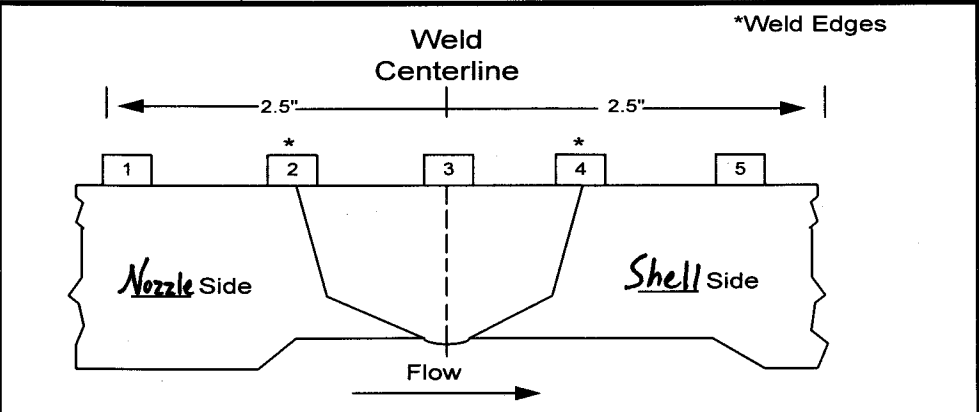


TVA **Wall Thickness Profile Sheet** Report No. R-P1281

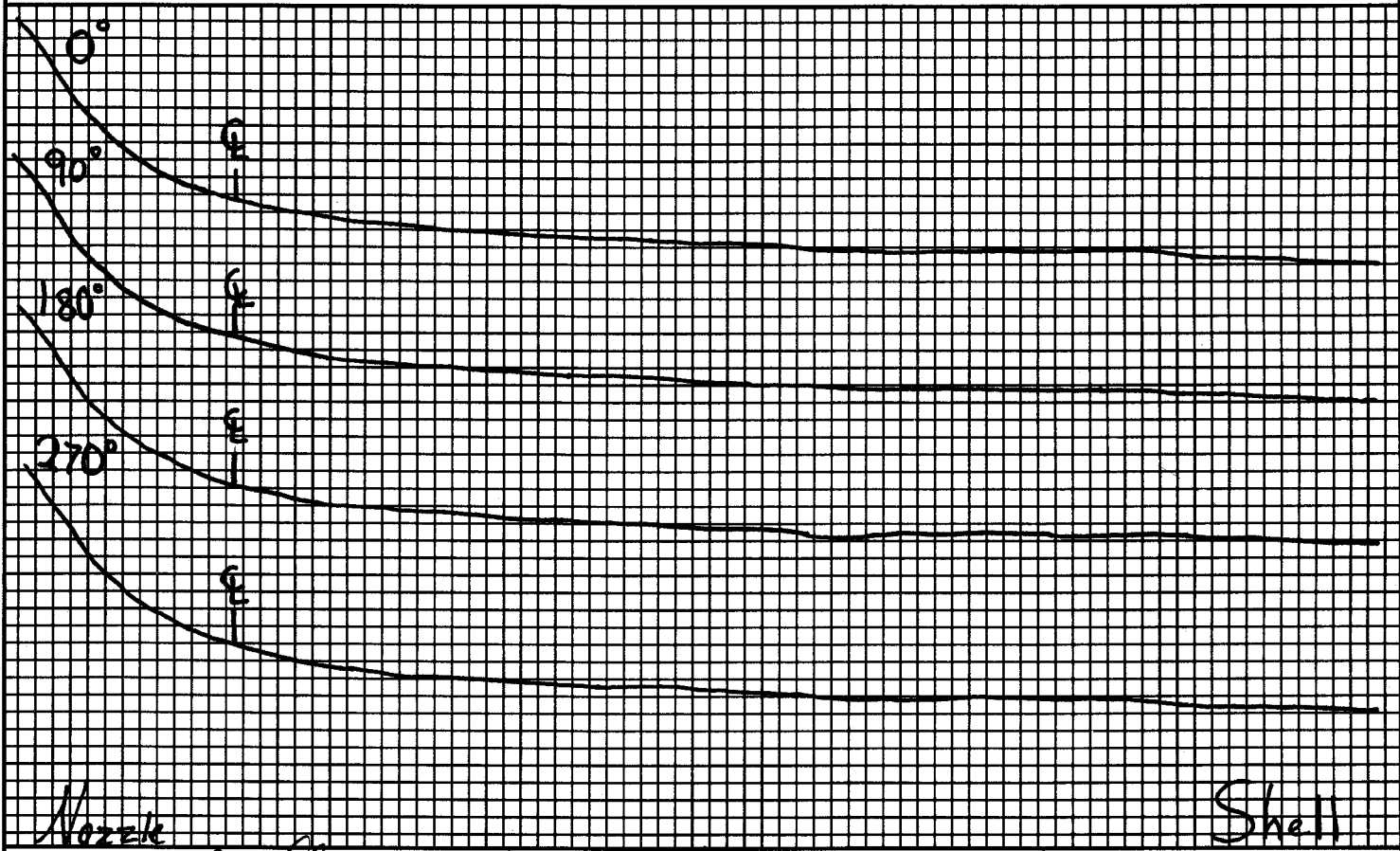
Project: WBN Weld No.: WP-14
 Unit: 2 System: PZR

