

**TVA**

**WALL THICKNESS  
PROFILE SHEET**

REPORT NO:

R. P. 434

PROJECT: WATTS BAR NUCLEAR

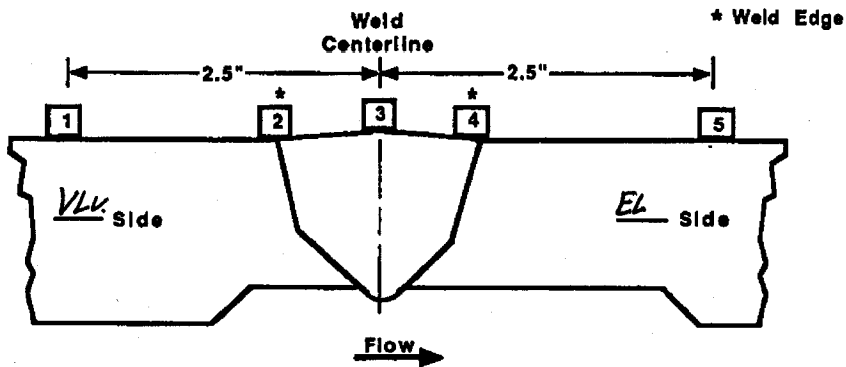
WELD NO: SIF-D199-03

UNIT: 2

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        | 1.412 | 1.335 | 1.201 | 1.454 |
| 3        | 1.379 | 1.150 | 1.126 | 1.140 |
| 4        | 1.092 | 1.137 | 1.004 | 1.100 |
| 5        | 1.453 | 1.261 | 1.227 | 1.267 |



CROWN HEIGHT: FLUSH

DIAMETER: 10.0

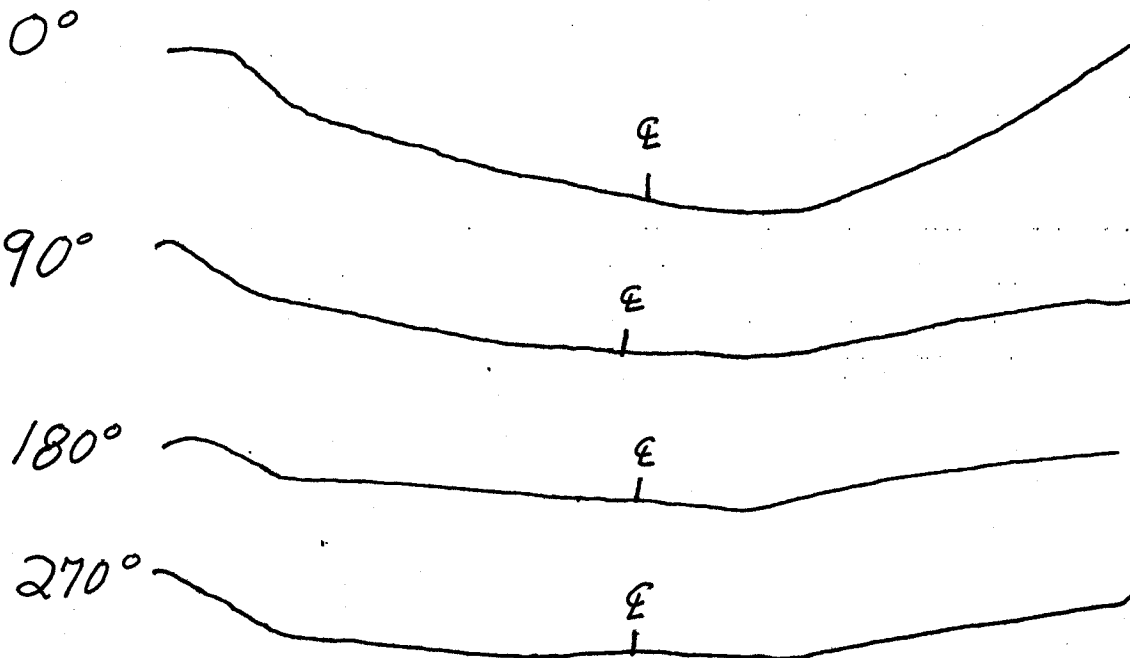
CROWN WIDTH: 1.50

WELD LENGTH: 35.875

VALVE

FLOW →

ELBOW



EXAMINER:

