSTEM
SEAL WATER INJECTION
WELD LOCATIONS



REFERENCE DRAWINGS
WESTINGHOUSE 1100E48
WBN E-2873 IC 74

MATERIAL SPECIFICATIONS
CLASS B
TANK
SHELL
SA-351 CF8A
3.12" NOM.
HEADS
SA 240 TP 304
2.00 NOM.
NOZZLES
SA 182 [illegible] 304
BOLTING
STUDS
SA 193 GR. B7
2.50-8UN-2A x 13.50
NUTS
SA 193 GR. 2H
2.50-8UN-2B HVY.
FITTINGS
SA 403 WP 304
6" SCH 160

NO.	DATE	REVISIONS	CK'D	APP'D

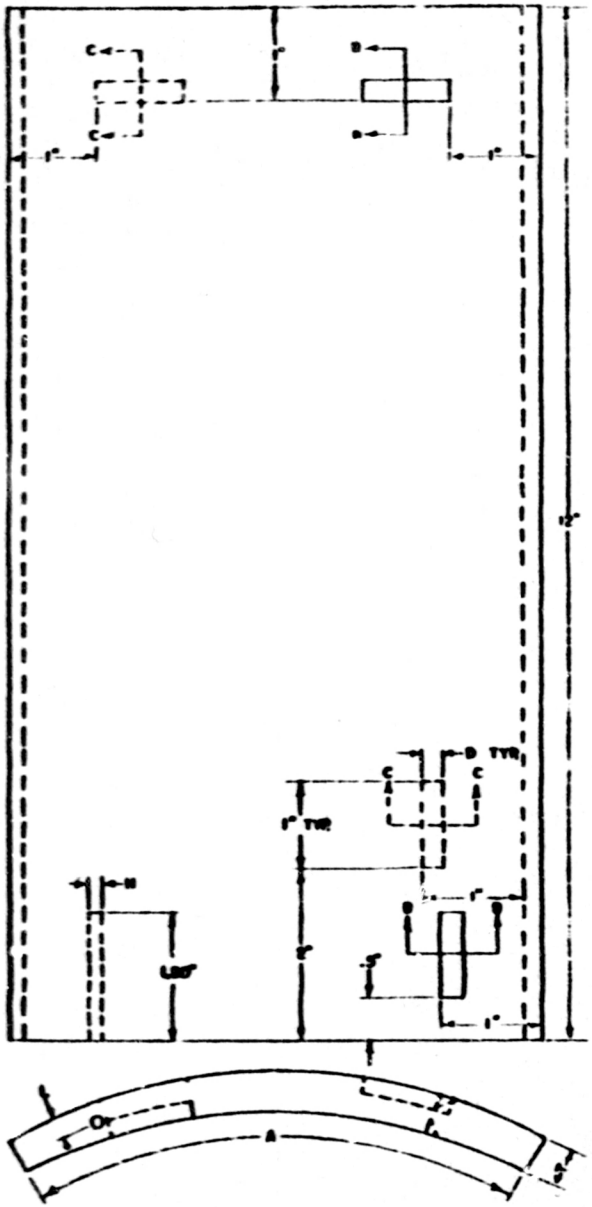
TENNESSEE VALLEY AUTHORITY
DIVISION OF NUCLEAR POWER

WATTS BAR NUCLEAR PLANT
UNIT [illegible]
BORON INJECTION TANK
WELD LOCATIONS

SCALE NTS
DATE 2-19-82
SI-0053-B

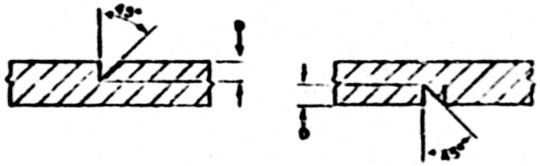
TABLE A
LIST OF CALIBRATION BLOCK DRAWINGS

BLOCK NO.	DRAWING NO.	APPENDIX B PAGE NO.
WB-1	CH-M-2445-C	1
WB-2	CH-M-2445-C	1
WB-3	CH-M-2445-C	1
WB-4	CH-M-2445-C	1
WB-5	CH-M-2445-C	1
WB-6	CH-M-2460-B	3
WB-7	CH-M-2507-C	4
WB-8	CH-M-2507-C	4
WB-9	CH-M-2507-C	4
WB-10	CH-M-2553-C	7
WB-11	CH-M-2593-C	11
WB-12	CH-M-2553-C	7
WB-13	CH-M-2571-C	8
WB-14	CH-M-2550-C	5
WB-15	CH-M-2552-C	6
WB-16	CH-M-2591-B	10
WB-17	CH-M-2571-C	8
WB-18	CH-M-2571-C	8
WB-19	CH-M-2571-C	8
WB-20	CH-M-2589-B	9
WB-21	CH-M-2571-C	8
WB-23	CH-M-2597-C	12
WB-24	CH-M-2597-C	12
WB-25	CH-M-2597-C	12
WB-26	CH-M-2597-C	12
WB-27	CH-M-2597-C	12
WB-29	CH-M-2591-B	10
WB-30	CH-M-2591-B	10
WB-31	CH-M-2597-C	12
WB-32	CH-M-2597-C	12
WB-33	CH-M-2638-C	
WB-34	CH-M-2638-C	
WB-35	CH-M-2597-C	12
WB-36	CH-M-2597-C	12
WB-37	CH-M-2678-B	13
WB-38	CH-M-2742-C	14
WB-39	CH-M-2771-C	15
WB-ET-1	CH-M-2447-B	2
7-1-8-CS-3-WAB	D-5420 032 (SWRI)	22
10.5-7-8-CS-4-WAB	D-5420 033 (SWRI)	23
16-59-2	D-5420 037 (SWRI)	25
IR-CSCL-2-WAB	D-5420 031 (SWRI)	21
NS-CSCL-1-WAB	D-5420 030 (SWRI)	20
Q-7053 1 of 2 Q-7053 2 of 2	D-5420 035 (SWRI)	24
TO 4519 TO 7216		
WAT-UT-01	D-5420 022 (SWRI)	17
WAT-UT-02	D-5420 026 (SWRI)	19
WAT-UT-03	D-5420 025 (SWRI)	18
WAT-UT-05	D-5420 021 (SWRI)	16
WAT-UT-06	2414 SH-7 (RDM)	26



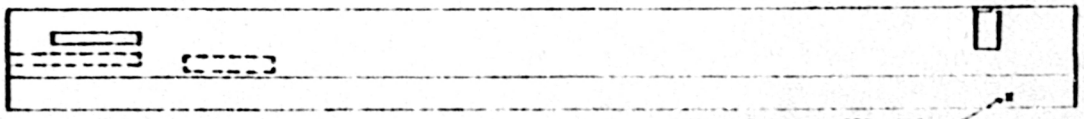
BLOCK NO.	DIA.	T	D	A	H	L
XX-1*	6	0.681	0.034	120°	3/32	1/2 T
XX-2	8	0.878	0.044	120°	3/32	1/2 T
XX-3	12	1.126	0.056	120°	1/8	1/4 T
XX-4	16	0.827	0.041	120°	3/32	1/2 T
XX-5	32	1.434	0.072	60°	1/8	1/4 T

* NOTE:
SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.



