TENNESSEE VALLEY AUTHORITY	EXAMINATION SUMMARY AND RESOLUTION SHEET	REPORT NUMBER: R-P0588

PROJECT: *WBN* UNIT: *2* CYCLE *00*		COMPONENT ID: SIF-B-T095-01	
EXAMINATION METHOD		SYSTEM: SIS	ISI DWG NO: *ISI-2063-W-12R-2*
MT ☐ PT ☐ UT ☑ VT ☐		CONFIGURATION:	CATEGORY
PROCEDURE: *N-UT-* 84	REV ~~8~~ 0 TC: N/A	PIPE TO BRANCH CONN.	*B-J*
EXAMINER: PATRICK MAHONEY	EXAMINER: JASON POLISENSKY	EXAMINER: N/A	EXAMINER: N/A
LEVEL: II	LEVEL: II	LEVEL:	LEVEL:

Total coverage calculated to be approximately 50 %

A SINGLE SIDED PHASED ARRAY ULTRASONIC EXAMINATION WAS PERFORMED TO MEET THE REQUIREMENTS OF ASME SECTION XI PRESERVICE INSPECTION.

A PHASED ARRAY 8 ELEMENT, 2 MHZ, PROBE WITH A 35°-80° (AXIAL) & 35°-70° (CIRC) SHEAR WAVE WAS USED TO PERFORM THE ULTRASONIC EXAMINATION. THE INSTURMENT WAS SET IN SECTOR SCAN DISPLAY MODE.

SCAN LIMITATION DUE TO BRANCH CONNECTION CONFIGURATION

NO RECORDABLE INDICATIONS

RESOLUTION BY:	REVIEWED BY:	ANII:
Patrick Mahoney	[signature]	DATE: 7/10/09
LEVEL II DATE: 6/29/09	LEVEL: III DATE: 6-30-09	Page: 1 OF 5

ACCESS: FORMS DATABASE R-10/04/01

TENNESSEE VALLEY AUTHORITY	PHASED ARRAY ULTRASONIC CALIBRATION DATA SHEET	REPORT NUMBER: R-P0588

PROJECT: WBN UNIT 2 CYCLE: 0	CALIBRATION DATE: 06/29/09
PROC.: N-UT-84 REV: 0 TC: N/A	CALIBRATION BLOCK NO.: WB-20 TEMP: 72.5°F
INSTR. MFG: GE IT DUE DATE: 12/19/09	SIMULATOR BLOCK NO: N/A
MODEL/TYPE: PHASOR XS M & TE ID: E41379	THERMOMTER S/N: E39053 DUE DATE: 08/12/09
SOFTWARE REVISION: 1.20	COUPLANT ULTRAGEL II BATCH: 06225F
EXAM TYPE: SHEAR ☒ LONG ☐ RL ☐	EXAM: ISI ☐ PSI ☒ LIMITATIONS: Y ☒ N ☐
CABLE TYPE: 1D LENGTH: 2M #CNT: Ø	

ANGLE VERIFICATION

BLOCK TYPE: Rom PAS	S/N: 790390		NOMINAL ANGLE		ACTUAL ANGLE	
REFLECTOR			LOW: 35	HIGH: 80	LOW: 35	HIGH: 80
SCAN DIRECTION	NOTCH DEPTH	SDH. DEPTH	REF. SENS/AMPL		ANGLE / METAL PATH	EXAM SENS.
AXIAL	.343	N/A	10.0 / 80%		40 / .444	14.0
CIRCUMFERENTAIL	.343		10.0 / 80%		40 / .443	14.0

INSTRUMENT SETTINGS

GAIN TOGGLE:	dBD: 0.0	dBA: 14.0

PROBE DATA		SCAN DATA	
		ELECTRONIC	SCAN PATTERN
PROBE MFG: GE IT	MODEL: 115-500-012	TYPE: SECTOR	ANGLE START: 35
S/N: 01TL8P	APERTURE SIZE: .315	FOCAL POINT: UNFOCUSED	ANGLE STOP: 80
ELEMENTS: 8	PITCH: .040	WAVE TYPE: SHEAR	ANGLE STEP: 1.0
FREQ: 2.0	ELEVATION: .354	RL FOCAL LAW: N/A	
CONFIGURATION: ARRAY	SHAPE: RECT	LEG: 1.0	MATERIAL THICKNESS: .350

WEDGE DATA		APERTURE	
PROBE CHECK: ☒ PRE-EXAM ☒ POST EXAM			
WEDGE MFG: GE IT	VELOCITY: .0920	NUMBER OF STEPS: 1	FIRST ELEMENT: 1
MODEL: 360-141-160	X OFFSET: .413	APERTURE SIZE: 8	APERTURE STEP: 1
WEDGE ANGLE: 38°	Z OFFSET: .413	DISPLAY DATA	ANGLE CORRECTION ☒ ON ☐ OFF
CONTOUR: FLAT	ELEMENT 1 POSITION: LOW		

