Public Service
Electric and Gas
Company

Steven E. Miltenberger

Vice President and Chief Nuclear Officer

Public Service Electric and Gas Company P.O. Box 236, Hancocks Bridge, NJ 08038 609-339-4199

May 27, 1988
NLR-N88082

United States Nuclear Regulatory Commission
Document Control Desk
Washington, DC 20555

Gentlemen:

NINETY DAY REPORT - INSERVICE INSPECTION
SEVENTH REFUELING (OCTOBER 3, 1987 - FEBRUARY 27, 1988)
SALEM GENERATING STATION
UNIT NO. 1
DOCKET NO. 50-272

This report is being submitted in accordance with Article IWA-6220(b) of Section XI of the ASME Boiler and Pressure Vessel Code. The inspection and examinations outlined in the report complete the requirements for the first 10-year ISI interval.

The attachment includes Form NIS-1, "Owners Data Report for Inservice Inspection" and Volumes 1 and 2 of the Inservice Examination of Selected Components at Salem Generating Station, Unit No. 1, prepared by Southwest Research Institute.

Should you have any further questions, please do not hesitate to contact us.

Sincerely,

Steven E Miltenberger

Attachment

A047
1/1

C Mr. D. C. Fischer
USNRC Licensing Project Manager

Mr. R. W. Borchardt
USNRC Senior Resident Inspector

Mr. W. T. Russell, Administrator
USNRC Region I

Mr. D. M. Scott, Chief
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Department of Environmental Protection
380 Scotch Road
Trenton, NJ 08628

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New Jersey Department of Labor and Industry
P.O. Box 1503
Trenton, NJ 08625

FORM NIS-1 OWNER'S DATA REPORT FOR INSERVICE INSPECTIONS
AS REQUIRED BY THE PROVISIONS OF THE ASME CODE RULES

1. Owner: Public Service Electric & Gas Co., 80 Park Plaza Newark, N.J. 07101
2. Plant: Salem Generating Station P.O. Box 236, Hancock's Bridge, N.J. 08038
3. Plant Unit 1
4. Owner's Ceritificate of Authorization (if required) N/A.
5. Commercial Service Date 7/1/77.
6. National Board Number for Unit N/A.
7. Examination Dates: 10/3/87 through 2/27/88.
8. This report covers the examinations that were conducted during the 7th Refueling/10 year ISI Outage, thus completing the requirements for the first ten year inspection interval.
9. Components Inspected.

COMPONENTS OR APPURTENANCE	MANUFACTURER OR INSTALLER	MANUFACTURER OR INSTALLER SER. NO.	STATION OR PROVINCE NUMBER	NATIONAL BOARD NO.
#1 Reactor Vessel	Combustion Engineering	67201 Head 67101 Vessel	N/A	20757
#11 Steam Generator	Westinghouse Tampa Div. P.O. Box 19218 Tampa, FL 33616	1003	N/A	68-10
#12 Steam Generator	" "	1022	N/A	68-08
#13 Steam Generator	" "	1023	N/A	68-09
#14 Steam Generator	" "	1203	N/A	68-51
#11 Regen. Ht. Exch.	Sentry Equip. Corp. Oconomowoc, WI	4195-A4 7, 8, 9	N/A	385, 386, 387

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9. Components Inspected (cont'd):

COMPONENTS OR APPURTENANCE	MANUFACTURER OR INSTALLER	MANUFACTURER OR INSTALLER SER. NO.	STATION OR PROVINCE NUMBER	NATIONAL BOARD NO.
#1 Pressurizer	Delta Southern	1011	N/A	68-8
Chemical Volume & Control Piping System	United Engineers & Constructors (UE&C) 30 South 17th St., Phila. PA 19101	N/A	N/A	N/A
Containment Spray Piping System	UE&C	N/A	N/A	N/A
Mainsteam Piping sys.	UE&C	N/A	N/A	N/A
#1 Volume Control Tank	Joseph Oat & Sons, Inc. Camden, N.J.	1781-2A	N/A	374
#1 Excess Letdown Heat Exchanger	Atlas Industries 81 Somerset Place Clifton, N.J.	850	N/A	701
#1 Letdown Heat Exchanger	Atlas Industries	N/A	N/A	694
#1 RHR Heat Exchanger	Engineers & Fabricators, Inc.	S15860-C	N/A	122