*John ...*

LEVEL:

II

DATE:

06-04-09

REVIEWED BY:

*David ...*

LEVEL:

III

DATE: 6-8-09

ANII:

*JD*

DATE:

6/29/09

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TVA

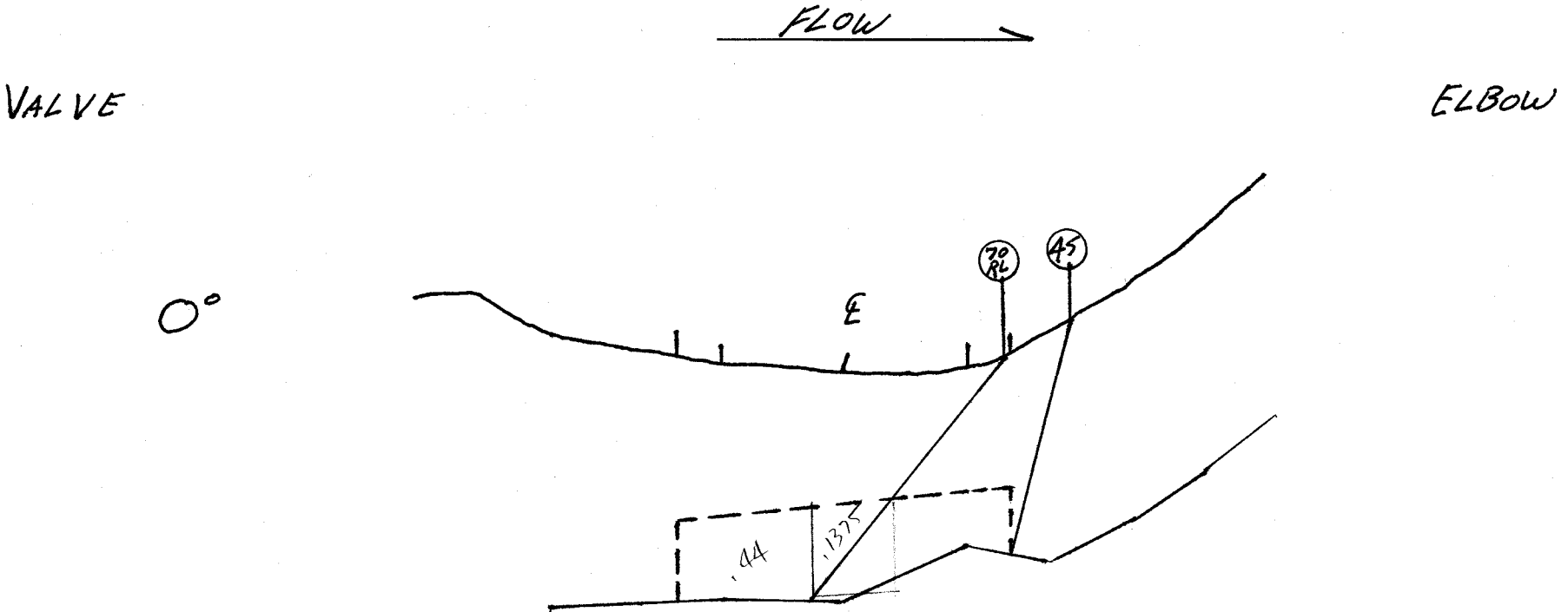
Office of Nuclear Power

PROJECT: WATT'S BAR NUCLEAR SYSTEM: SIS

UNIT: 2 WELD NO: SIF-D199-03

REPORT NO.:

R-P0434



EXAMINATION SCAN 4 LIMITED FROM L1= 30.875 TO L2= 5.0 INCHES, W= 1.0, DUE TO POOR CONTACT AT INTERDOSE OF THE ELBOW AND VALVE CONFIGURATION.