PART DATA		UT DATA			
		BASE	PULSER	RECIEVER	NRM/TCG
MATERIAL: STEEL STNLSS	VELOCITY: .1220	DELAY: 0.0	VOLT: 150	FREQ: BB 0.6-6.5	CYC GAIN CNTL 0.0
CALIBRATION TIMES			WIDTH: 250	ASCAN RECT: FULLWAVE	
INITIAL TIME: 0830	FINAL TIME: 0950	MATERIAL: STEEL STNLSS	PRF VALUE: AH		
VERF. TIMES N/A N/A N/A N/A					

LINEARITY CHECK

VERTICAL											
SIGNAL 1	100	90	80	70	60	50	40	30	20	10	
SIGNAL 2	50	45	40	35	30	25	20	15	10	5	

ATTENUATOR								
GAIN	SET	-6 dB	-12 dB	SET	+12	SET	+6
AMP	80	32-48	16-24	20	64-96	40	64-96
		40	20		80		80

COMMENTS:	WELDS/ITEMS EXAMINED:
	SIF-B-T095-01
	SIF-B-T097-13

EXAMINER: PATRICK MAHONEY	EXAMINER: JASON POLISENSKY	REVIEWER:	ANII:
LEVEL: II	LEVEL: II	LEVEL: III DATE: 6-30-09	DATE: 7/10/09
			PG. 2 OF 5

TENNESSEE VALLEY AUTHORITY	MANUAL ULTRASONIC PIPING EXAMINATION DATA SHEET	REPORT NUMBER R-P0588

PROJECT: WBN UNIT/CYCLE 2/00
SYSTEM: SIS (063)
WELD I.D.: SIF-B-T095-01
CONFIG.: PIPE TO B/C
FLOW

PROCEDURE: N-UT-84 REV: Ø TC: N/A
Wo REFERENCE: ℄ of Weld
Lo REFERENCE: TDC

EXAMINATION DATE 06/29/09
START TIME: 0925 ✓ END TIME: 0945 ✓
EXAM SURFACE ☐ ID ☒ OD
MATERIAL TYPE: ☐ CS ☒ SS ☐ CSCL ☐ CCSS
SURFACE TEMP.: 77.9 ✓ PYRO NO. E39053 ✓

EXAMINATION ANGLE	35°-80° DEG.	35°-70° DEG.
AXIAL SCAN SENSITIVITY	14 dB	— dB
CIRC. SCAN SENSITIVITY	— dB	14 dB

IND NO.	L (in) FROM REF.			AT MAX AMP			MAX AMP % DAC	EXAM NO. 3-14	NOM. ANG.	NRI	INDICATION INFORMATION: TYPE, DAMPING, ETC.
	L1	L Max	L2	W MAX	MP MAX	D MAX					
								3	35-80	☒	
								4	N/A	☐	NO SCAN DUE TO BRANCH
								5	35-70	☒	
								6	35-70	☒	
										☐	
										☐	

REMARKS/LIMITATIONS NO RECORDABLE INDICATIONS
SINGLE SIDED EXAMINATION (NO SCAN 4)