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9. Components Inspected (cont'd).:

COMPONENTS OR APPURTENANCE	MANUFACTURER OR INSTALLER	MANUFACTURER OR INSTALLER SER. NO.	STATION OR PROVINCE NUMBER	NATIONAL BOARD NO.
Pressurizer Relief Piping Sys.	UE&C	N/A	N/A	N/A
Reactor Coolant Piping Sys	UE&C	N/A	N/A	N/A
Steam Gen. Feed Piping System	UE&C	N/A	N/A	N/A
Safety Injection Piping Sys.	UE&C	N/A	N/A	N/A

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10. Abstracts of Examinations:

1.0 Examinations were conducted by PSE&G as well as companies under contract to PSE&G. The following examination summary (Section 11) is a brief summary
with further details found in the attached report and on file at the Salem Generating Station.

Since nearly all inservice examination requirements can be found in Salem's Technical Specifications, This summary lists these requirements first arranged to Tech. Spec. paragraph number followed by applicable NRC circurlars and bulletins.

11. Examination Summary:

1.0 Technical Specification 4.0.5 - ASME XI

NOTE: The Inservice Inspections performed during the seventh refueling/ten year ISI Outage at Salem, Unit 1, complete the examinations required for the first ten year inspection interval. The components were examined in accordance with "Examination Plan for the 1987 Inservice Examination of Salem Generating Station, Unit 1".

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11 Examinations Summary (cont'd):

1.1 ISI Examination

Southwest Research Institute (SWRI) under the direction of the Salem ISI Group conducted seventy-two (72) ultrasonic, twenty-one (21) liquid penetrant, three (3) magnetic particle, and twenty-eight (28) visual examinations. The examinations were conducted on selected welds or components of the following systems:

A. Reactor Coolant including Reactor Vessel examinations utilizing the Par device, Control Rod Drive Housing exams, and Steam Generator Primary Manway Bolting.

B. Chemical and Volume Control

C. Main Steam

D. Residual Heat Removal

E. Safety Injection

F. Steam Generator Feedwater

Mechanized UT examinations were performed on the Reactor Vessel welds and selected Reactor Coolant piping welds from the inside surface utilizing the Par ISI-2 device and SWRI Fast Par equipment. The mechanized UT examinations of the RPV were performed in accordance with the requirements of the 1974/Summer 1975 Edition of ASME Section XI and Regulatory Guide 1.150 Rev. 1.

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11 Examinations Summary (cont'd):

1.1(cont.)

Since Salem Unit 1 will be satisfying the requirements of the 1983/Summer 1983 Edition of ASME Section XI for the second interval, the outlet nozzle areas were examined from the nozzle bore to fulfill the second interval first period inspection requirements of the 1983/Summer 1983 Code.

VT examinations were performed on the RPV interior surface core, support structures, core barrel, and upper internals with a remotely controlled submarine and SWRI's Par mounted camera.

1.1.1 During the ISI, certain limitations were noted and reported on CNF 1.

1.1.2 During the PT examination of the longitudinal weld 31-RC-1120-5LUO, three linear indications were found. These surface indications appeared to be the result of a lug used during construction. The indications were reported on CNF 2. After cosmetic buffing, SWRI personnel re-examined the weld and found no recordable indications nor any measurable decrease in component thickness.

1.1.3 The VT examination of bolting on valve 11SJ49 revealed a heavy concentration of boron crystals. This was reported on CNF 3. Re-examination after cleaning revealed no recordable indications.