BY: Jose Alejandro [Signature] LEVEL: II DATE: 06-04-09 PAGE 6 OF 7

TVA

Office of Nuclear Power

PROJECT: WATTS BAR NUCLEAR SYSTEM: SIS

UNIT: 2 WELD NO: SIF-D199-03

REPORT NO.:

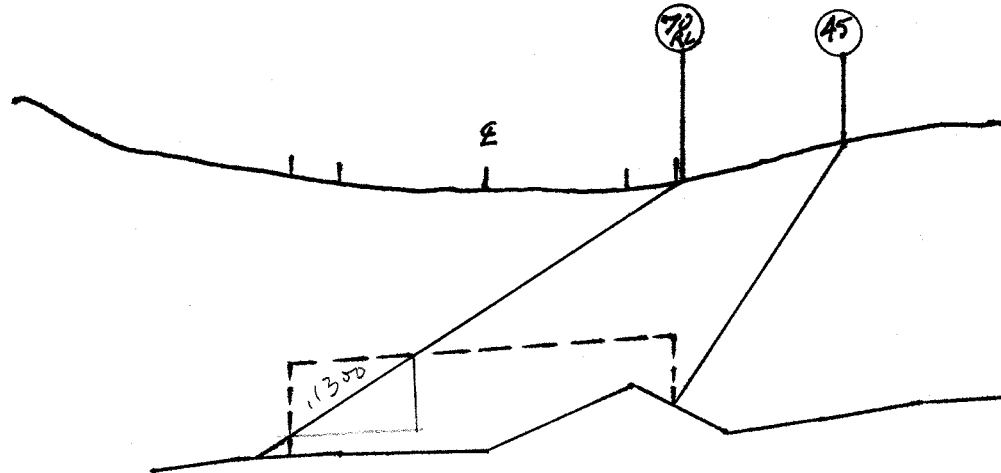
R. D0434

FLOW →

VALVE

ELBOW

90°



EXAMINATION SCAN 4  
 LIMITED DUE TO VALVE  
 CONFIGURATION FROM  
 L1 = 5.0 TO L2 = 30.875  
 INCHES AND W = 1.0 INCHES

TVA Procedure  
N-GP-31

Weld # SIF-D199-03

Attachment 3

|         |   |       |        |          |
|---------|---|-------|--------|----------|
| Item 1  | Required examination Volume in sq. in. (width x height)                 | 2     | 0.5    | 1        |
| Item 2  | Number of scan directions   |       |        | 4        |
| Item 3  | Total Scan volume in sq. in.  |       |        | 4        |
| Item 4  | Total length of weld  |       |        | 35.875   |
| Item 5  | Total required exam volume in cubic inches                              |       |        | 143.5    |
| Item 6  | Exam volume achieved (sq. in.) in direction 1 X length of weld achieved | 1     | 0      | 0        |
| Item 7  | Exam volume achieved (sq. in.) in direction 2 X length of weld achieved | 0.298 | 35.875 | 10.69075 |
| Item 8  | Exam volume achieved (sq. in.) in direction 3 X length of weld achieved | 1     | 35.875 | 35.875   |
| Item 9  | Exam volume achieved (sq. in.) in direction 4 X length of weld achieved | 1     | 35.875 | 35.875   |
| Item 10 | Determined the achieved exam volume add 6, 7, 8 & 9                     |       |        | 82.44075 |
| Item 11 | Exam volume percentage item 10/item 5 x 100                             |       |        | 57.45    |

Limitation:  
One sided examination  
due to valve geometry

JA  
06-08-09

INFORMATION ONLY