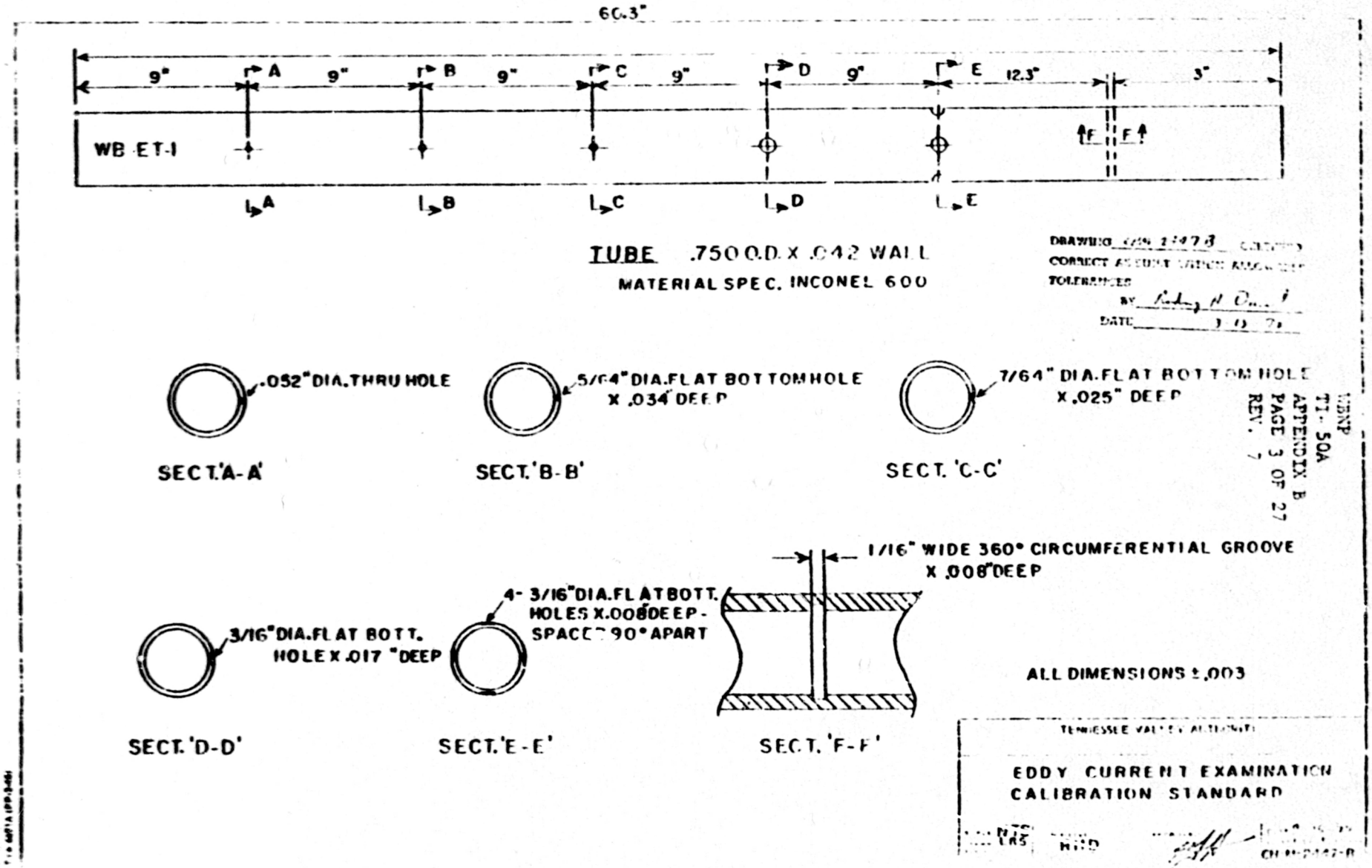
SECTION B-B

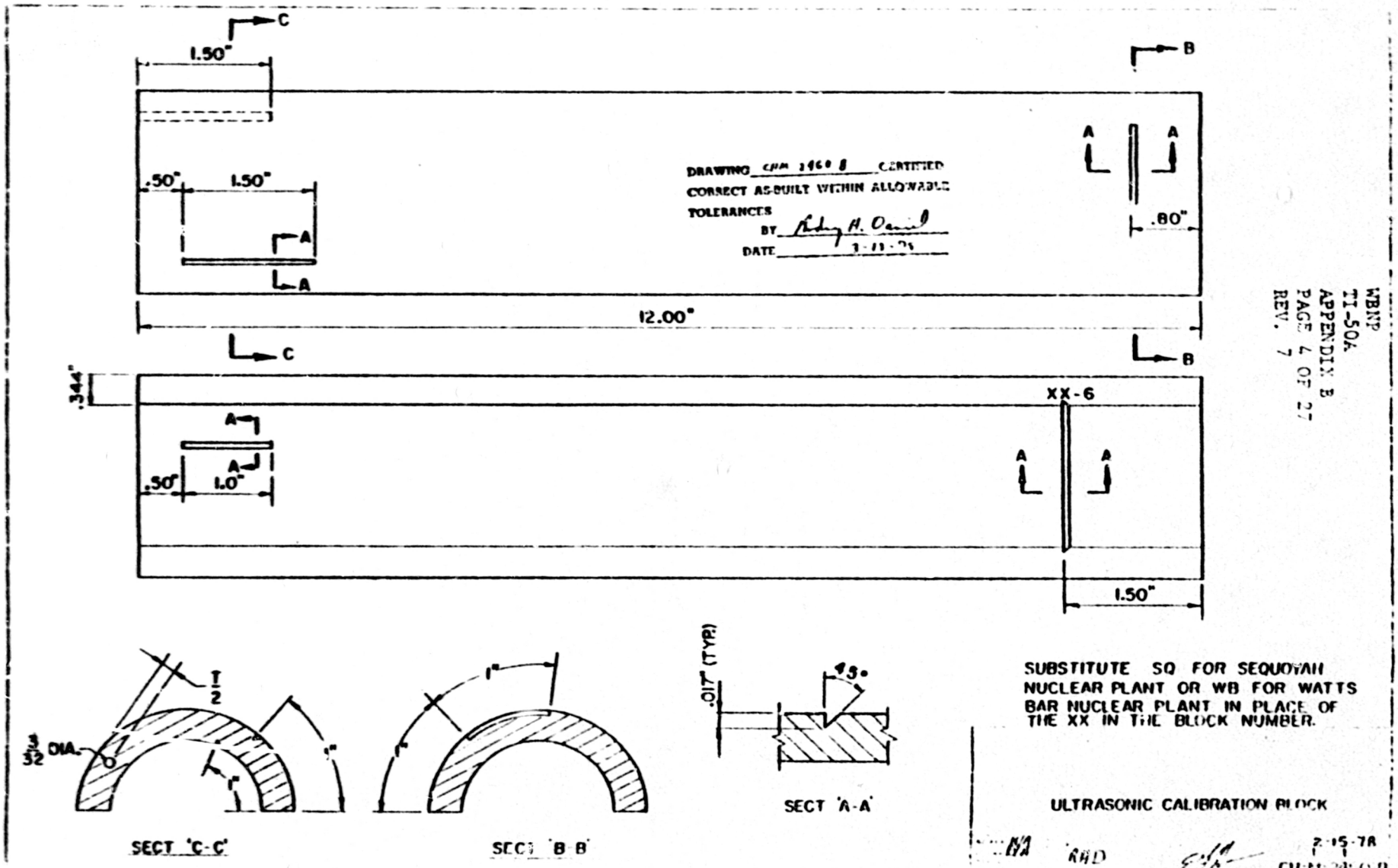
SECTION C-C

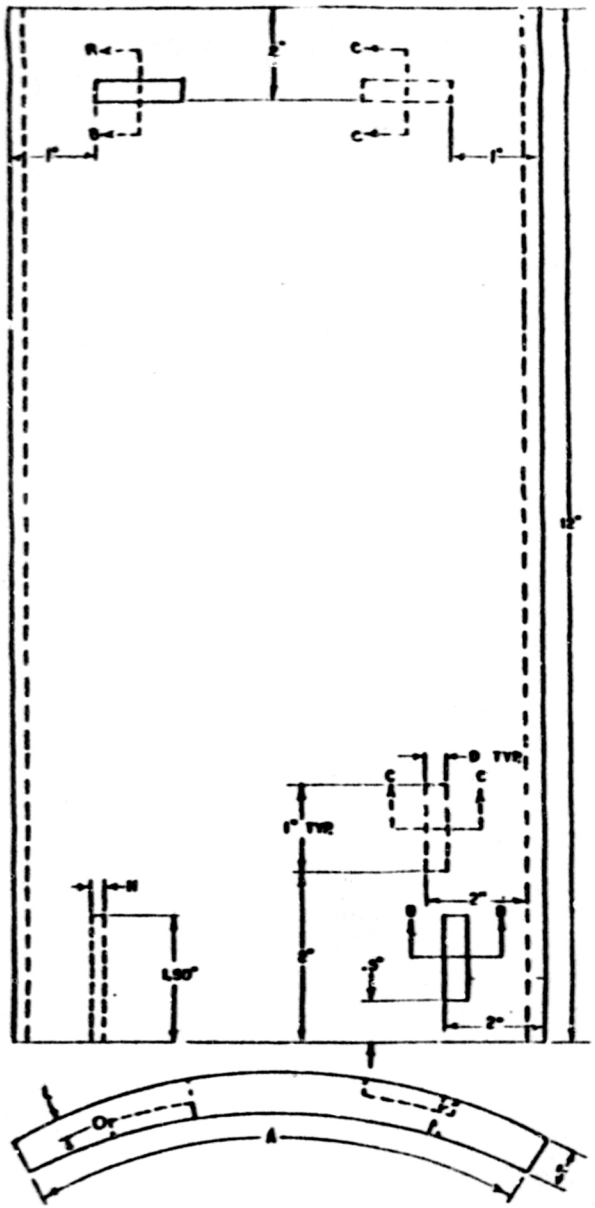


STAMP BLOCK NUMBER HERE

ULTRASONIC CALIBRATION BLOCKS

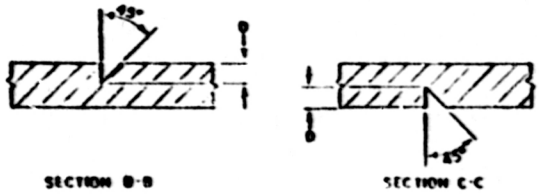

60.3"
9"
A
9"
B
9"
C
9"
D
9"
E
12.3"
3"
WB ET-1
F
F
A
B
C
D
E
TUBE .750 O.D. X .042 WALL
MATERIAL SPEC. INCONEL 600
DRAWING
CORRECT AS SUBJECT WITHIN ALLOWABLE TOLERANCES
BY
DATE
.052" DIA. THRU HOLE
SECT. 'A-A'
5/64" DIA. FLAT BOTTOM HOLE X .034" DEEP
SECT. 'B-B'
7/64" DIA. FLAT BOTTOM HOLE X .025" DEEP
SECT. 'C-C'
WBNP
TI-50A
APPENDIX B
PAGE 3 OF 27
REV. 7
1/16" WIDE 360° CIRCUMFERENTIAL GROOVE X .008" DEEP
3/16" DIA. FLAT BOTT. HOLE X .017" DEEP
SECT. 'D-D'
4- 3/16" DIA. FLAT BOTT. HOLES X .008" DEEP - SPACED 90° APART
SECT. 'E-E'
SECT. 'F-F'
ALL DIMENSIONS ±.003
TENNESSEE VALLEY AUTHORITY
EDDY CURRENT EXAMINATION
CALIBRATION STANDARD


C
1.50"
B
A
A
.50"
1.50"
A
A
.80"
DRAWING CHM 3460 B CERTIFIED
CORRECT AS-BUILT WITHIN ALLOWABLE
TOLERANCES
BY
DATE
12.00"
C
B
.344"
XX-6
A
A
A
A
.50"
1.0"
1.50"
1/2
3/32 DIA.
1"
1"
1"
1"
.017" (TYP.)
45°
SECT 'C-C'
SECT 'B-B'
SECT 'A-A'
SUBSTITUTE SQ FOR SEQUOYAH
NUCLEAR PLANT OR WB FOR WATTS
BAR NUCLEAR PLANT IN PLACE OF
THE XX IN THE BLOCK NUMBER.
ULTRASONIC CALIBRATION BLOCK
N/A
RAD
2-15-78
WBNP
TI-50A
APPENDIX B
PAGE 4 OF 27
REV. 7



BLOCK NO	DIA	T	D	A	H	L
XX-7	8"	0.75	0.016	120°	3/32	1/2 T
XX-8	12"	0.75	0.016	120°	3/32	1/2 T
XX-9	8"	0.309	0.015	120°	3/32	1/2 T

* NOTE:
SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.