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11. Examinations Summary (cont'd):

1.1.4 Boron residue and heavy rust were also found during VT examinations of sixteen (16) studs and nuts associated with valve 1RH2. These results were reported on CNF 4. Re-examination after cleaning revealed light pitting, rust, and a tool mark. These indications were accepted "as is" by PSE&G personnel.

1.1.5 During the remote VT examination of the RPV upper internals, residue from an adjacent cutting operation was detected. This residue was removed by PSE&G after verbal notification by SWRI. The area was re-examined and no debris was found. No other reportable indications were found as a result of the MT, UT, or Mechanized UT.

The RPV Closure Head Dollar Plate weld 1-RPV-6046B was not volumetrically examined. and will be rescheduled for examination during the first refueling outage of the second interval.

1.2 Visual Examinations of Supports

Stone and Webster Visual Examinators under the direction of the Salem ISI Group conducted visual examinations on one thousand-six (1006) supports. Several discrepancies were found, i.e., rust, loose nuts, improper load settings, etc. Work Orders were issued on all noted deficiencies to correct.

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11. Examinations Summary (cont'd):

1.3 Safety/Relief Valve Testing

The PSE&G Salem Maintenance Department conducted twelve (12) safety/relief valve liftset tests on various systems. Three (3) of the valves tested were found to exceed the allowable limits. All were reset to their proper settings and tested acceptable.

1.4 TEN YEAR ISI HYDRO PROGRAM

During the 7th Refueling/10 Year ISI Outage a total of one hundred sixty-nine (169) Hydrostatic tests were performed. Sixty-four (64) Hydros were performed prior to the actual start of the Outage. Eighty-five (85) Hydros were scheduled to be performed during the Outage, but with boundary valve leak-throughs, pipe boundary leaks and retests after repairs and an additional twenty (20) Hydros were performed.

All Hydrostatic Tests were performed between the 6th Refueling Outage of Salem Unit 1 (3-22-86 to 5-9-86) and the 7th Refueling/10 Year ISI Outage completion (2-7-88). All Nuclear Class I, II, III systems Hydrostatic tests were performed in accordance with 1974/Summer 1975 Edition of ASME Section XI.

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11. Examinations Summary (cont'd):

2.0 Technical Specification 4.4.5.0 - Steam Generator Tube eddy current inspection.

2.1 Examinations were limited to the No. 13 Steam Generator and were performed by Westinghouse NSID, coordinated by the Salem ISI Group. Results of the examinations are as follows:

Extent of Exam.		No. of Tubes Inspected	Tubes with Indications (3)		
			< 20%	20-39%	> 40%
Full Length	(1)	1152	11	10	2
"U" Bend	(2)	69	0	0	0
Top of Tube Sheet	(4)	406(*)	0	0	0
Total		1505(*)	11	10	2

(1) From tube sheet, hot leg side, to tube sheet, cold leg side.
(2) From tube sheet, hot leg side, to top support plate, cold leg side.
(3) Estimated depth of indication in % of tube wall.
(4) Exams performed per Westinghouse recommendation per North Anna incident.

(*) 8x1 testing was performed on 406 tubes. Of the 406 tubes, 122 were also inspected using the standard bobbin coil probe and were included in the count of full length/u-bend tubes inspected per Technical Specifications. Therefore, only 284 tubes will be added to the total number of tubes inspected.

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11. Examinations Summary (cont'd):

2.1(cont.)

Three (3) tubes were plugged as a result of the examinations. Two (2) tubes were plugged because they exceeded the plugging limit per Technical Specifications and one (1) tube was plugged per Westinghouse recommendation for not having AVB contact.

2.2 Current Status of the Steam Generators

At this time the total number of tubes plugged in the Salem Unit 1 Steam Generators are as follows:

Generator #	11	12	13	14
Tubes Plugged	14	18	17	31

NOTE: In the Steam Generator's 11-14 the first five (5) and the last five (5) tubes in row 1 were explosively plugged because of a generic wearing problem on the tubes, due to the vibration of the tube lane blocking device.

