

TVA

WALL THICKNESS PROFILE SHEET

REPORT NO:

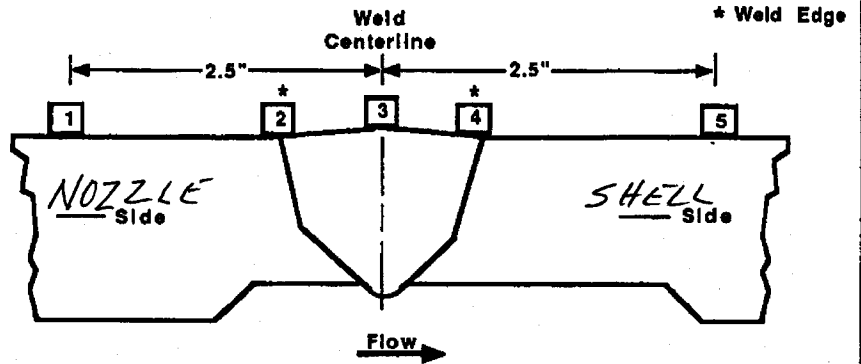
R.1283

PROJECT: WBN
UNIT: 2

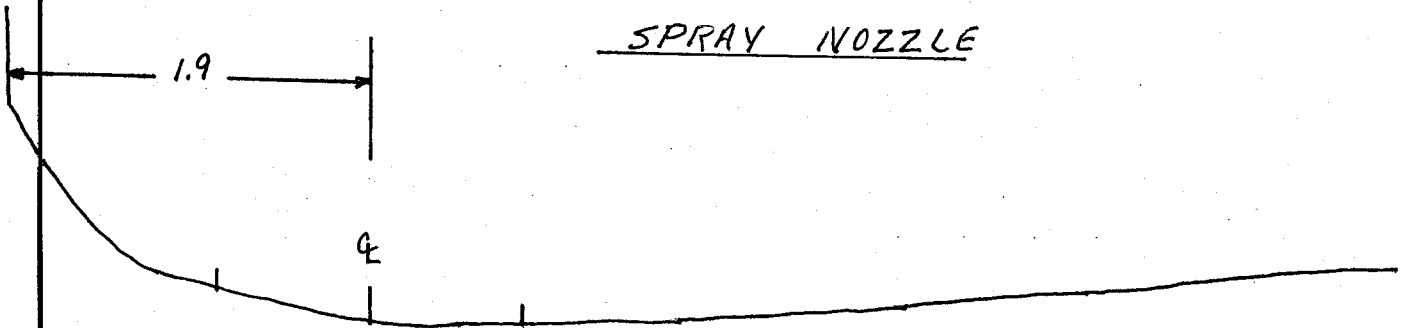
WELD NO: WP-11
SYSTEM: PZR

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

Position	0°	90°	180°	270°
1	*	*	*	*
2	3.61	3.68	3.61	3.68
3	3.11	3.44	3.15	3.02
4	2.97	3.13	3.06	3.07
5	2.79	2.84	2.82	2.82



CROWN HEIGHT: FLUSH DIAMETER: ~~4.0~~ 6.0
CROWN WIDTH: 1.6 WELD LENGTH: 39.8



* No thickness reading taken on nozzle side.