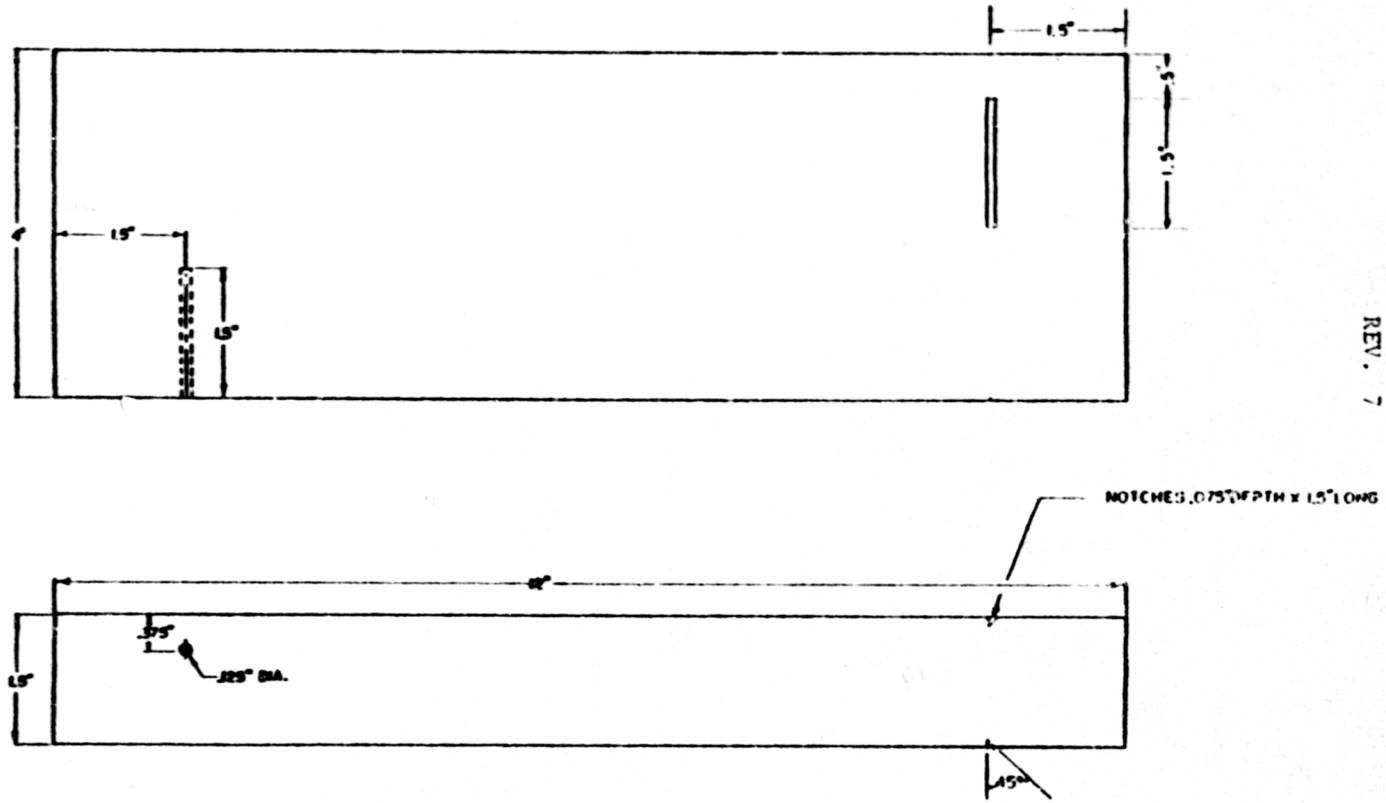


SECTION B-B

SECTION C-C

STAMP BLOCK NUMBER HERE

ULTRASONIC CALIBRATION BLOCKS

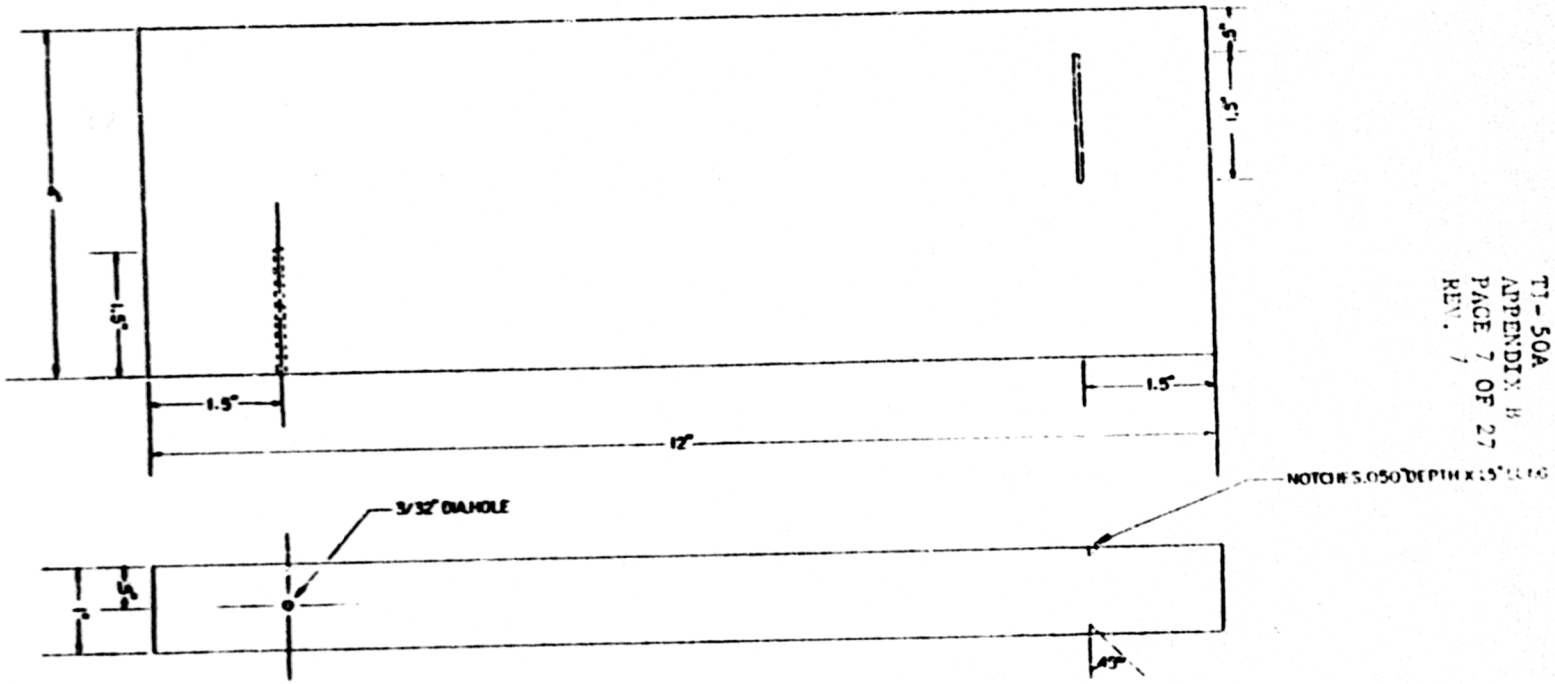


SS GRADE 70 WB-14 SO-14

TENNESSEE VALLEY AUTHORITY

DIVISION OF POWER PRODUCTION

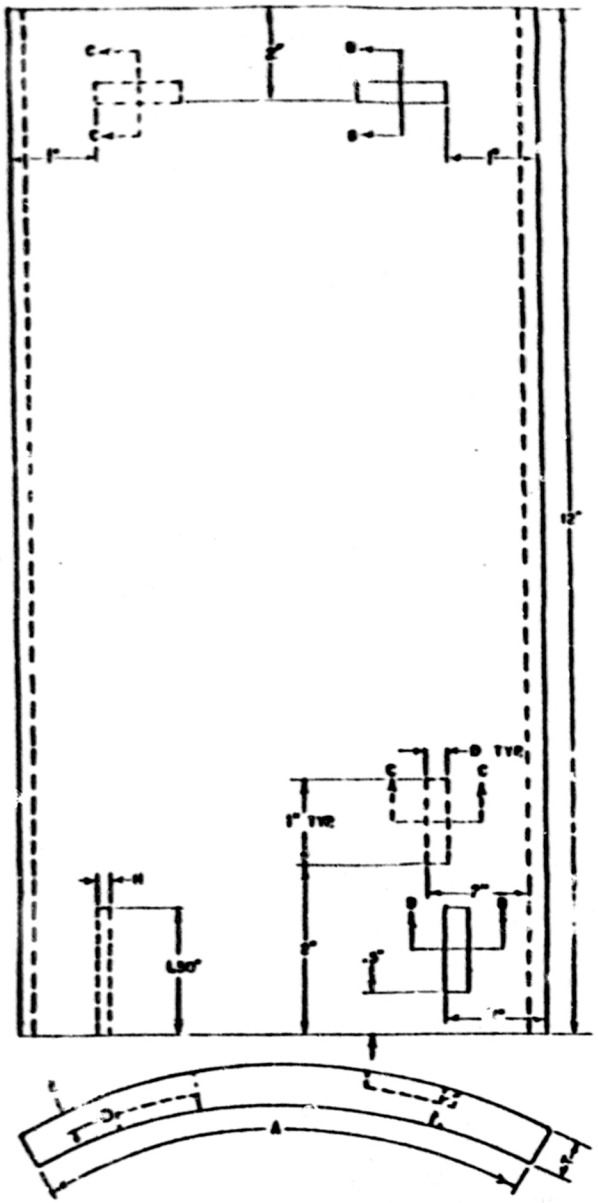
ULTRASONIC CALIBRATION BLOCK
WATTS BAR NUCLEAR PLANT &
SEQUOYAH NUCLEAR PLANT
MAIN STEAM SYSTEM



SS 304 WE 15 SD 15

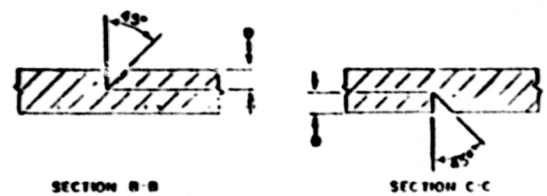
TENNESSEE VALLEY AUTHORITY

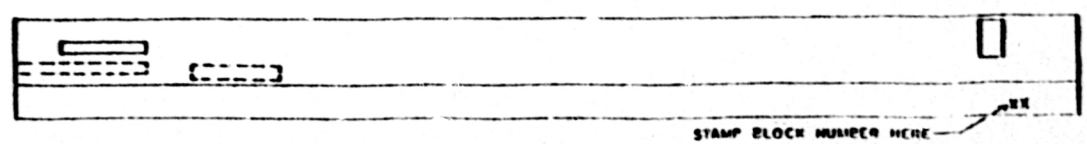
ULTRASONIC CALIBRATION BLOCK
WATTS BAR NUCLEAR PLANT &
SEQUOYAH NUCLEAR PLANT
RHR SYSTEM



BLOCK NO	DIA	T	D	A	H	L
XX-10	14"	1.362	0.068	120°	1/8	1/4T
XX-12	2 1/2"	0.415	0.021	180°	3/32	1/2T

* NOTE:
SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.

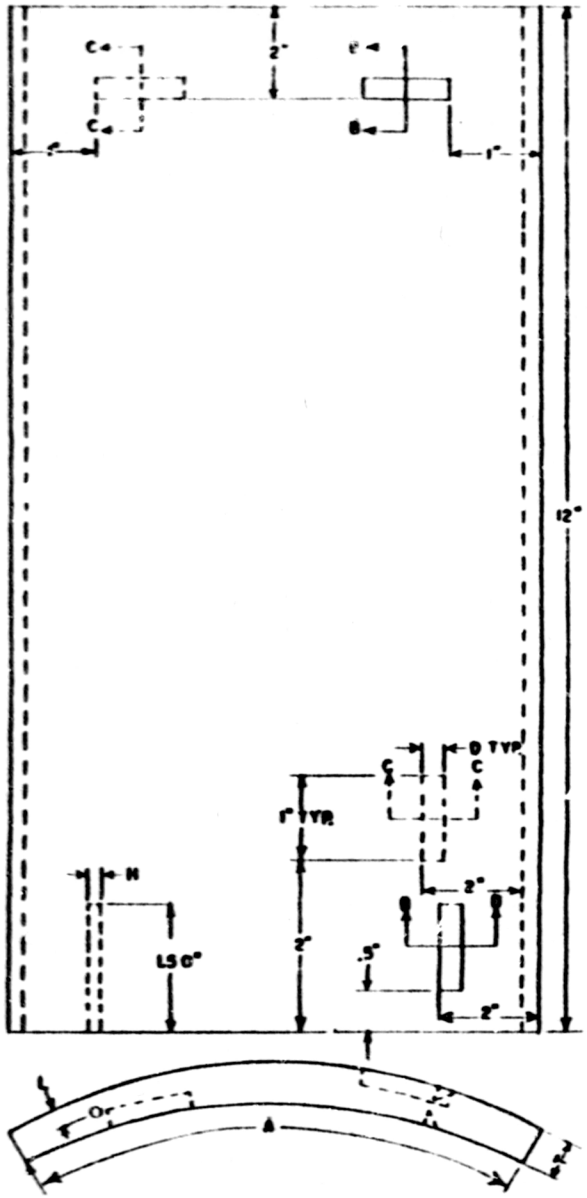




TENNESSEE VALLEY AUTHORITY

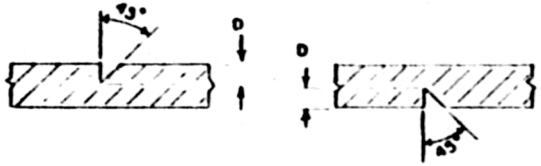
ULTRASONIC CALIBRATION BLOCKS

SCALE: NTS | DATE 7-13-70
DRAWN BY: | CHK 2553 C



BLOCK NO	DIA	T	D	A	H	L
XX-13	4"	0.438	0.022	180°	3/32	1/2 T
XX-17	5"	0.625	0.031	180°	3/32	1/2 T
XX-18	18"	0.919	0.047	120°	3/32	1/2 T
XX-19	6"	0.864	0.043	180°	3/32	1/2 T
XX-21	10"	1.500	0.075	180°	1/8	1/4T

NOTE: SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.

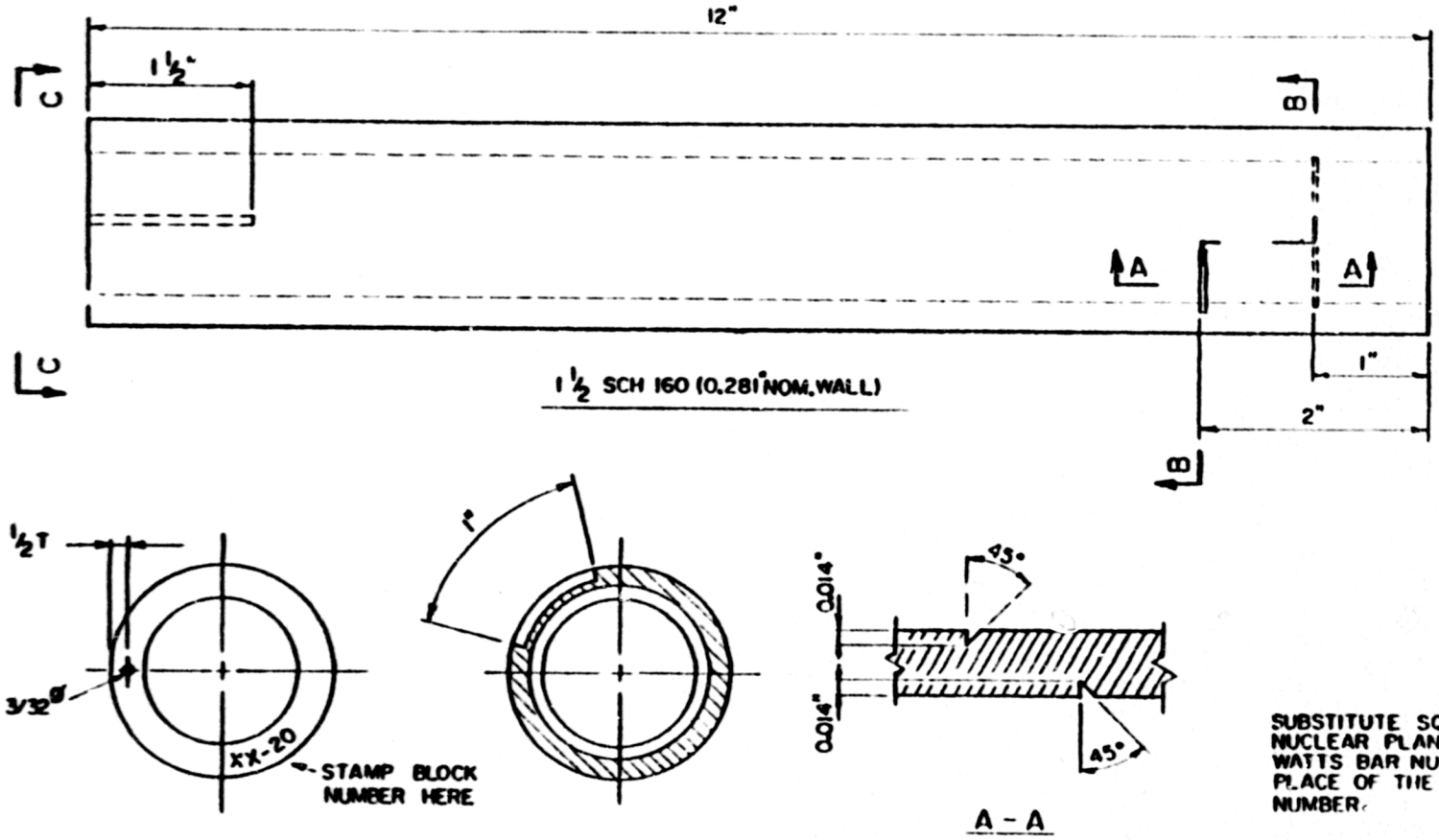


SECTION B-B SECTION C-C

STAMP BLOCK NUMBER HERE

TENNESSEE VALLEY AUTHORITY
DIVISION OF POWER PRODUCTION

ULTRASONIC CALIBRATION BLOCKS



SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.