Prior to issuing this report, Unit 1 was shutdown for a forced outage. During this outage one tube, Row 1 Column 78 in 13 Steam Generator was determined to have a through wall indication on the hot leg side, 4.09 inches above the seventh support plate and was mechanically plugged. The table 'Current Status of Steam Generators' reflects this.

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11. Examinations Summary (cont'd):

3.0 Technical Specification 4.6.1.2 (a) Reactor Containment Type "A" Test.

3.1 Summary

The Third and Final Inservice Containment Integrated Leak Rate (Type "A") Test for the first 10-year interval at Salem, Unit 1, was performed during the 24-hour period ending December 23, 1987. The test was coordinated and directed by the Salem ISI Group.

The test results indicate that the "as-left" Integrated Containment Leakage Rate, with corrections, for both the Percent Total Time and Mass Point methods of calculation are 0.039 and 0.043 weight percent per day of containment free volume respectively, at the 95% upper confidence limit. This is in accordance with the acceptance criteria prescribed in 10CFR50, Appendix J and the Salem Unit No. 1 Technical Specification. The calculated "as-found" integrated containment leakage rate was also within prescribed limits with a leakage rate of 0.063 weight per day.

4.0 Technical Specification 4.6.1.2 (d) Containment Type "B" (Penetrations) and "C" (Valves) Leak Rate Testing.

4.1 Summary

The PSE&G Research Corp. under the field supervision of the Salem ISI Group, conducted leak rate tests on sixty-three (63) Type "C" Mechanical Penetrations, one hundred twenty-two (122) valves, four (4) Type "B" Mechanical Penetrations and sixty-six (66) Type "B" Electrical Penetrations.

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11. Examinations Summary (cont'd):

4.1(cont.)

The results of these tests revealed several Type "C" valves exceeding leak rate acceptance criteria, which were reworked to an acceptable condition.

A total As-Found leakage rate of 61,772.5 SCCM was measured through all the containment penetrations (combined Type B and Type C tests). After corrective maintenance, a total As-Left leakage rate of 61,463.5 SCCM was measured through all the containment penetrations (combined Type B and Type C tests). The high value for the As-Left leakage can be primary attributed to the As-Left leakage for valve 12CS48 which had a measured As-Left leakage of 23,700.0 SCCM.

5.0 Technical Specification 4.6.1.3 (b) Elevation 100' and 130' Airlock Leak Rate Tests

5.1 Summary

PSE&G Research Corp. under the field supervision of the Salem ISI Group, conducted leak rate tests on the 100' and 130' personnel airlocks. At this time the total As-Left measured leakage through the airlocks was 9080 SCCM.

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11. Examinations Summary (cont'd):

6.0 Technical Specification 4.7.9 (a) "Visual Inspection of Hydraulic and Mechanical Snubbers".

6.1 Summary

Stone and Webster visual examiners assigned to the Salem ISI Group conducted visual examinations on one hundred-seventeen (117) mechanical snubbers and twenty-four (24) hydraulic snubbers.

During the mechanical snubber examination no deficiencies were found that would effect operability. However, several were found with missing lock wires, minor rust, and attachment ends missing washers. Work orders were issued on these discrepancies and the conditions corrected.

Several minor union leaks were found during the visual examination of the hydraulic snubbers. These discrepancies were also corrected.

NOTE: All mechanical and hydraulic snubbers were visually examined again at the end of the outage to assure all discrepancies were corrected, settings were proper, and no damage had occurred.

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11. Examinations Summary (cont'd):

7.0 Technical Specification 4.7.9 (c) "Functional Testing of Selected Hydraulic and Mechanical Snubbers".

7.1 Summary - Hydraulic Snubbers

Technical Specification 4.7.9 requires functional testing on 10% of the snubber total during each plant refueling outage. In addition, all snubbers which failed their previous functional test must also be functionally tested. Accordingly four (4) snubbers were tested (see below):

- One (1) 200 KIP Main Steam Isolation valve (MSIV) hydraulic snubber.
- Two (2) 1000 KIP Steam Generator Snubbers (Rexnord).
- One (1) 1000 KIP Steam Generator Snubbers (Paul Munroe).