EXAMINER: [Signature]
LEVEL: II
DATE: 10-19-10

REVIEWED BY: [Signature]
LEVEL: III DATE: 10-31-10

ANII: [Signature]
DATE: 1-6-10
PAGE 6 OF 10

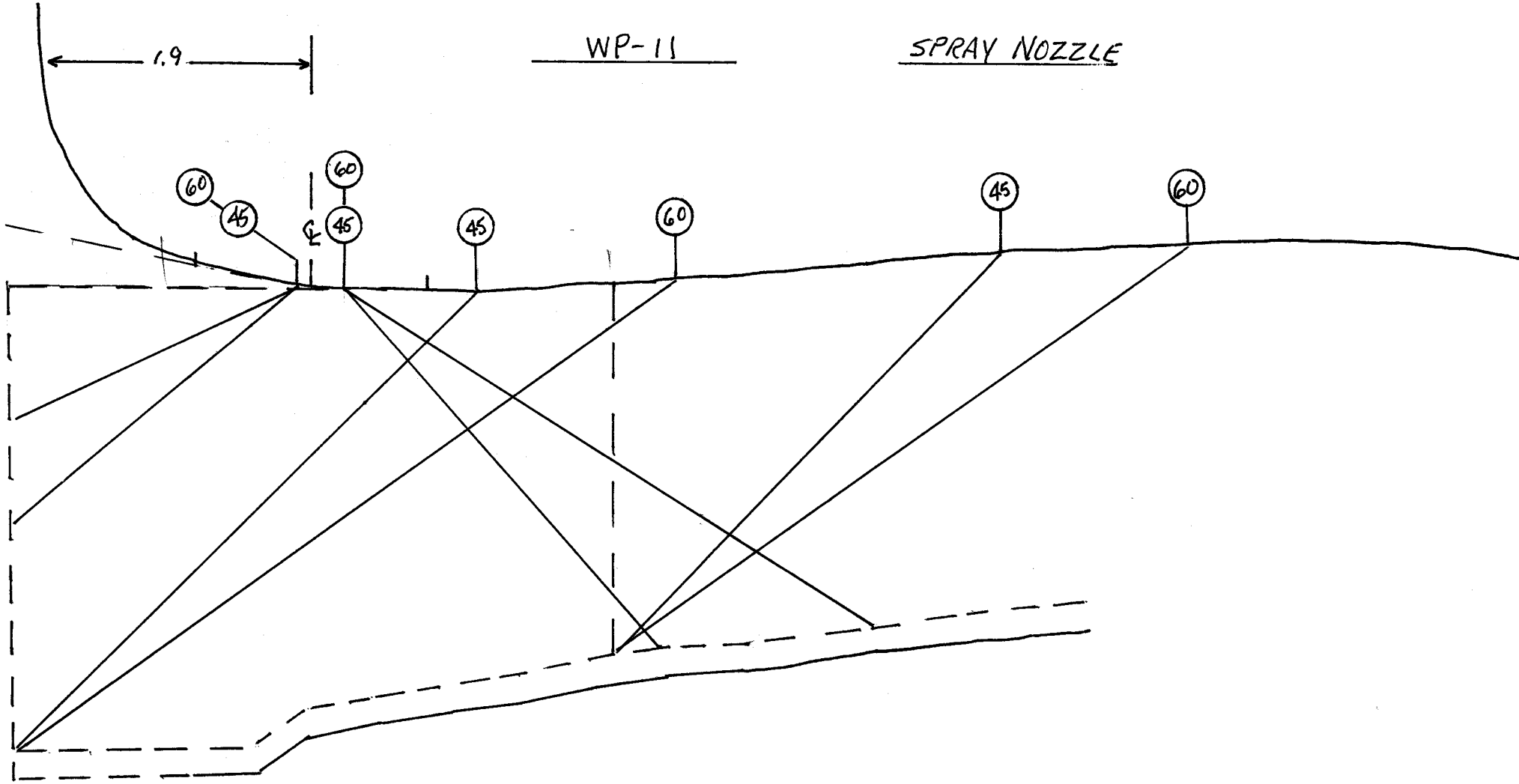
WBN 2

PZR

WP-11

SPRAY NOZZLE

1.9



7410

R.P1283

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-11 (60 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.2	2.6	10.92	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			43.68	sq. in.
Item 4	Total length of weld			39.7	inches
Item 5	Total required exam volume in cubic inches			1734.096	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	10.638	39.7	422.3286	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	8.56125	39.7	339.88163	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	5.72	39.7	227.084	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	5.72	39.7	227.084	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1216.3782	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			70.14	%

Scan limitation due to Nozzle configuration

Initials

JA

Date

10/25/2010

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-11 (45 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.2	2.6	10.92	sq. in.
Item 2	Number of scan directions			4	directions
Item 3	Total Scan volume in sq. in.			43.68	sq. in.
Item 4	Total length of weld			39.7	inches
Item 5	Total required exam volume in cubic inches			1734.096	cu. in.
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	8.62	39.7	342.214	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	8.56125	39.7	339.88163	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	5.72	39.7	227.084	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	5.72	39.7	227.084	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9			1136.2636	cu. In.
Item 11	Exam volume percentage item 10/item 5 x 100			65.52	%

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010

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-11 (0 Deg)

Item 1	Required examination Volume in sq. in. (width x height)	4.2	2.6	10.92	sq. in.
Item 2	Number of scan directions	4 directions			
Item 3	Total Scan volume in sq. in.	43.68 sq. in.			
Item 4	Total length of weld	39.7 inches			
Item 5	Total required exam volume in cubic inches	1734.096 cu. in.			
Item 6	Exam volume acheived (sq. in.) in direction 1 X length of weld achieved	7.8	39.7	309.66	cu. In.
Item 7	Exam volume acheived (sq. in.) in direction 2 X length of weld achieved	7.8	39.7	309.66	cu. In.
Item 8	Exam volume acheived (sq. in.) in direction 3 X length of weld achieved	7.8	39.7	309.66	cu. In.
Item 9	Exam volume acheived (sq. in.) in direction 4 X length of weld achieved	7.8	37.7	294.06	cu. In.
Item 10	Determined the acheived exam volume add 6, 7, 8 & 9	1223.04 cu. In.			
Item 11	Exam volume percentage item 10/item 5 x 100	70.53 %			

Scan limitation due to Nozzle configuration

Initials
JA

Date
10/25/2010