TENNESSEE VALLEY AUTHORITY

ULTRASONIC CALIBRATION BLOCK

NTS | RHB | 1-29-79

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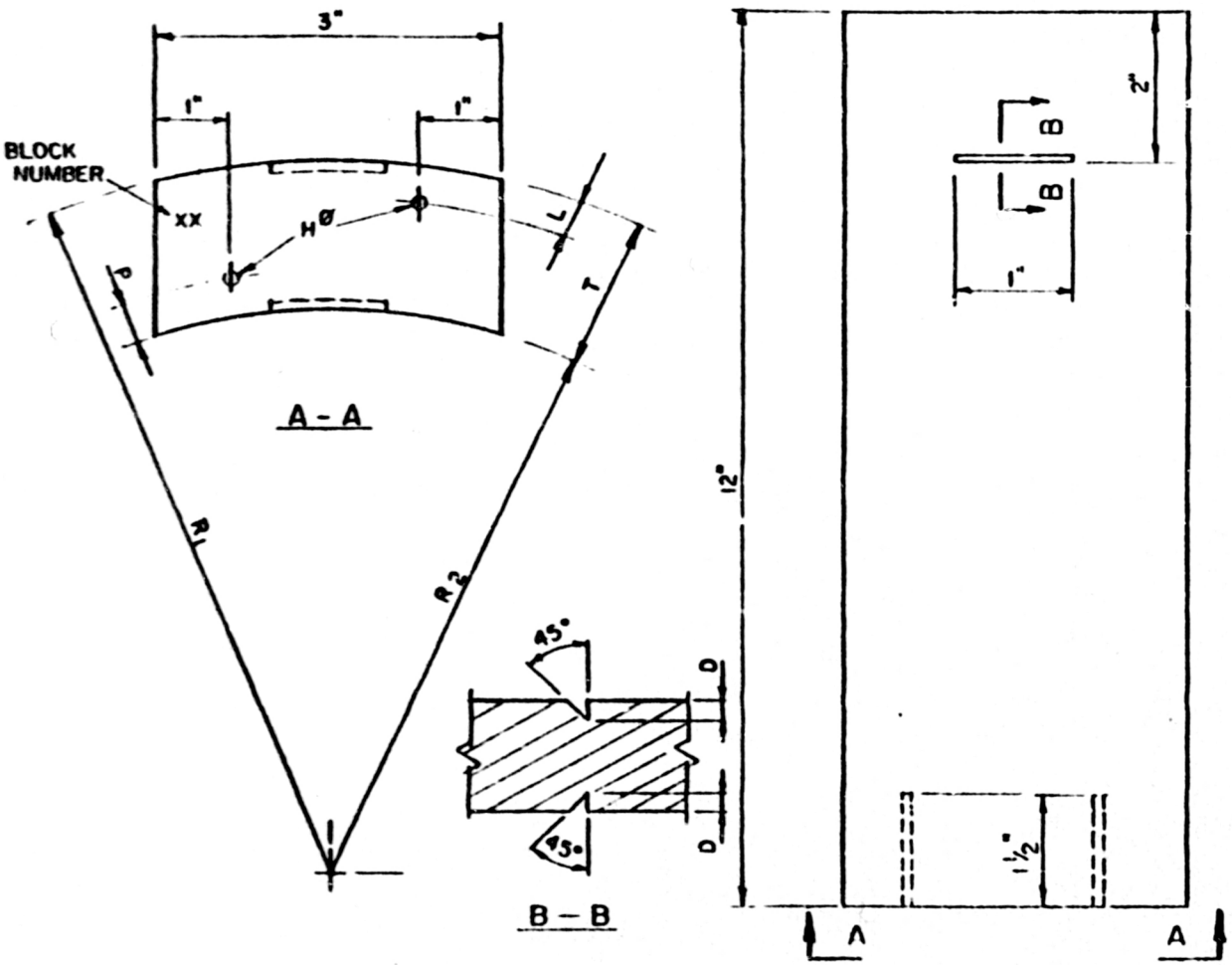


BLOCK NUMBER	R_1	R_2	D	T	L	H	P
XX-16	6.375	5.063	0.066	1.312	1/4 T	1/8	1/4T
XX-29	4.200	3.000	0.060	1.200	1/4 T	1/8	1/4T
XX-30	2.900	2.000	0.045	0.900	1/2 T	3/32	NA

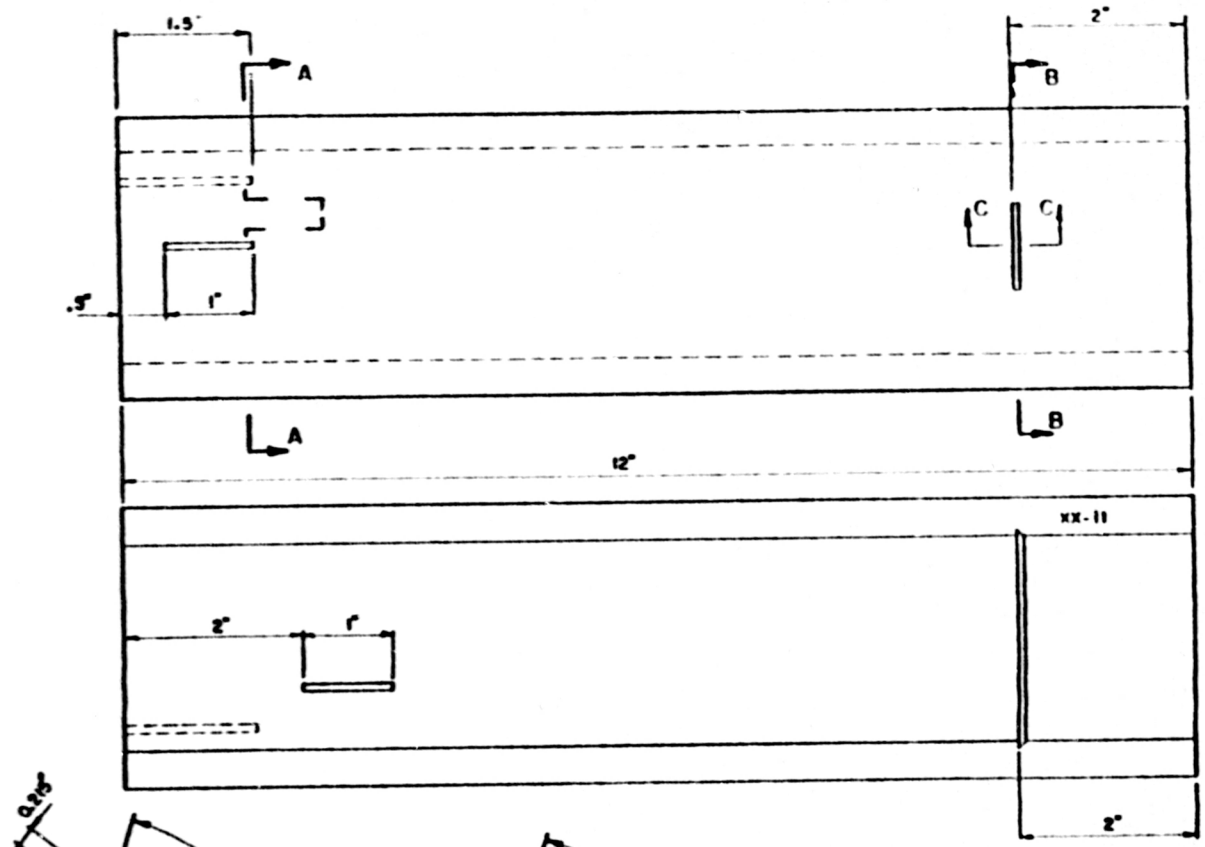
SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.

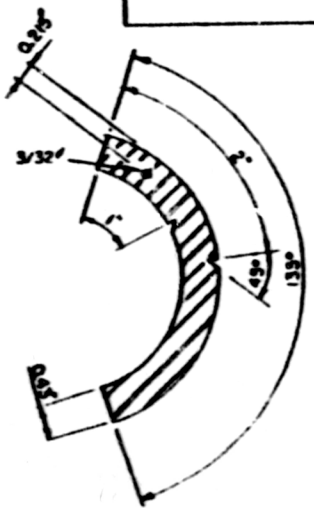
FABRICATE FROM S.S. PLATE.

TENNESSEE VALLEY AUTHORITY

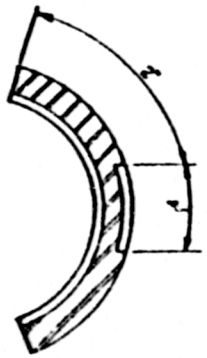
ULTRASONIC CALIBRATION BLOCKS

NTS | R/TD | 1/30/71 | CH-M-2501-1

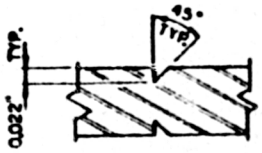




A-A



B-B



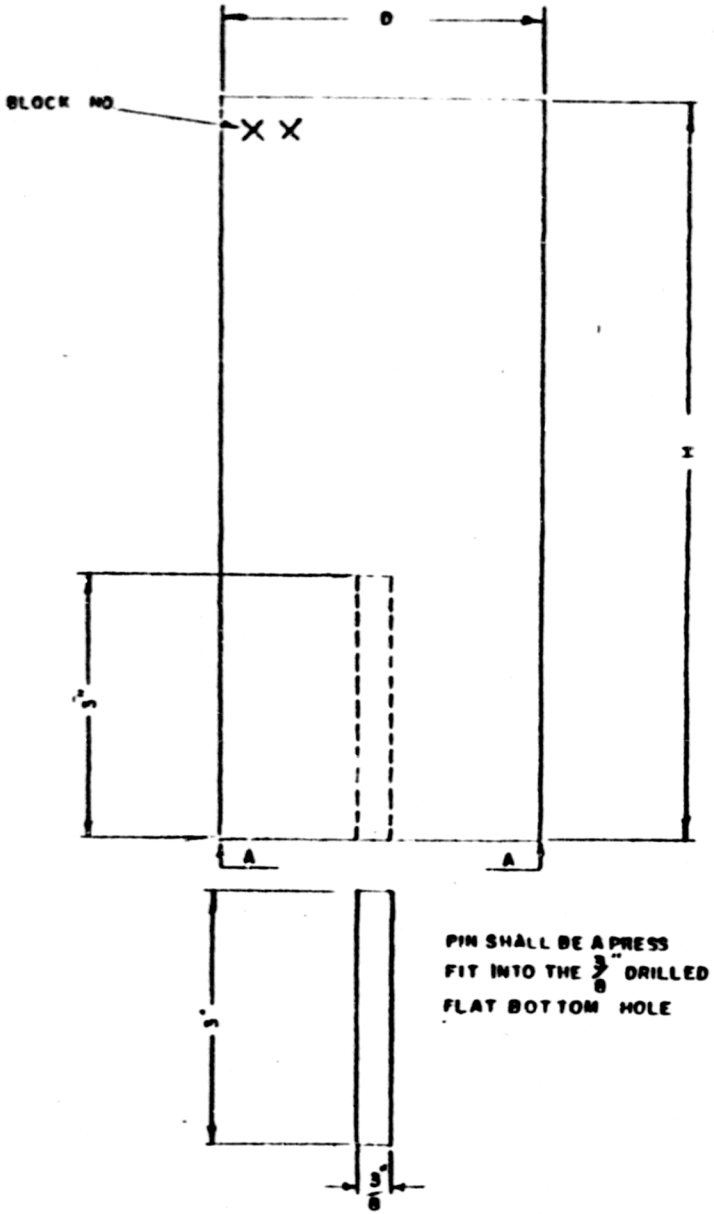
C-C

NOTES:

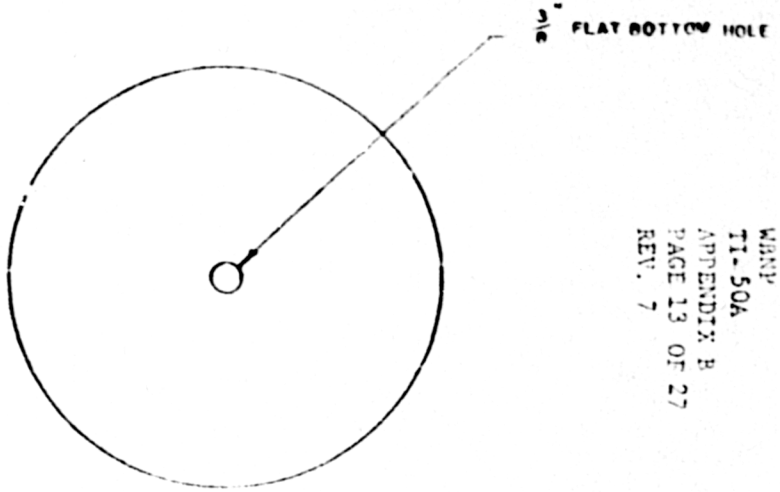
1. MAT'L: 3" SCH 160 PIPE SS.
2. SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER.

