

TVA

**WALL THICKNESS
PROFILE SHEET**

REPORT NO:

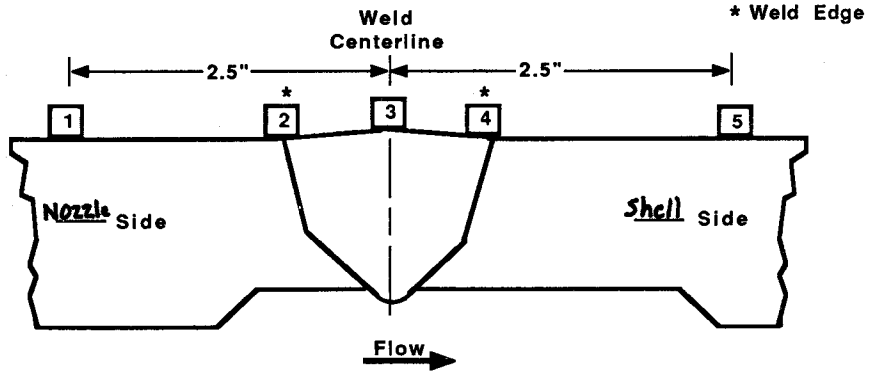
R.P1282

PROJECT: WBN
UNIT: 2

WELD NO: WP-12
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	3.93	3.54	3.29	3.55
4	3.28	3.41	3.19	3.31
5	2.96	3.14	3.31	3.07



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

Relief Nozzle



NOZZLE

Shell

EXAMINER: *Joe Cleary*
LEVEL: II
DATE: 10-19-10

REVIEWED BY: *David D...*
LEVEL: LU DATE: 10-31-10

ANII: *ASL*
DATE: 1-6-11
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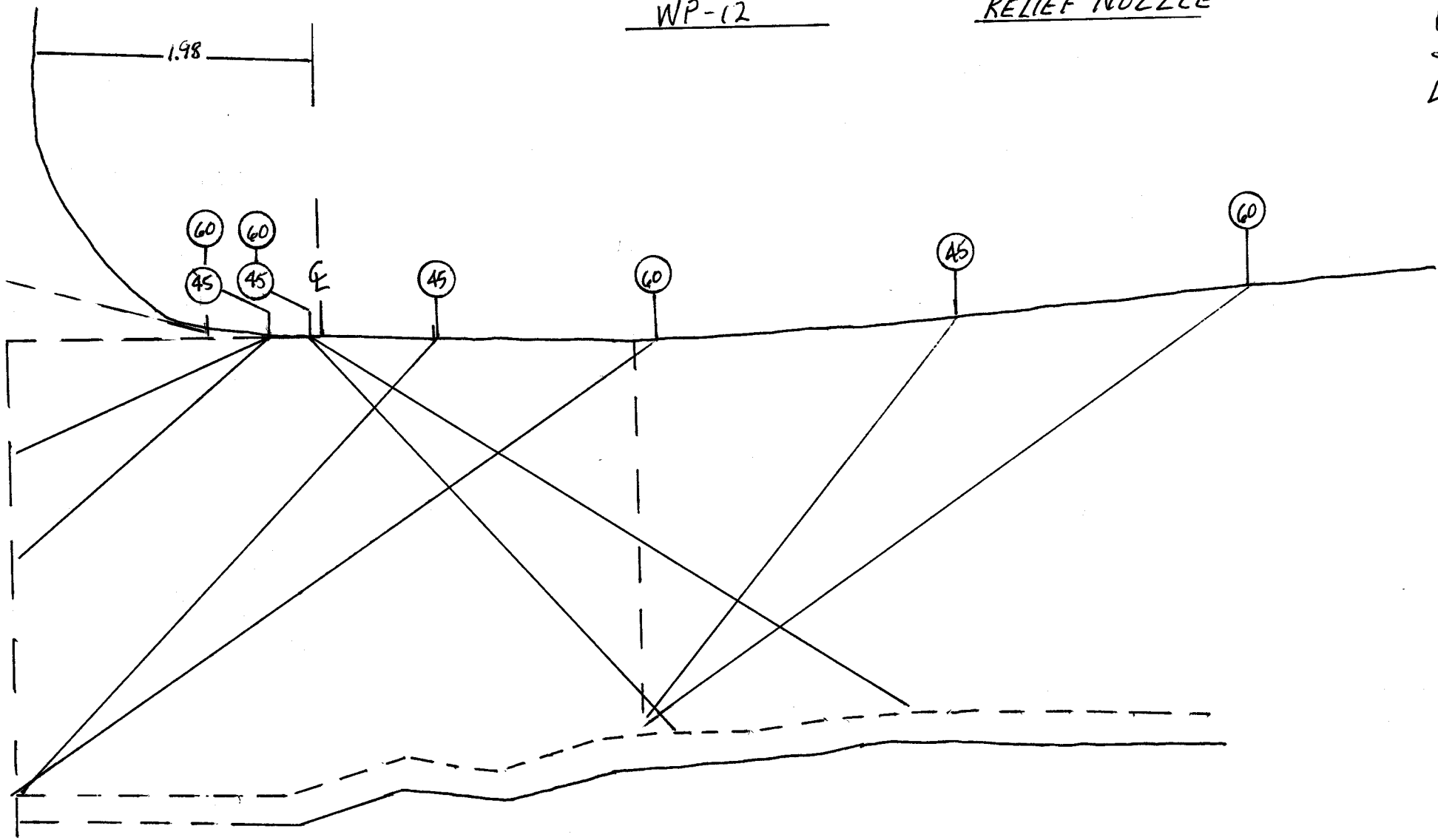
WBN 2

PZR

WP-12

RELIEF NOZZLE

074



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-12 (60 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.8	12.32	sq. in.
Item 2	Number of scan directions	4			directions
Item 3	Total Scan volume in sq. in.	49.28			sq. in.
Item 4	Total length of weld	46.7			inches
Item 5	Total required exam volume in cubic inches	2301.376			cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	11.58	46.7	540.786	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	6.3843	46.7	298.14681	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	5.7625	46.7	269.10875	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	5.7625	46.7	269.10875	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9	1377.1503			cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100	59.84			%

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

R.P1282

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-12 (45 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.8	12.32	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			49.28	sq. in.
Item 4	Total length of weld			46.7	inches
Item 5	Total required exam volume in cubic inches			2301.376	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	10.9325	46.7	510.54775	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	2.645	46.7	123.5215	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	5.7625	46.7	269.10875	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	5.7625	46.7	269.10875	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1172.2868	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			50.94	%

Scan limitation due to Nozzle configuration

Initials
JA
Date
10/25/2010

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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-12 (0 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.4	2.8	12.32	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			49.28	sq. in.
Item 4	Total length of weld			46.7	inches
Item 5	Total required exam volume in cubic inches			2301.376	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	8.12	46.7	379.204	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	8.12	46.7	379.204	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	8.12	46.7	379.204	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	8.12	46.7	379.204	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1516.816	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			65.91	%

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010