The tests were performed by Wyle Laboratories using the API In-place Hydraulic Snubber Tester. All snubbers tested were found acceptable.

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11. Examinations Summary (cont'd):

7.2 Summary - Mechanical Snubbers

Technical Specification 4.7.9 requires functional testing on 10% of the snubber total during each Plant Refueling Outage. For each type snubber that does not meet the acceptance criteria an additional 10% of that type of snubber must be functionally tested.

Wyle Laboratories under the direction of the Salem ISI Group performed the mechanical snubber testing on site utilizing the Wyle Model 150 Bench Test Machine recently purchased by PSE&G.

The first sample tested included a total of twenty-two (22) snubbers of which:

A. Twelve (12) snubbers selected to satisfy the 10% Technical Specification requirements.

B. In addition, all remaining PSA-1/4 and PSA-1/2 snubbers, seven (7) total, that were not included in the 10% Tech. Spec. sample were tested due to the previous failure record of these size snubbers.

C. Three (3) snubbers that had failed prior functional test.

The results of this sample found no failures.

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11. Examinations Summary (cont'd):

8.0 NRC Circular 76-06 and NRC Bulletin 79-17 "Commitment to Examine and/or Flush Stainles Steel Lines Containing Stagnant Borated Water".

8.1 Summary 76-06 and 79-17

SWRI under the direction of the Salem ISI Group performed ultrasonic examinations on six (6) additional welds.

Portions of Containment Spray, Safety Injection, and Chemical Volume Control Systems were flushed (and continue to be flushed) during the pump capacity surveillance testing as per Surveillance Procedure SP (0) 4.0.5-P.

The Inservice Inspection Group, under the directions of the ISI Engineer, conducted an inspection of all areas in the South Penetration and Auxiliary Building wherein the subject piping systems were installed. Other than minor mechanical joint leakage (which were corrected) no discrepancies were noted.

Portions of the CVC-Operation System that do not contain sampling connections in certain stagnant piping are flushed by the Operationg Department in accordance with SP (0) 4.0.5-P.

Chloride sampling and testing for chloride content of those samples of fluids in stagnant piping is conducted on a quarterly basis. During the past 18 months this program identified only two (2) nonconformances. The nonconforming piping was flushed and the situation corrected. This was verified by additional sample analysis. We will continue this sampling and analysis program as we have in the past.

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11. Examinations Summary (cont'd):

9.0 NUREG 0578 - TMI Lessons Learned - Performing Service Leak Exams, measuring leakage outside Containment, and take Corrective Actions necessary to reduce leakage as low as possible on systems likely to contain Radioactive liquids in the event of an incident.

9.1 Summary -

The Salem ISI Group performed service pressure leak exams on the Safety Injection, Chemical Volume Control, residual Heat Removal and Containment Spray Systems.

In addition, PSE&G Research Corp. under the direction of the Salem ISI Group conducted the Waste Gas System Leak Rate Test in accordance with Site Services Procedure M9-ILP-WG-1.

There were no adverse findings in the examinations or tests conducted relative to this bulletin.

10.0 NRC Bulletin 82-02 "Degradation of Threaded Fasteners in the Reactor Coolant Pressure Boundry of Power Plants".

10.1 Summary

All Steam Generator Primary Manway and Reactor Coolant Pump Main Flange Bolting was visually examined in-place. None were found to have been degraded or have any boron buildup. In addition, surface examinations were performed on thirty-two (32) Primary Manway Bolts using the Fluorescent Magnetic Particle Method. Results of the surface examinations were satisfactory.

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We certify that the statements made up in this report are correct and the examinations and corrective measures taken conform to the rules of the ASME Code, Section XI.