TENNESSEE VALLEY AUTHORITY
DIVISION OF POWER PRODUCTION

ULTRASONIC CALIBRATION BLOCK XX-11



PIN SHALL BE A PRESS FIT INTO THE 3/8" DRILLED FLAT BOTTOM HOLE



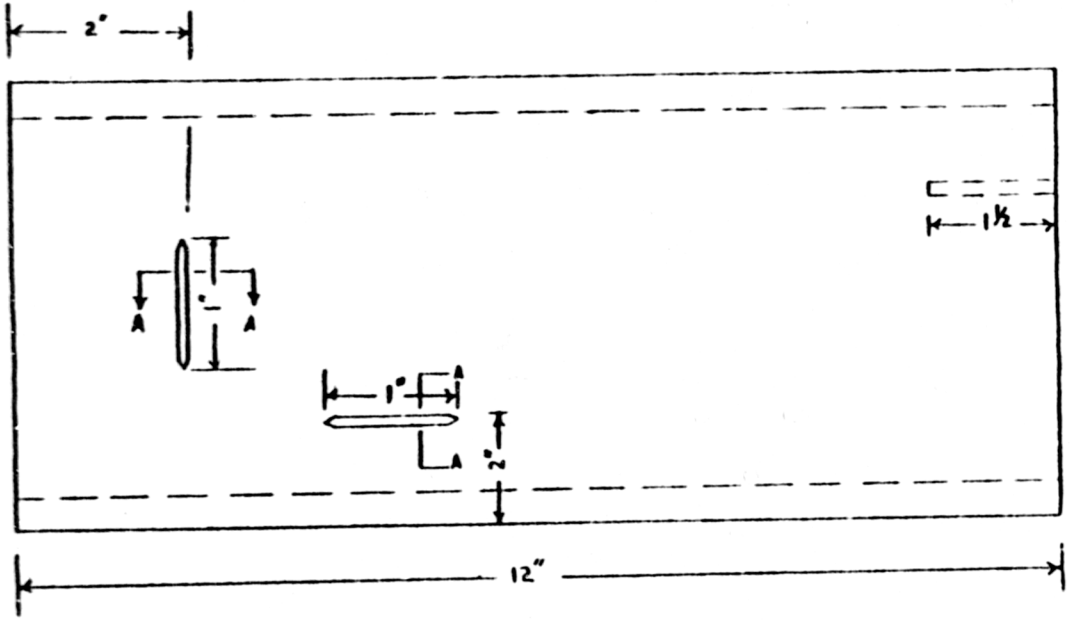
A-A

NOTE: 1. PIN SHALL BE SAME MATERIAL AS ROLLED STOCK
2. SUBSTITUTE SQ FOR SEQUOYAH NUCLEAR PLANT OR WB FOR WATTS BAR NUCLEAR PLANT IN PLACE OF THE XX IN THE BLOCK NUMBER

BLOCK	D	H	MATERIAL
XX 23	1 3/8"	17"	SA-A3 GRB7
XX 24	1 1/4"	9"	SA-A3GRB7
XX 25	1 1/8"	10 1/2"	SA-A3GRB7
XX 26	4 1/2"	30 1/2"	SA-A3GRB7
XX 27	2"	8"	SA-A3GRB7
XX 31	1 1/4"	7 1/2"	AISI-4140
XX 32	1 1/4"	10"	AISI-4140
XX 35	1 3/8"	8"	AISI-4140
XX 36	1 1/8"	10 3/4"	AISI-4140

