

TVA

**WALL THICKNESS
PROFILE SHEET**

REPORT NO:

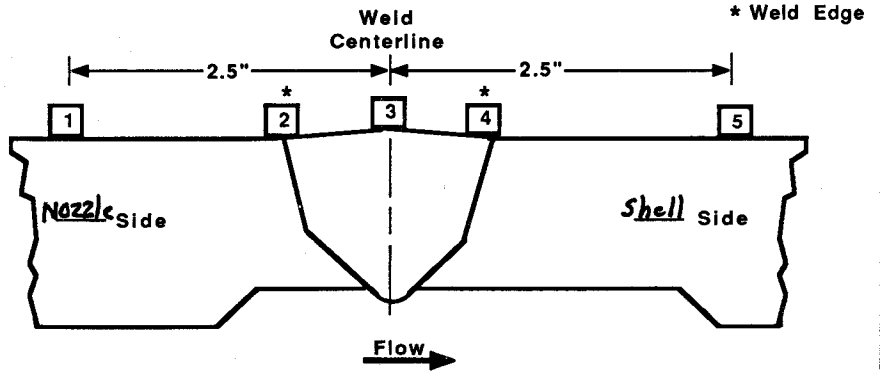
R.P1280

PROJECT: WBN
UNIT: 2

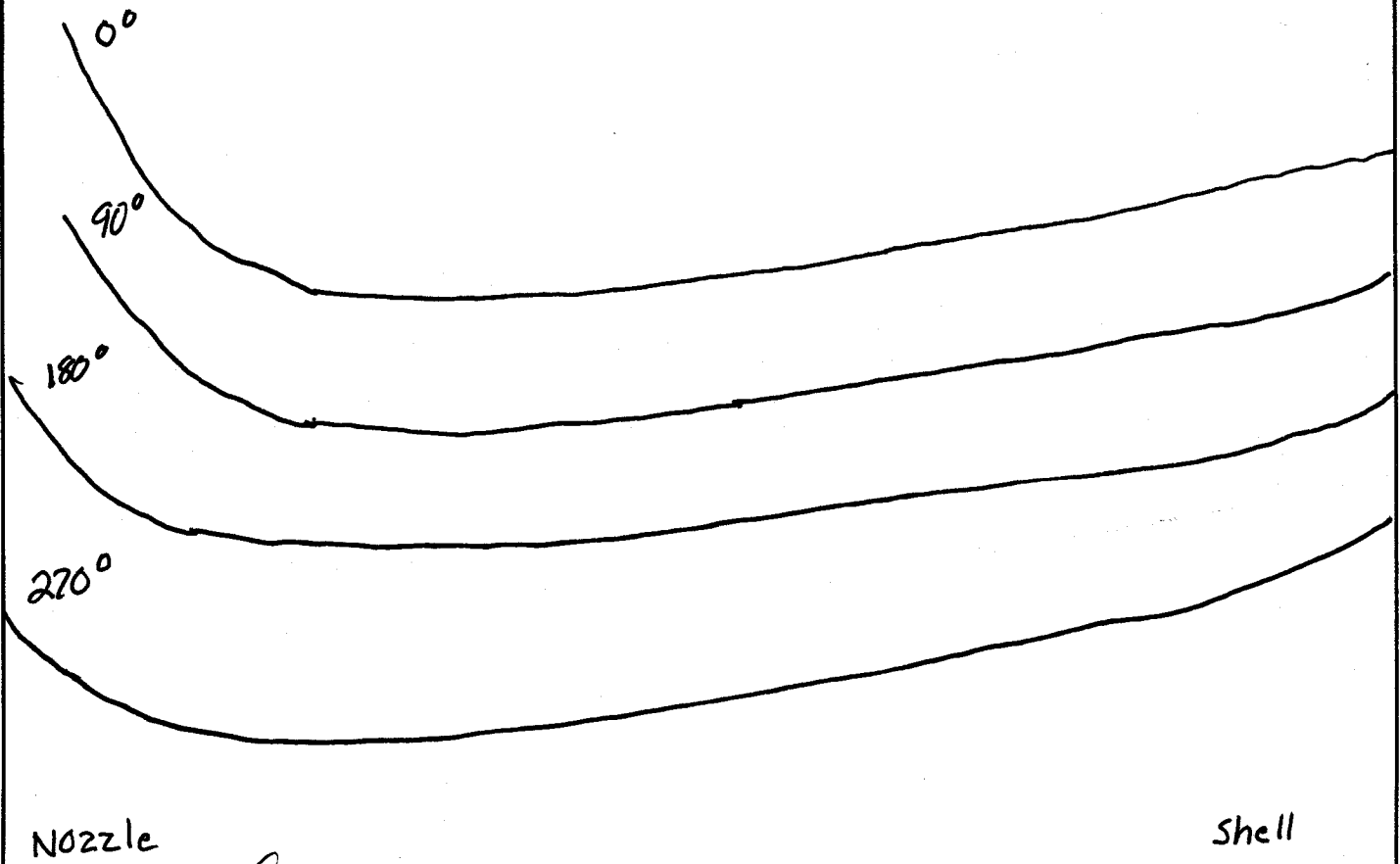
WELD NO: WP-15
SYSTEM: PZR

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	N/A	N/A	N/A	N/A
3	N/A	N/A	N/A	N/A
4	3.24	3.37	3.30	3.23
5	2.92	3.21	3.22	3.08



