TVA

WALL THICKNESS PROFILE SHEET

REPORT NO: R.P0383

PROJECT: WATTS BAR NUCLEAR

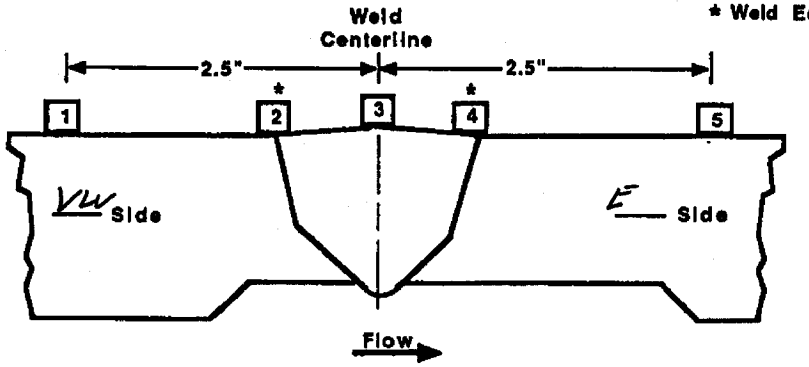
UNIT: 2

WELD NO: SIF-D199-11

SYSTEM: SIS

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

Position	0°	90°	180°	270°
1	N/A	N/A	N/A	N/A
2	1.419	1.319	1.296	1.438
3	1.343	1.546	1.210	1.416
4	1.024	1.013	1.123	1.107
5	1.200	1.181	1.335	1.167