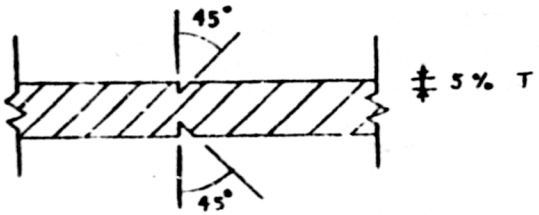
TENNESSEE VALLEY AUTHORITY
DIVISION OF POWER PRODUCTION

STUD AND BOLT CALIBRATION BLOCK



SA-53 GR B

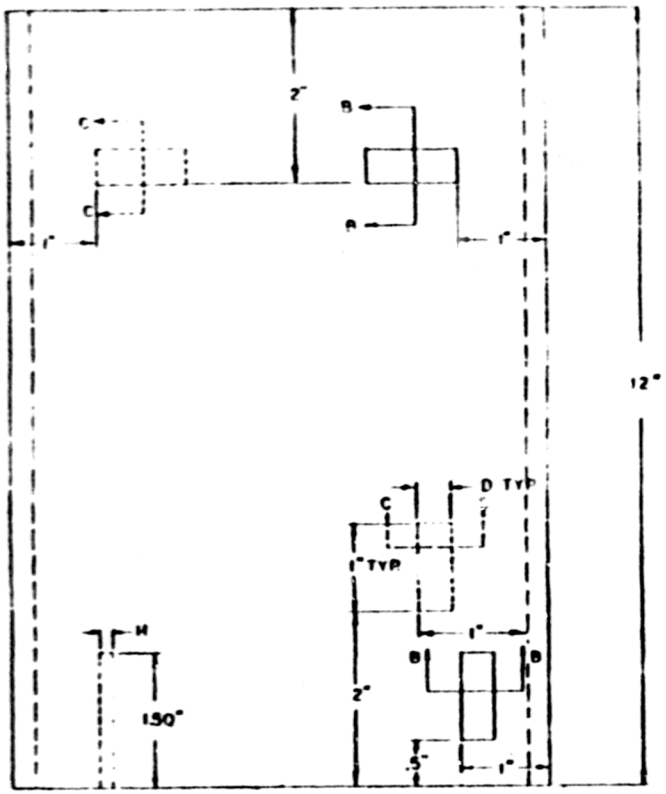
SECTION A-A



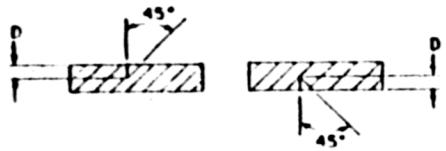
TENNESSEE VALLEY AUTHORITY
DIVISION OF POWER PRODUCTION

6" SCH 80
UT PIPE CALIBRATION BLOCK WBNP

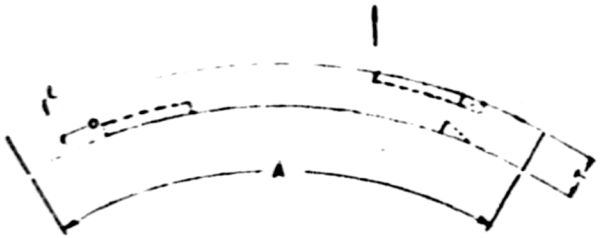
RHD



BLOCK NO.	DIA.	T	D	A	H	L
WB 3A	8"	0.500	0.025	120°	3/32	1/2 T



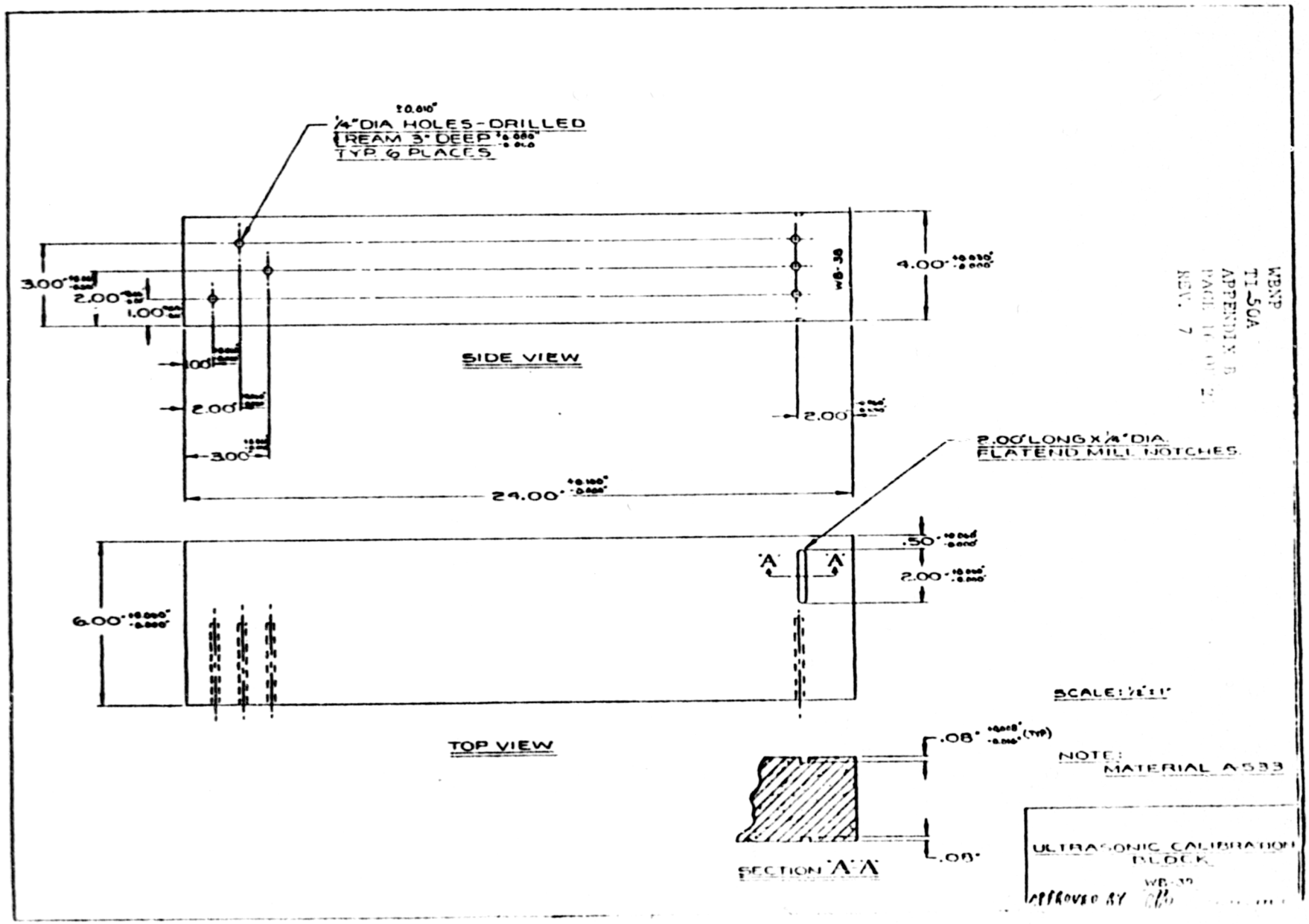
SECTION B-B SECTION C-C

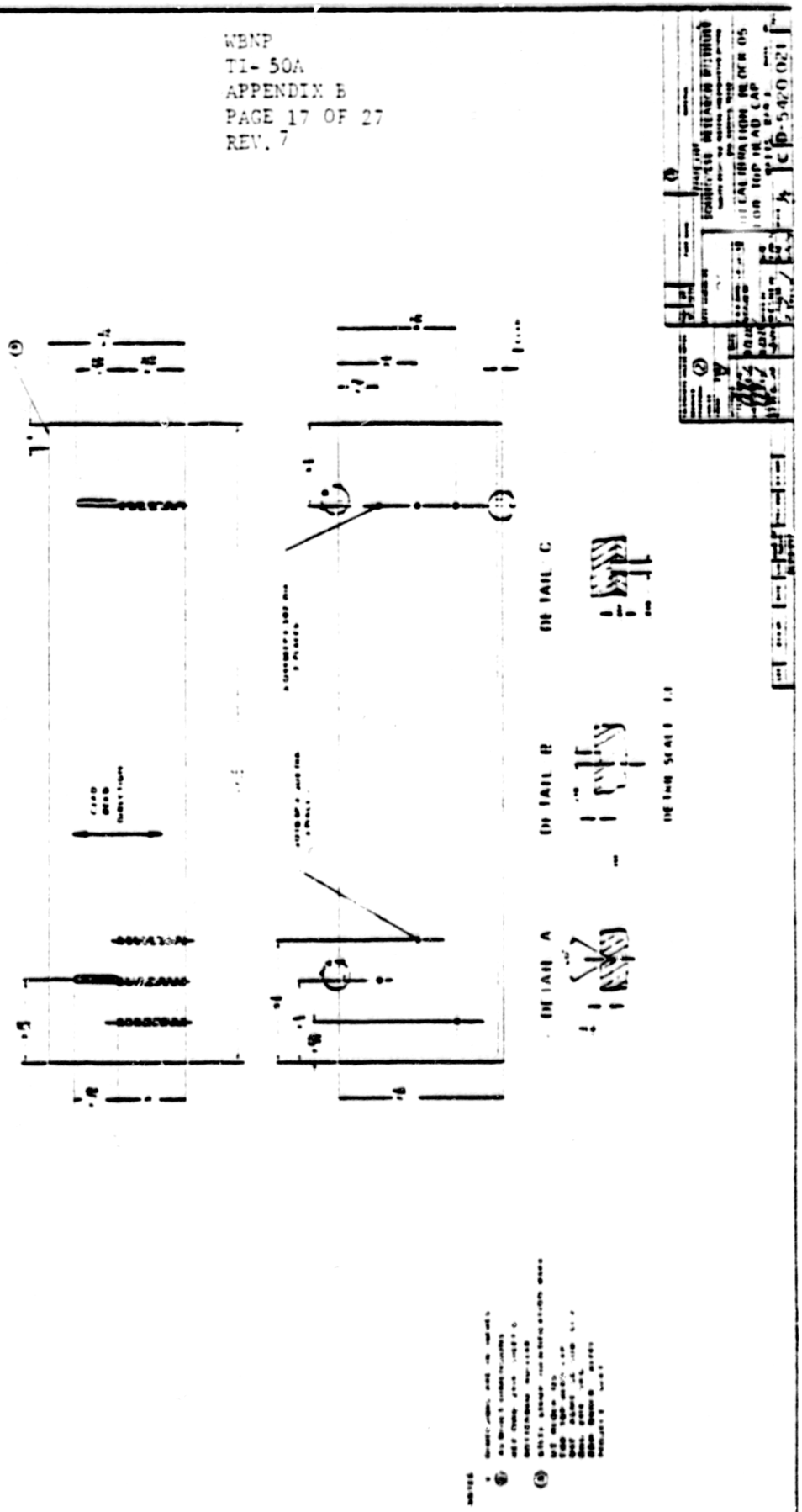


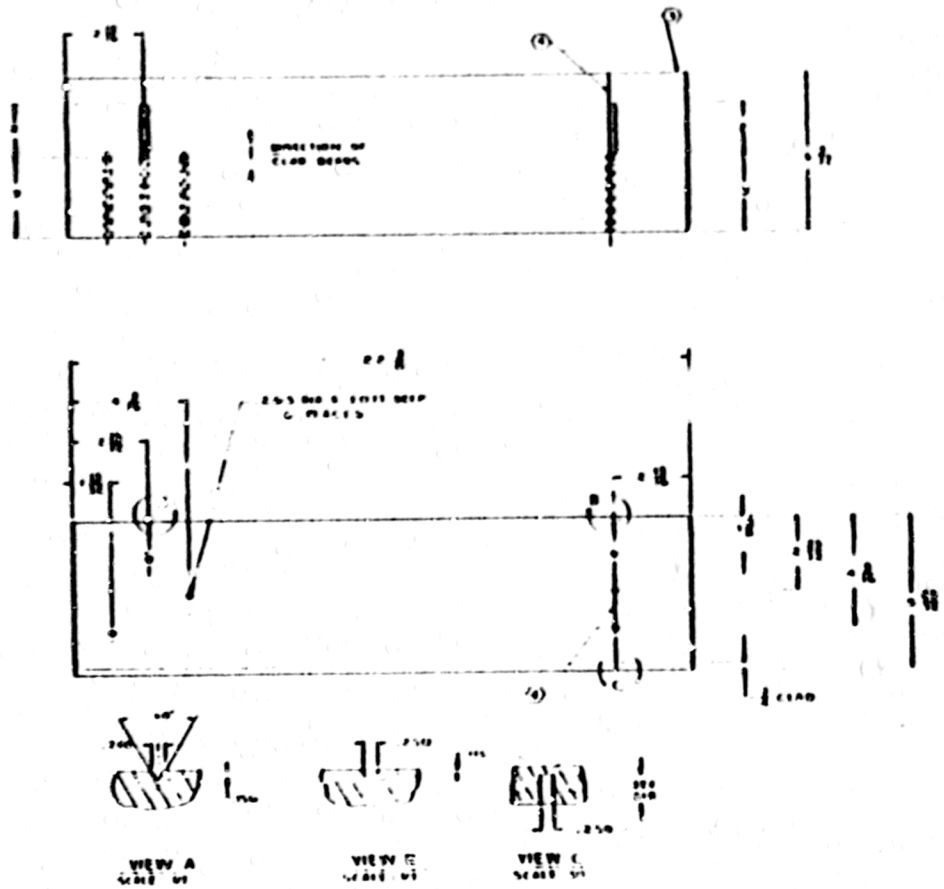
STAMP BLOCK NO. HERE

TENNESSEE VALLEY AUTHORITY
DIVISION OF POWER PRODUCTION

ULTRASONIC CALIBRATION BLOCK


±0.010"
1/4" DIA HOLES-DRILLED
REAM 3" DEEP
TYP. 6 PLACES
3.00"
2.00"
1.00"
1.00"
2.00"
3.00"
SIDE VIEW
WB-38
4.00"
2.00"
24.00"
2.00" LONG X 1/4" DIA.
FLATEND MILL NOTCHES.
.50"
2.00"
'A'
'A'
6.00"
TOP VIEW
SCALE: 1/2"=1"
.08"
(TYP)
.08"
SECTION 'A'-'A'
NOTE:
MATERIAL A-533
ULTRASONIC CALIBRATION
BLOCK
WB-39
APPROVED BY


DETAIL A
DETAIL B
DETAIL C
CALIBRATION INCH 05
FOR TOP HEAD CAP



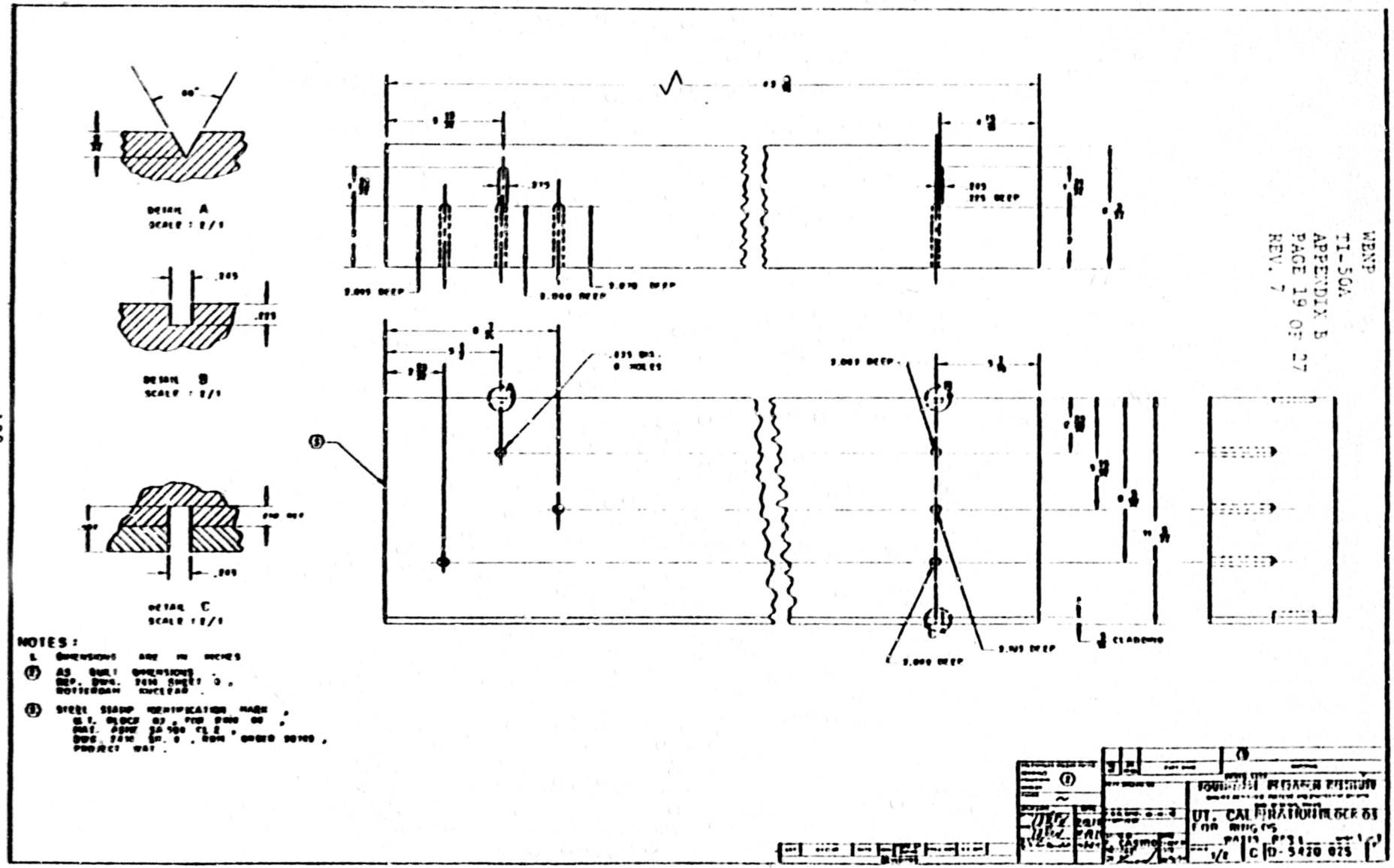
NOTES:

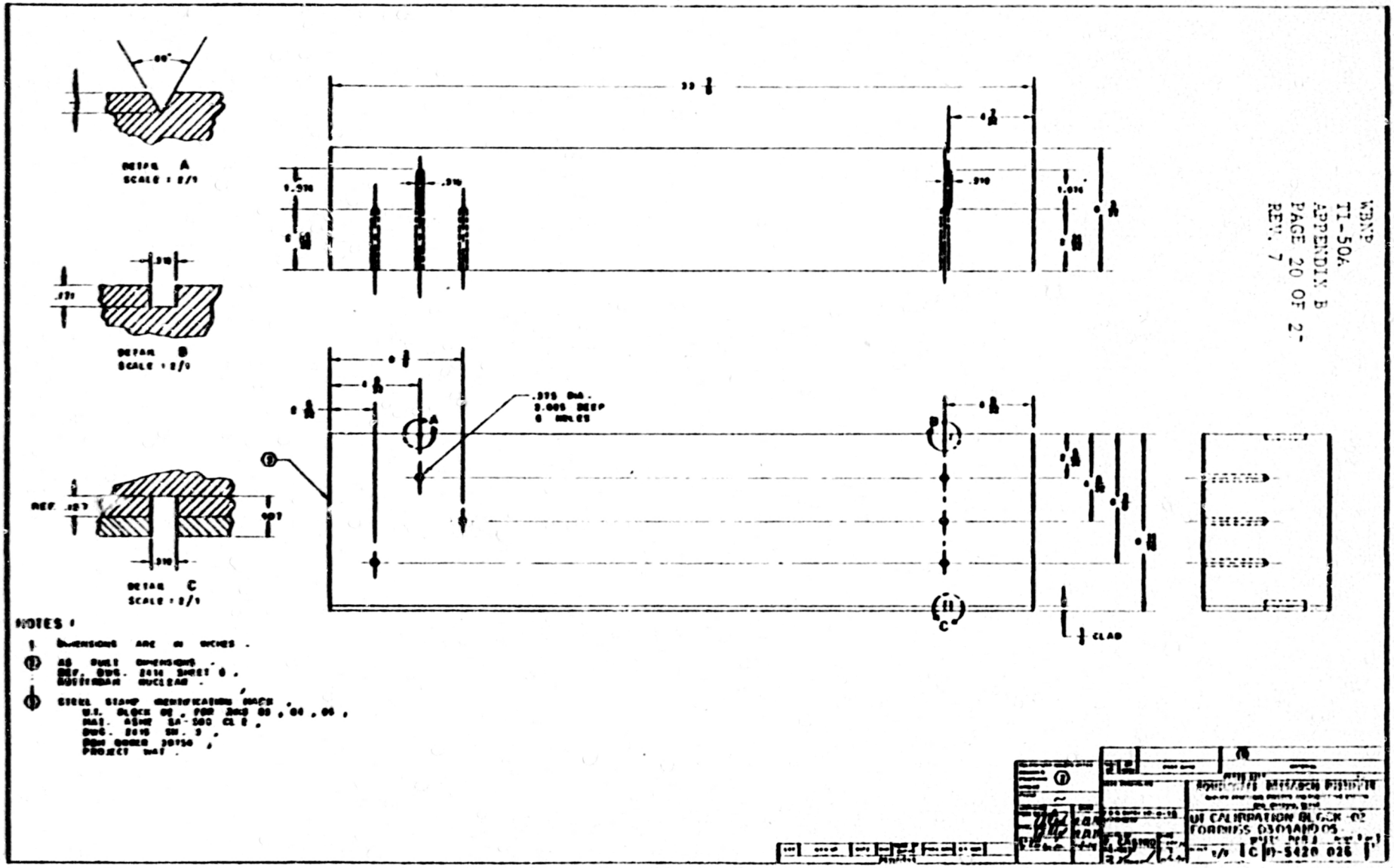
1. DIMENSIONS ARE IN INCHES
2. AS BUILT DIMENSIONS
ROTTERDAM WELDING
3. STEEL STAMP IDENTIFICATION MARK
U.T. BLOCK OF FOR BOTTOM HEAD CAP
MAT ASME SA 508 CL 2
PROJECT SHT 1
4. SENSE LINE (DESIGN INSP) ON TOP AND BOTTOM OF BLOCK TO BE THE EXTENSION OF SENSE LINE ON LINE AND TO PASS ALONG EDGE OF SQUARE NOTCH