CROWN HEIGHT: Flush DIAMETER: 6"
CROWN WIDTH: 1.6" WELD LENGTH: 46.7"



EXAMINER: Juan Alejandro
LEVEL: II
DATE: 10-19-10

REVIEWED BY: Darlene Duley
LEVEL: III DATE: 10-27-10

ANII: MM
DATE: 1-5-11
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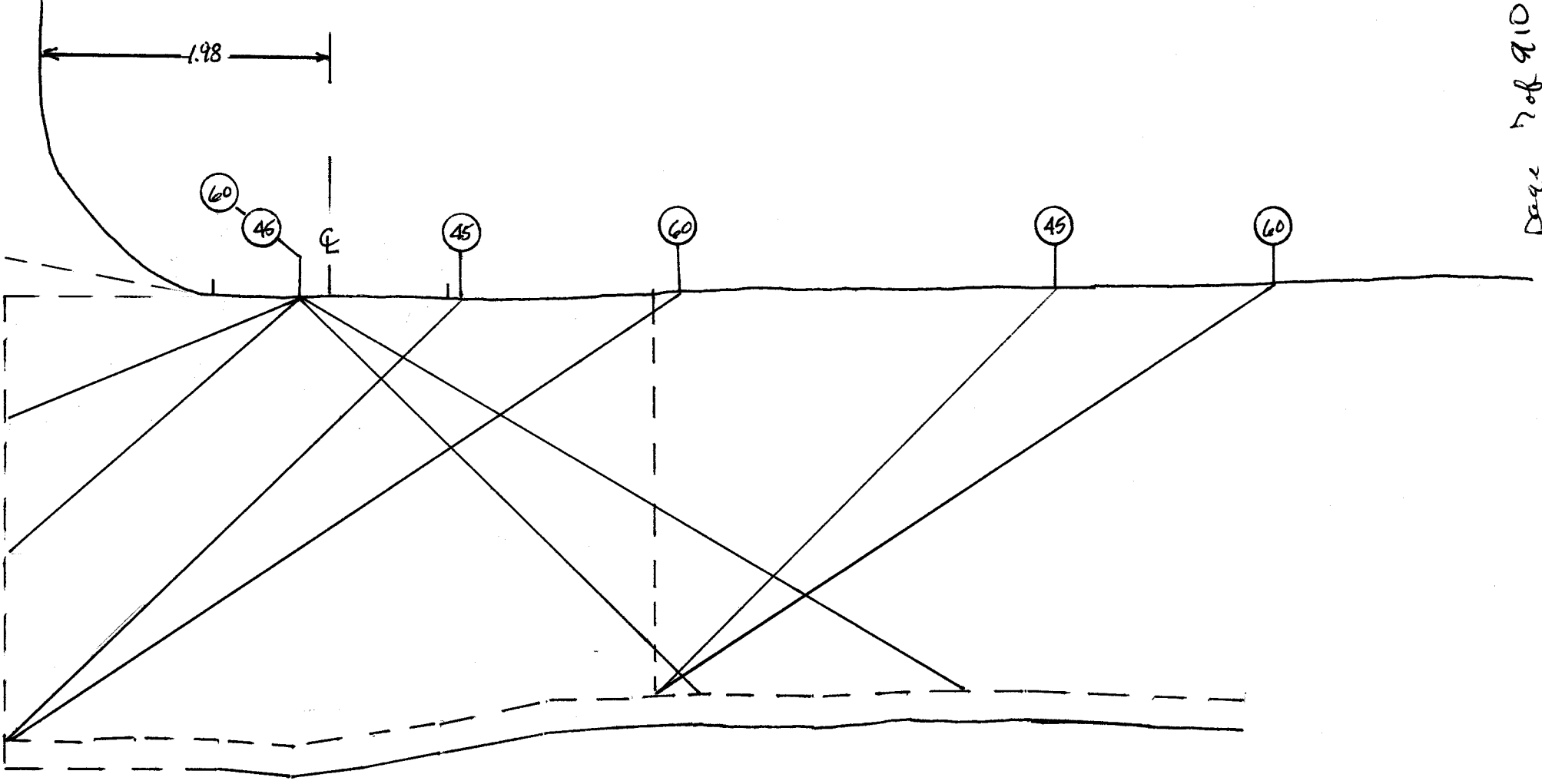
WBN 2

PZR

R.P. 1080

WP-15

SAFETY NOZZLE



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Watts Bar Unit 2

R. P1280

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

WP-15 (45 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.75	12.1	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			48.4	sq. in.
Item 4	Total length of weld			46.7	inches
Item 5	Total required exam volume in cubic inches			2260.28	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	11.5	46.7	537.05	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	3	46.7	140.1	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	6.6	46.7	308.22	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	6.6	46.7	308.22	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1293.59	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			57.23	%

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

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Watts Bar Unit 2

R. P. 1280

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

WP-15 (60 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.75	12.1	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			48.4	sq. in.
Item 4	Total length of weld			46.7	inches
Item 5	Total required exam volume in cubic inches			2260.28	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	11.5	46.7	537.05	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	4.49	46.7	209.683	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	6.6	46.7	308.22	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	6.6	46.7	308.22	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1363.173	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			60.31	%

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

Watts Bar Unit 2

R. P. D80

**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

WP-15 (0 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.75	12.1	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			48.4	sq. in.
Item 4	Total length of weld			46.7	inches
Item 5	Total required exam volume in cubic inches			2260.28	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	8.0025	46.7	373.71675	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1494.867	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			66.14	%

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

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