MAINTAINED A 5% - 20% ID ROLL DURING EXAMINATION

EXAMINER: PMahoney LEVEL: II
EXAMINER: JASON POLSONSKI LEVEL: II
REVIEWED BY: LEVEL: III DATE: 6 30 09

ANII: ✓
DATE: 7/10/09
PAGE 3 OF 5

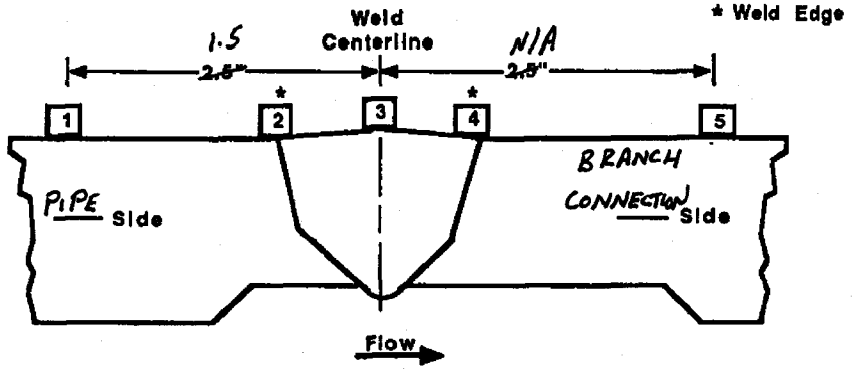
ACCESS: FORMS DATABASE 10/18/01

TVA	WALL THICKNESS PROFILE SHEET	REPORT NO: R-P0588

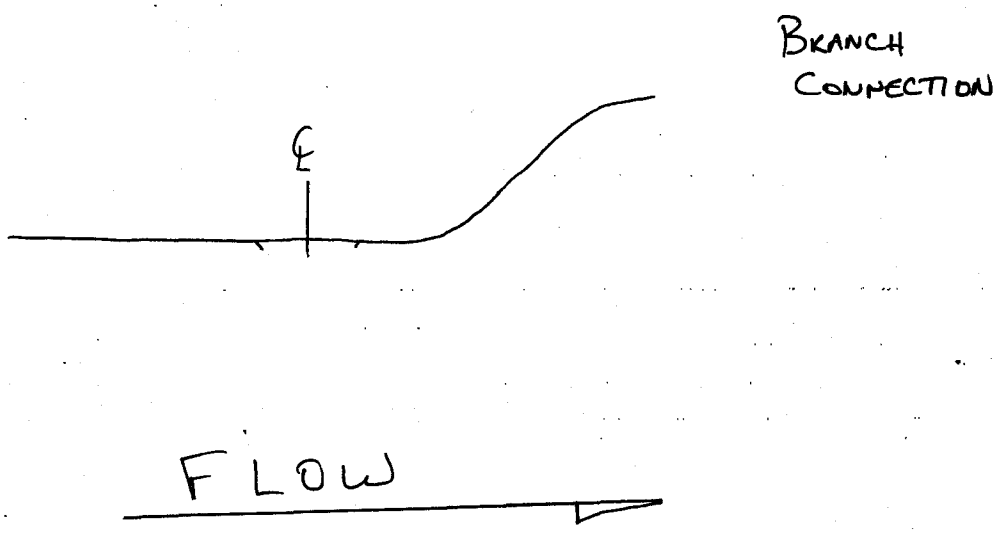
PROJECT: WBN
UNIT: 2
WELD NO: SIF-B-T095-01
SYSTEM: SI

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

Position	0°	90°	180°	270°
1	.31			
2	.31			
3	.36			
4	.33			
5	N/A			



CROWN HEIGHT: FLUSH
CROWN WIDTH: .50"
DIAMETER: 1.5"
WELD LENGTH: 6"



EXAMINER: JASON POLISENSKY
LEVEL: II
DATE: 06/29/09

REVIEWED BY:
LEVEL: III
DATE: 6-30-09

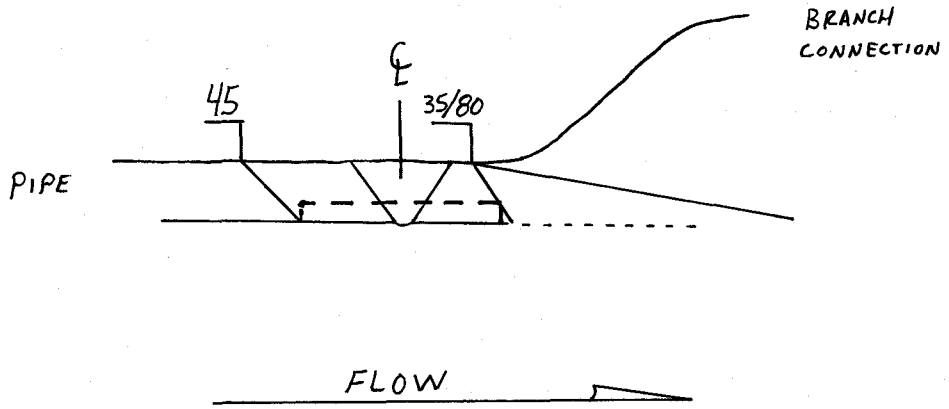
ANII:
DATE: 7/10/09

PAGE 4 OF 5

TVA 19668 (NP-5-89)

1-108-999-44

TVA Office of Nuclear Power	PROJECT: WBN SYSTEM: SI UNIT: 2 WELD NO: SIF-B-T095-01	REPORT NO.: R-P0588



EXAMINATION PERFORMED TO QUALIFIED SECTOR SCAN ANGLES 35°-80° Ax & 35-70 Circ.

BY: JASON POLISENSKY LEVEL: II DATE: 06/29/09 PAGE 5 OF 5

R.P0588

TVA Procedure
N-GP-31

Weld # SIF-B-T095-01

Attachment 3

Item 1	Required examination Volume in sq. in. **(width x height)**	1	0.1	0.1	sq. in.
Item 2	Number of **scan directions**			4	directions
Item 3	Total Scan **volume** in sq. in.			0.4	sq. in.
Item 4	Total **length** of weld			6	inches
Item 5	Total required **exam volume** in cubic inches			2.4	cu. in.
Item 6	**Exam volume achieved** (sq. in.) in direction 1 X **length of weld achieved**	0.1	6	0.6	cu. In.
Item 7	**Exam volume achieved** (sq. in.) in direction 2 X **length of weld achieved**	0.1		0	cu. In.
Item 8	**Exam volume achieved** (sq. in.) in direction 3 X **length of weld achieved**	0.05	6	0.3	cu. In.
Item 9	**Exam volume achieved** (sq. in.) in direction 4 X **length of weld achieved**	0.05	6	0.3	cu. In.
Item 10	Determined the **achivied exam volume** add 6, 7, 8 & 9			1.2	cu. In.
Item 11	Exam **volume percentage** item 10/item 5 x 100			50	%

Scans 3 & 4 (Circ Scan directions 5 & 6) were restricted to pipe side of weld.
This was a single sided examination

Patrick Mahoney Level: II Date: 6/29/09

INFORMATION ONLY