

**TVA**

**WALL THICKNESS  
PROFILE SHEET**

REPORT NO:

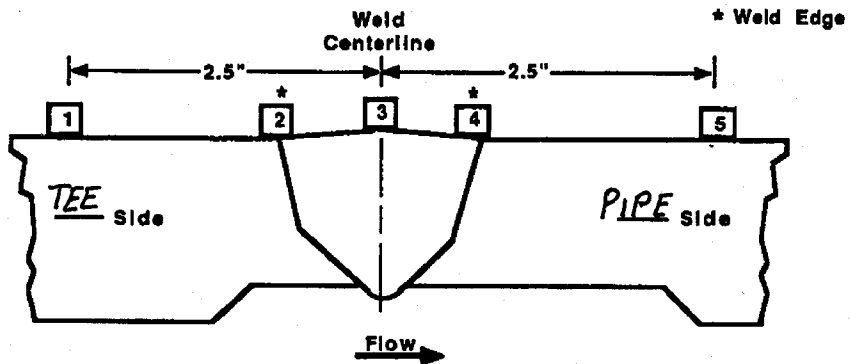
R-PO930

PROJECT: WBN  
UNIT: 2

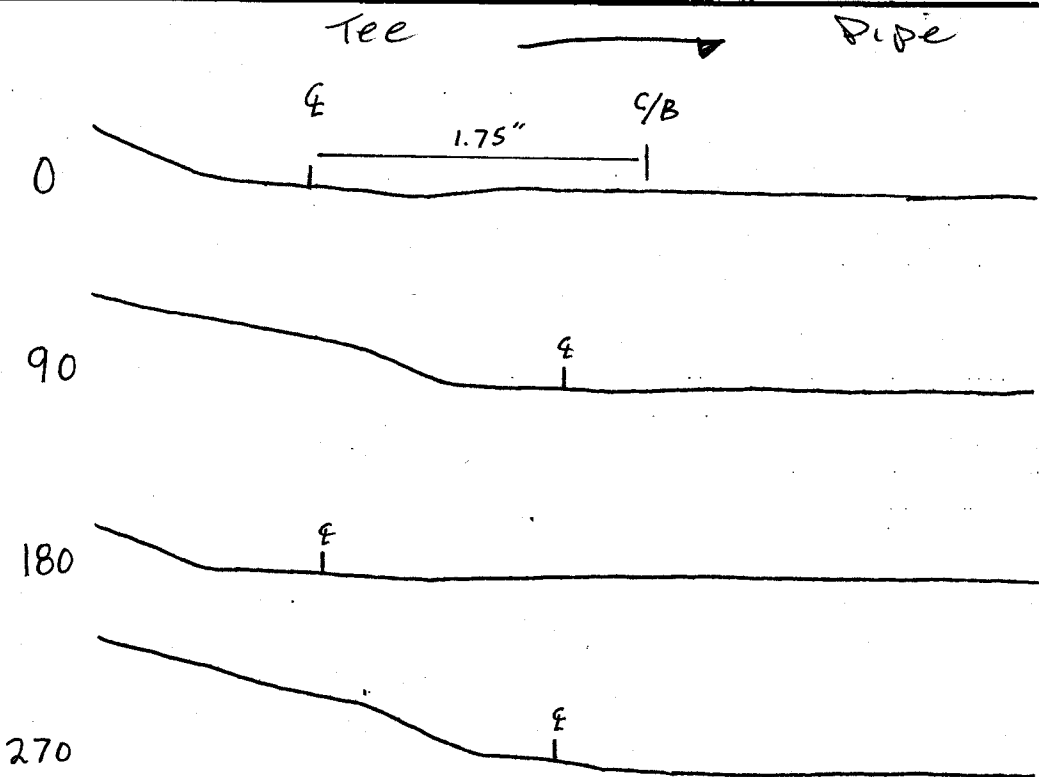
WELD NO: BHRF-D033-01  
SYSTEM: BHB

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

Position	0°	90°	180°	270°
1	N/A	1.37	N/A	1.48
2	.87	1.04	.85	.86
3	.93	.90	.90	.91
4	.82	.82	.82	.82
5	.95	.90	.88	.96