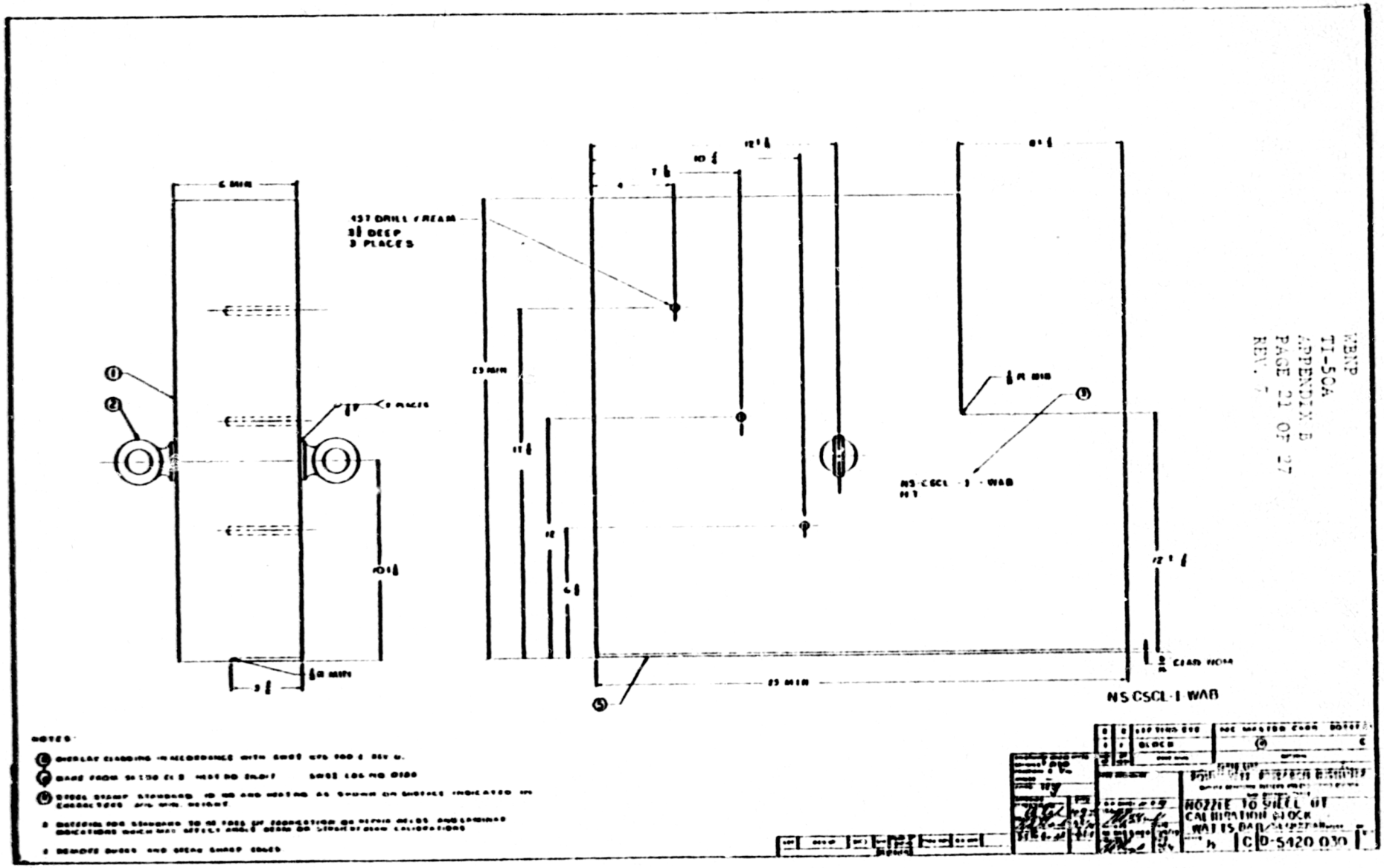
WESTINGHOUSE RESEARCH INSTITUTE

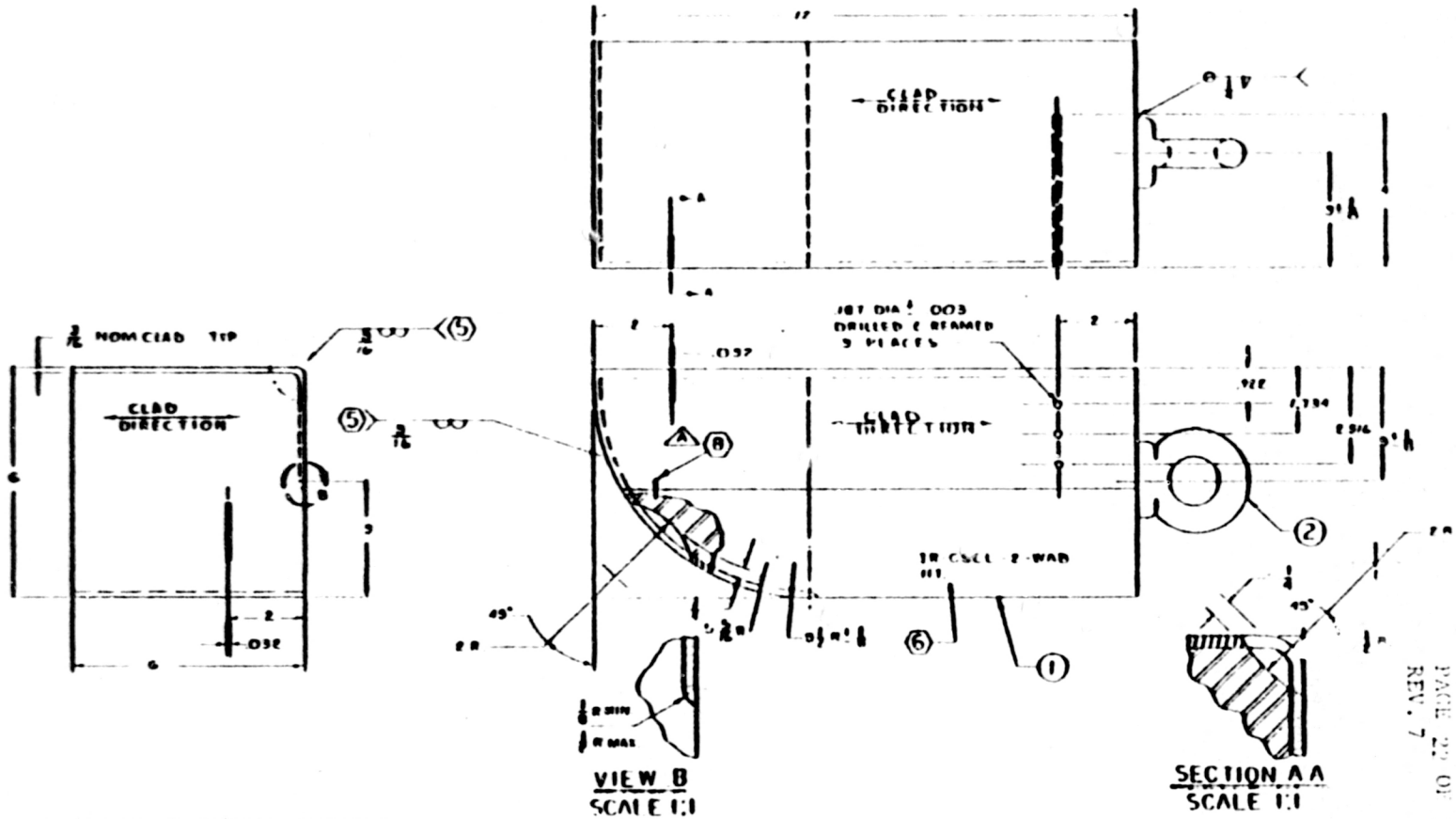
UT CALIBRATION BLOCK OF FOR BOTTOM HEAD CAP

C D-5420022


DETAIL A
SCALE : 2/1
DETAIL B
SCALE : 2/1
DETAIL C
SCALE : 2/1
NOTES :
1. DIMENSIONS ARE IN INCHES
2. AS BUILT DIMENSIONS
3. STEEL STAMP IDENTIFICATION MARK
UT. CALIBRATION BLOCK 03
FOR RING 05
D-5420 025


DETAIL A
SCALE : 2/1
DETAIL B
SCALE : 2/1
DETAIL C
SCALE : 2/1
.375 DIA.
3.005 DEEP
6 HOLES
CLAD
NOTES :
1. DIMENSIONS ARE IN INCHES.
UT CALIBRATION BLOCK -02
FORMISS D301AND05


NS CSCL-1 WAB
NOZZLE TO SHELL UT
CALIBRATION BLOCK
C D-5420 030



IR CSCL - 2 - WAB

(8) SAW CUT OR SURFACE SHOWN, NOT TO BE USED FOR CALIBRATION.