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	3.34	3.24	3.24	3.34
4	3.21	3.15	3.15	3.27
5	2.92	3.07	3.12	3.09



Crown Height: Flush Diameter: 6"
 Crown Width: 1.6" Weld Length: 46.7"



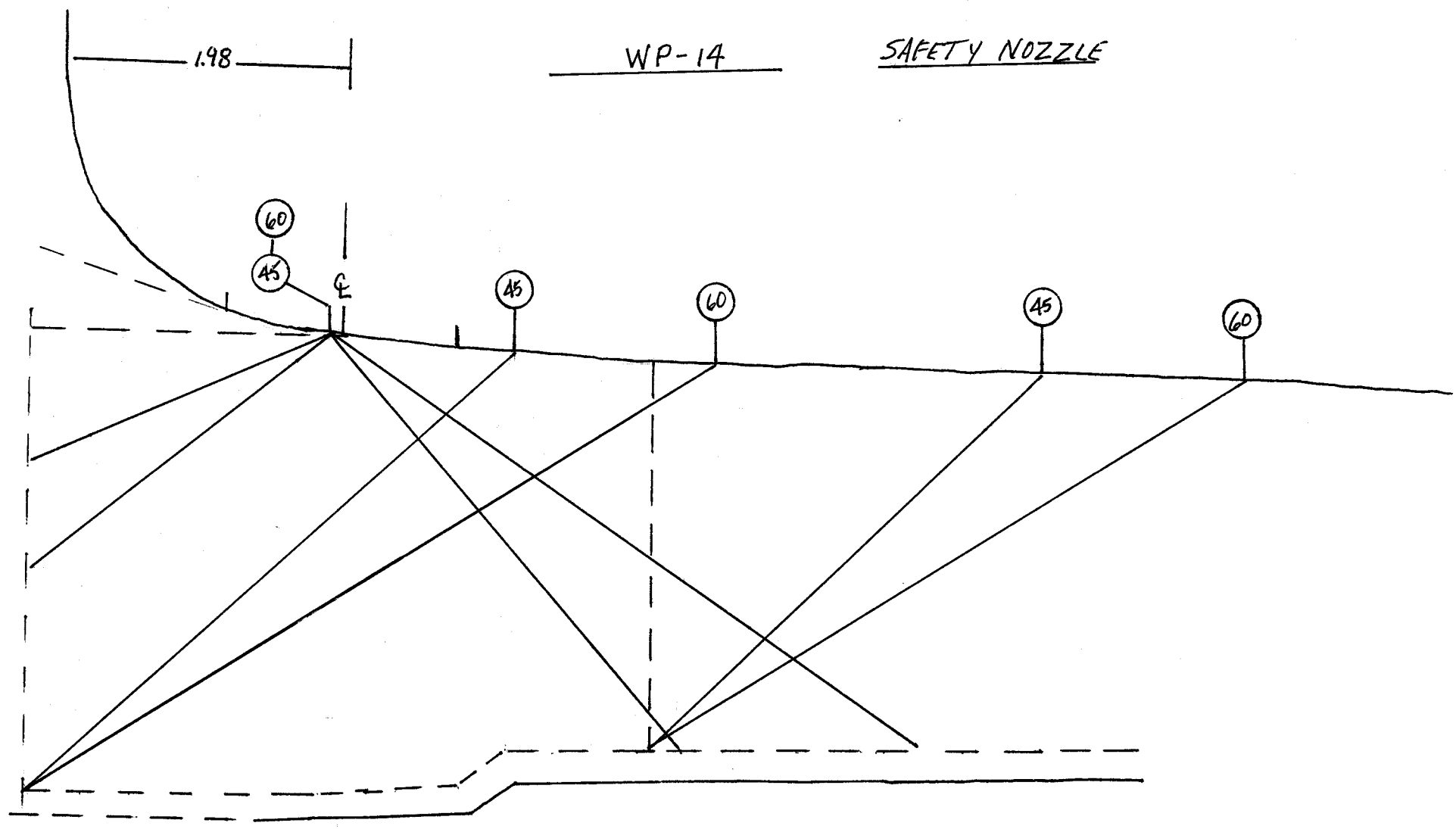
Examiner: Mike DeFuria Reviewed By: Debra Dwyer ANII: none
 Level: II Level: III
 Date: 10-19-10 Date: 10-31-10 Date: 1-6-11

