

ATTACHMENT 3
DOSE ESTIMATES

Pen	Ind	Character/Loc.	Repair steps	Time	Dose mRem	Repair Comments
64	1	12:00 J-Weld 3/32" x 1/4" Linear Rejectable	Mark indication	6	420	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	20	1400	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			Enter/Exit All Jumps	94	6819	
			QC inspection @ 5X PT of area	20	1400	
64	2	12:00 J-Weld 1/16" x 1/16" Rounded Acceptable	Mark indication	0	0	Repaired incidently with #1
			Light Grinding	0	0	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
64	3	11:00 1/16" x 1/2" Linear Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
64	4	3:00 1/4" x 1/4" Rounded Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	22	1540	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
64	5	3:00 1/8" x 1/8" Rounded Acceptable	Mark indication	0	0	Possibly will be Repaired incidently with #1
			Light Grinding	0	0	
			Welding Supv Perform Visual	0	0	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
64	6	2:00 1/8" x 1/2" Linear Rejectable	Mark indication	10	700	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	

Pen	Ind	Character/Loc.	Repair steps	Time	Dose mRem	Repair Comments
64	7	2:00 0 Rounded Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
64	8	5:00 1/16" x 3/16" Linear Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
64	9	6:00 1/16" x 3/16" Linear Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	10	700	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
31	1	11:00 1/8" x 3/8" Linear Rejectable	Mark indication	6	420	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	15.5	1085	
31	2	1:00 1/16" x 1" Linear Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
31	3	1:00 1/4" x 1/4" Rounded Rejectable	Mark indication	0	0	Light Grind to reduce to acceptable Weld over if depth required
			Light Grinding	15	1050	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	

Pen	Ind	Character/Loc.	Repair steps	Time	Dose mRem	Repair Comments
31	4	8:00 1/2" x 5/8" Rounded Rejectable	Mark indication	0	0	Local Excavate to reduce to acceptable Weld over if depth required
			Light Grinding	22	1540	
			Welding Supv Perform Visual	2	140	
			Remark Penetration and Clean	3	210	
			QC inspection @ 5X PT of area	1	70	
			Total	REM	28..554	

Assumptions:

- Only covers penetration 64 and 31
- Both options include grinding on 64-4 and 31-4 (pen-Indication)
- Both options include weld repair (overlay) on all indications in 64 and 31
- No extra time for chasing indications after grinding

Actuals for dose used:

- Dose at head 70 mrem/min
- Dose in and out 36 mrem/min
- Dose on turnovers .1 mrem/min

Conclusions:

- Relief request will yield a 7 REM savings for pen 64 and 31 MINIMUM
- Additional saving should be less for the remaining penetrations since we expect less indication repair.
- Overall savings of approx 35% in dose.