CROWN HEIGHT: FLUSH DIAMETER: 8.0  
CROWN WIDTH: 1.0 WELD LENGTH: 27.5



EXAMINER: Jason Polensky JASON POLSENSKY  
LEVEL: II  
DATE: 09/09/09

REVIEWED BY: [Signature]  
LEVEL: III DATE: 10/1/09

ANII: [Signature]  
DATE: 10/21/09  
PAGE 5 OF 6

TVA

Office of Nuclear Power

PROJECT: WBN SYSTEM: RHR

UNIT: 2 WELD NO: RHRF-D033-01

REPORT NO.:

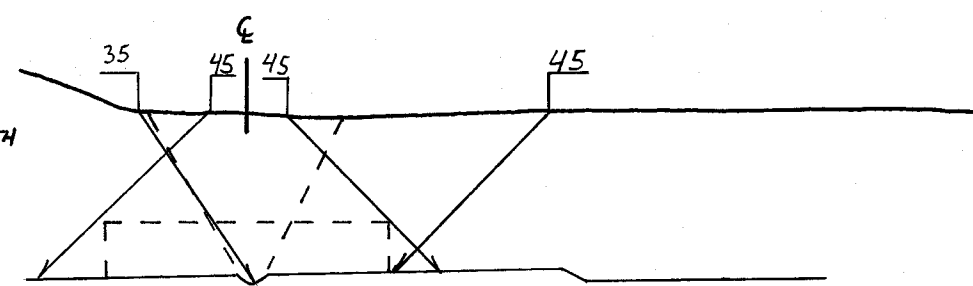
R-P0930

TEE

FLOW

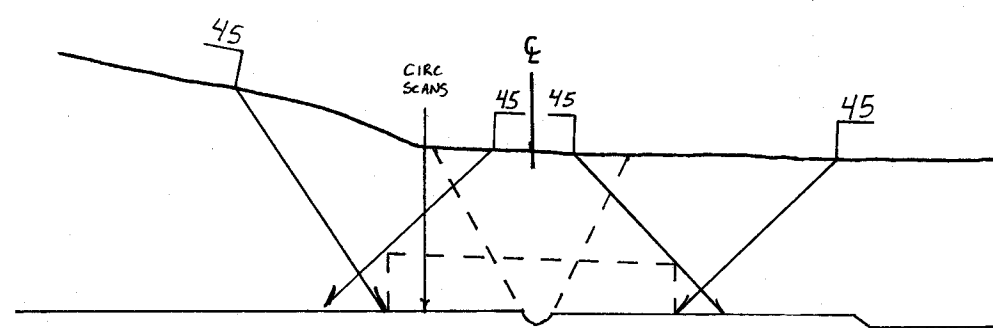
PIPE

SINGLE SIDED ACCESS  
15.5" TOTAL LENGTH



DUE TO CONFIGURATION, SCANS 5&6  
LIMITED ON PIPE SIDE TO WELD TOE  
TEE SIDE.

DUAL SIDED  
ACCESS 12"  
TOTAL LENGTH



EXAMINATION PERFORMED TO QUALIFIED SECTOR SCAN ANGLES OF 35° TO 70° AX AND 25° TO 70° CIRC (SHEAR) 40° TO 70° AX (RL)

BY: Jason Polisenky JASON POLISENSKY LEVEL: II DATE: 09/09/09 PAGE 6 OF 6

# Watts Bar Unit 2

**TVA Procedure N-GP-31  
Attachments 3 & 4**

Measured Fields	Calculated Fields
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Worksheet Version 1.0 dated 07/01/09

**WELD  
NUMBER**

RHRF-D033-01

Item 1	Required examination Volume in sq. in. (width x height)	1.5	0.28	0.42	sq. in.	
Item 2	Number of scan directions			4	directions	
Item 3	Total Scan volume in sq. in.			1.68	sq. in.	
Item 4	Total length of weld			27.5	inches	
Item 5	Total required exam volume in cubic inches			46.2	cu. in.	
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	*	0.3368	27.5	9.262	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	0.42		27.5	11.55	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	0.372		27.5	10.23	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	0.372		27.5	10.23	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9				41.272	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100				<b>89.33</b>	%

Scan 3 limited due to Branch config.  
Single sided access 15.5" of 27.5"

\* value to achieve caculate 9.26 cu.in. total scan volume

**Initials**  
JAP

**Date**  
09/09/2009

**INFORMATION ONLY**