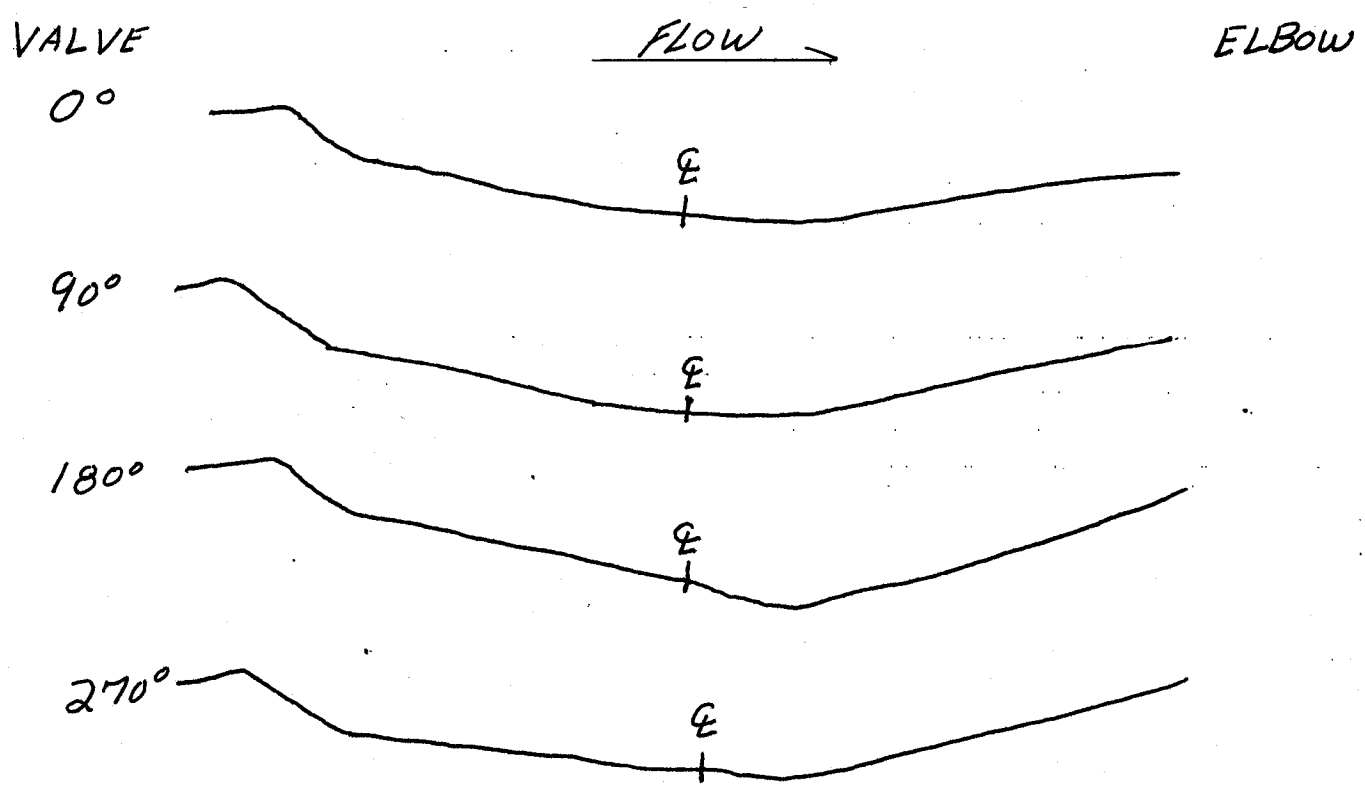


CROWN HEIGHT: FLUSH

CROWN WIDTH: 1.250

DIAMETER: 10.0

WELD LENGTH: 35.250



EXAMINER: [signature] II

LEVEL:

DATE: 05-21-09

REVIEWED BY: [signature]

LEVEL: III DATE: 5/29/09

ANII: [signature] 6/10/09

DATE: 6/10/09

PAGE 5 OF 6

TVA 19668 (NP-5-89)

1-108-999-44

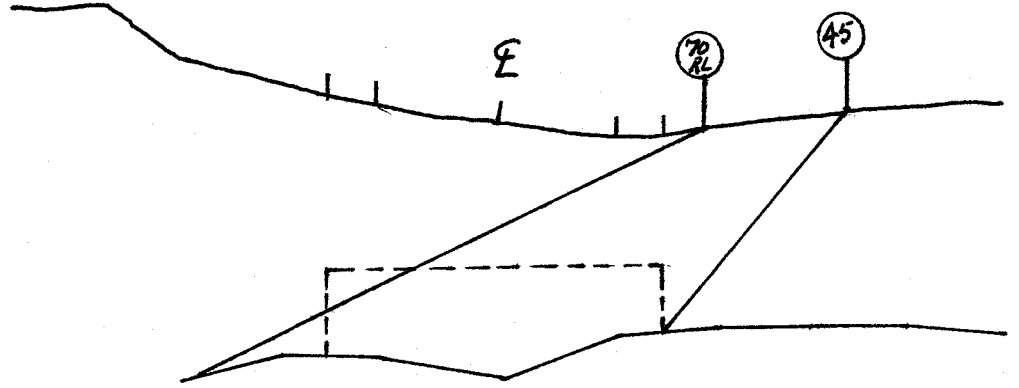
TVA Office of Nuclear Power	PROJECT: WATTS BAR NUCLEAR SYSTEM: SIS UNIT: 2 WELD NO: SIF-D199-11	REPORT NO.: R.P0383

FLOW →

VALVE

0°

ELBOW



Plot shown represents primary angle of 45°; phased array angles used 25°-70°, RL angles used 40°-70°

BY: Jose Alejandro LEVEL: II DATE: 05-21-09 PAGE 6 OF 6

R. P0383

TVA Procedure
N-GP-31

Weld # SIF-D199-11

Attachment 3

Item 1	Required examination Volume in sq. in. **(width x height)**	1.75	0.45		0.7875
Item 2	Number of **scan directions**				4
Item 3	Total Scan **volume** in sq. in.				3.15
Item 4	Total **length** of weld				35.25
Item 5	Total required **exam volume** in cubic inches				111.0375
Item 6	**Exam volume achieved** (sq. in.) in direction 1 X **length of weld achieved**	0	35.25		0
Item 7	**Exam volume achieved** (sq. in.) in direction 2 X **length of weld achieved**	0.73125	35.25		25.77656
Item 8	**Exam volume achieved** (sq. in.) in direction 3 X **length of weld achieved**	0.7875	35.25		27.75938
Item 9	**Exam volume achieved** (sq. in.) in direction 4 X **length of weld achieved**	0.7875	35.25		27.75938
Item 10	Determined the **achivied exam volume** add 6, 7, 8 & 9				81.29531
Item 11	Exam **volume percentage** item 10/item 5 x 100				73.21429

one sided due to value
5-27-09
Joan Kim II

INFORMATION ONLY