(7) MAKE FROM SA508 CL II HT NO. 216817 SWRI LOG NO 0788

(6) STEEL STAMP ID NO. AS SHOWN ON SURFACE INDICATED IN CHARACTERS 3/16 MIN HEIGHT

(5) HAND GRIND OR MACHINE FLUSH TO CONTOUR SHOWN AND MACHINE FLAT SURFACES FLUSH

4. CLAD OVERLAY IN ACCORDANCE WITH SWRI WPS 900 2 REV. 1

3. MATERIAL TO BE FREE OF FABRICATION OR REPAIR WELDS AND LAMINAR INDICATIONS WHICH MAY AFFECT CALIBRATION.

2. DEBURR/BREAK SHARP EDGES 1/32.

1. DIMENSIONS ARE IN INCHES.

2	1	LIFTING EYE	McMASTER-CARR 3024T26
1	1	BLOCK	(7) C

PARTS LIST

SOUTHWEST RESEARCH INSTITUTE
QUALITY ASSURANCE SYSTEMS ENGINEERING DIVISION
SAN ANTONIO, TEXAS

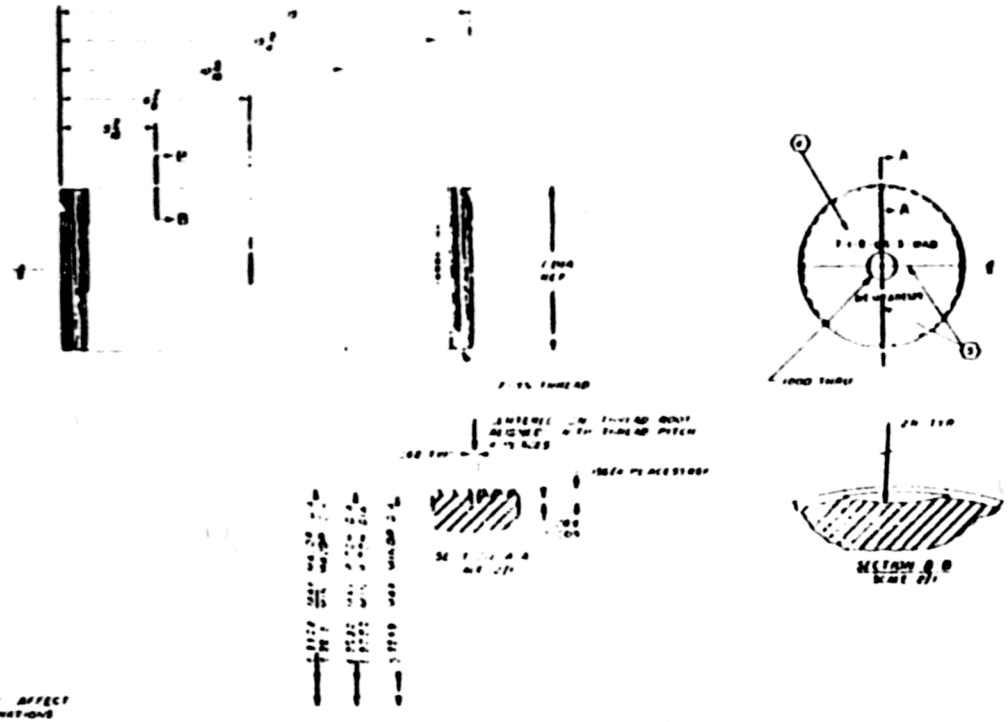
INLET/OUTLET NOZZLE INNER RADIUS UT CALIBRATION BLOCK
WATTS BAR/SEQUOYAH

A	2732		

REVISIONS

M. MESHEW

1/2 | C | C-5420031 | A



NOTES

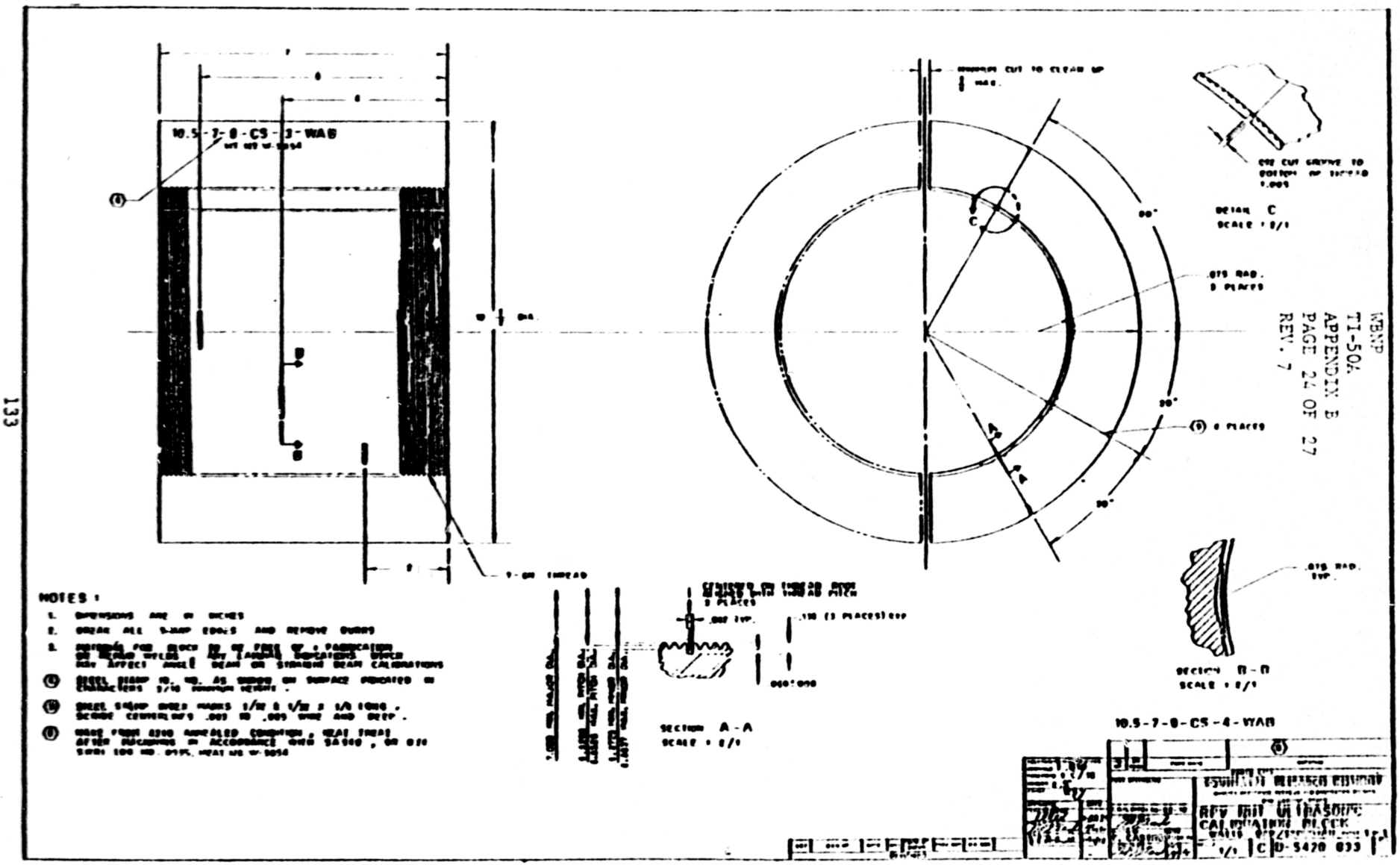
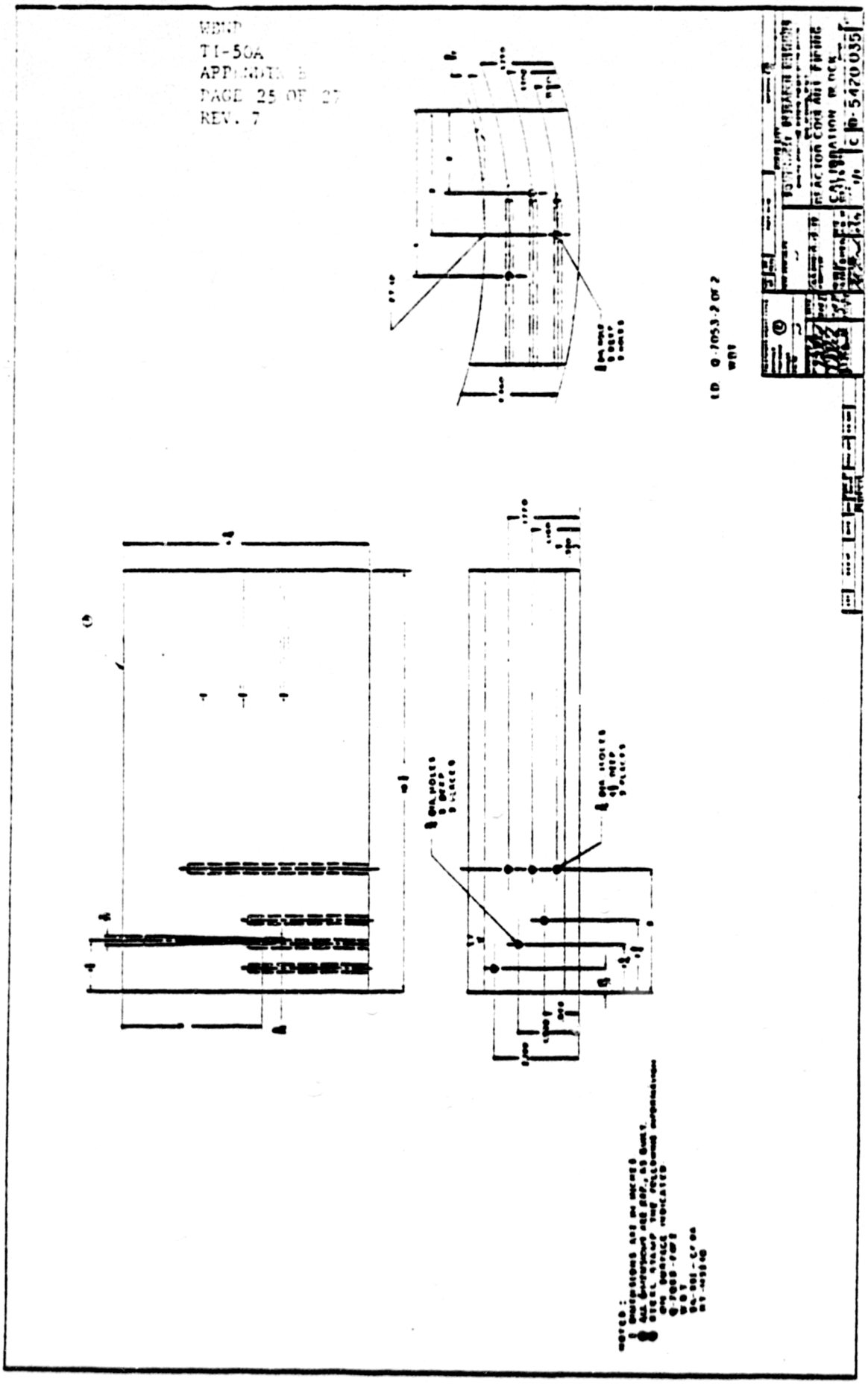
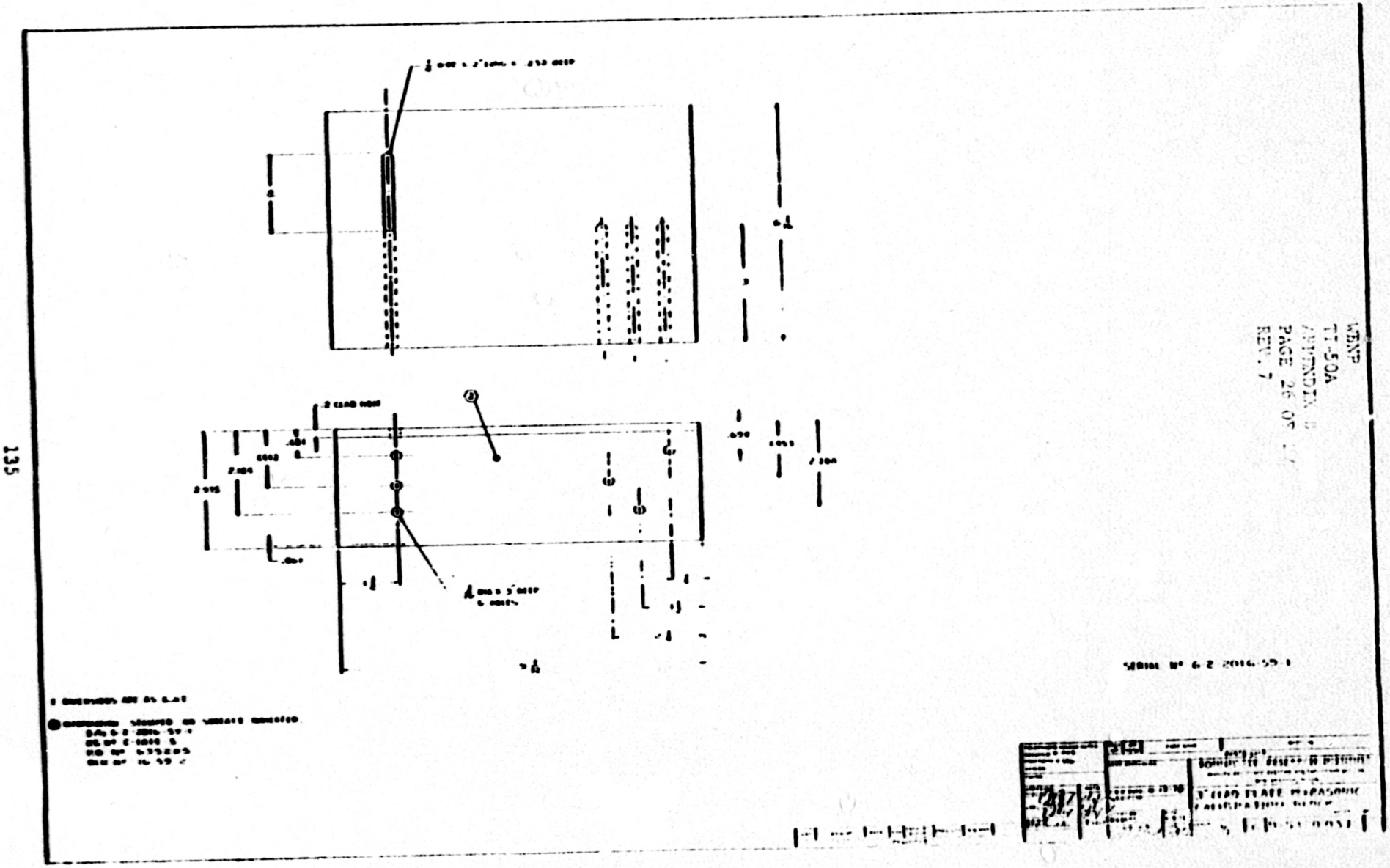
1. DIMENSIONS ARE IN INCHES
2. DEBURR & BREAK SHARP EDGES
3. MATERIAL FOR BLOCK TO BE FREE OF FABRICATION OR REPAIR WELDS, ANY LAMINAR INDICATIONS WHICH MAY AFFECT ANGLE BEAM OR STRAIGHT BEAM CALIBRATIONS
4. STEEL STAMP ID NO AS SHOWN, ON SURFACE INDICATED IN CHARACTERS 3/16" MIN HEIGHT
5. SCRIBE CENTERLINES 005 TO 008 WIDE AND DEEP ON EACH NOTED STEEL STAMP, ON ONE LOT, ADDED MARKS AT EACH END OF CENTERLINES 1/32 X 1/32 X 1/8 LONG
6. MADE FROM STEEL ANNEALED CONDITION HEAT TREAT AFTER MACHINING IN ACCORDANCE WITH SASTM GRADE SHOT LOL NO OVER, ADDED NOTES

7-1-8-CS-3-WAB

SOUTHWEST RESEARCH INSTITUTE

ASTM STYLE UT
CALIBRATION BLOCK

D-5120 032


10.5-7-8-CS-3-WAB
DETAIL C
SCALE 2/1
SECTION A-A
SCALE 2/1
SECTION B-B
SCALE 2/1
10.5-7-8-CS-4-WAB
NOTES:
REV INT ULTRASONIC
CALIBRATION BLOCK
C D-5420 033

WBNP
TI-50A
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