WBN 2

PZR

WP-14

SAFETY NOZZLE



Watts Bar Unit 2

R. D1281

**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-14 (45 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.3	2.7	11.61	sq. in.
Item 2	Number of scan directions	4 directions			
Item 3	Total Scan volume in sq. in.	46.44 sq. in.			
Item 4	Total length of weld	46.7 inches			
Item 5	Total required exam volume in cubic inches	2168.748 cu. in.			
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	9.93	46.7	463.731	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	5.1525	46.7	240.62175	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	6.075	46.7	283.7025	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	6.075	46.7	283.7025	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9	1271.7578 cu. In.			
Item 11	Exam volume percentage item 10/item 5 x 100	58.64 %			

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010

8 of 10

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**

WP-14 (60 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.3	2.7	11.61	sq. in.
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Item 2	Number of scan directions			4	directions
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Item 3	Total Scan volume in sq. in.			46.44	sq. in.
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Item 4	Total length of weld			46.7	inches
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Item 5	Total required exam volume in cubic inches			2168.748	cu. in.
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Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	10.665	46.7	498.0555	cu. In.
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Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	2.53425	46.7	118.34948	cu. In.
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Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	6.075	46.7	283.7025	cu. In.
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Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	6.075	46.7	283.7025	cu. In.
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Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1183.81	cu. In.
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Item 11	Exam volume percentage item 10/item 5 x 100			54.58	%
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Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

R-11281

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

WP-14 (0 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.3	2.7	11.61 sq. in.
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Item 2	Number of scan directions	4 directions		
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Item 3	Total Scan volume in sq. in.	46.44 sq. in.		
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Item 4	Total length of weld	46.7 inches		
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Item 5	Total required exam volume in cubic inches	2168.748 cu. in.		
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Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	7.425	46.7	346.7475 cu. In.
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Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	7.425	46.7	346.7475 cu. In.
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Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	7.425	46.7	346.7475 cu. In.
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Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	7.425	46.7	346.7475 cu. In.
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Item 10	Determined the acheived exam volume add 6, 7, 8 & 9	1386.99 cu. In.		
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Item 11	Exam volume percentage item 10/item 5 x 100	63.95 %		
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Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

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