Date May 2, 19 88 Signed PSE&G Owner By Louis H. Lake

Certificatate of Authorization No. (if applicable) N/A

Expiration Date N/A

CERTIFICATE OF INSERVICE INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the State or Province of New Jersey and employed by Lumbermen's Mutual Casualty Company, Long Grove, Illinois, have inspected the components described in this Owner's Data Report during the period 10-3-87 to 2-27-88 and state that to the best of my knowledge and belief the Owner has performed examinations and taken corrective measures described in this Owner's Data Report in accordance with the requirements of the ASME Code, Section XI.

By signing this certificate neither the Inspector nor his employer makes any warranty, expressed of implied, concerning the examinations and corrective measures described in this Owner's Data Report. Futhermore, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date May 16, 19 88

James E. Cole Commissions NJ 373 "I"

Inspector's Signature — National Board, State, Province and No.

1987 INSERVICE EXAMINATION OF SELECTED CLASS 1 AND CLASS 2 COMPONENTS AT SALEM GENERATING STATION, UNIT 1

VOLUME II
APPENDICES (CONT'D)
SwRI Project 1552

Prepared for

Public Service Electric and Gas Company
80 Park Plaza
P.O. Box 570
Newark, New Jersey 07101

January 1988

SOUTHWEST RESEARCH INSTITUTE
SAN ANTONIO HOUSTON

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1987 INSERVICE EXAMINATION OF SELECTED CLASS 1 AND CLASS 2 COMPONENTS AT SALEM GENERATING STATION, UNIT 1

VOLUME II
APPENDICES (CONT'D)
SwRI Project 1552

Prepared for

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APPENDIX I

INSERVICE EXAMINATION LIMITATIONS FOR THE SALEM UNIT 1 REACTOR PRESSURE VESSEL

APPENDIX I

INSERVICE EXAMINATION LIMITATIONS FOR THE SALEM UNIT 1
REACTOR PRESSURE VESSEL

1. Introduction

Some limitations to ultrasonic examination volumetric coverage were experienced during the 1987 Inservice Inspection (ISI) of the Salem Generating Station, Unit 1, Reactor Pressure Vessel (RPV) welds and components. These limitations are generically reported in the Examination Summary Table of this Final Report. The purpose of this appendix is to further define and quantify the RPV examination limitations as required by U.S. NRC Regulatory Guide 1.150.

SwRI ultrasonic examination procedures implemented during the 1987 Salem 1 RPV ISI met or exceeded the requirements of ASME Section XI 1974 Edition with Addenda through Summer 1975 and U.S. NRC Regulatory Guide 1.150, Revision 1. These procedures, implemented as part of the SwRI Scan Plan, generally required examination of weld metal and 1/2T adjacent base metal from four directions for 10 percent of weld length for all vessel longitudinal and meridional welds, 5 percent of weld length for vessel circumferential welds, 100 percent of length of the flange-to-shell weld, and 100 percent of length for the nozzle-to-shell welds.

The outlet nozzle-to-shell welds and inside radius sections were examined during the 1987 ISI in accordance with the requirements of ASME XI 83W83 Code to satisfy the First Period, Second Interval requirements of the Salem 1 ISI Program. The 1983 Edition defines the nozzle examination volume differently from the 74S75 Code.

The examination volumes which received other than full coverage as specified are identified herein. Generally interface noise inhibited resolution capabilities at the sound-beam entry surface for about 1/2-inch depth for the 45- and 60-degree shear waves and about 1-1/2-inch depth for the 0-degree longitudinal wave. This near-surface examination volume was examined with supplemental 50/70-degree tandem beam search units which were calibrated from the clad-to-base metal interface down to the applicable 1/4T depth thus overlapping the 45- and 60-degree examination volumes. Using this examination process, only two generic types of limitations were experienced during the 1987 Salem 1 ISI of the RPV welds and components:

(1) Component geometric interference with the scanning equipment, and

(2) Geometric shadowing of examination volumes.

2. Description of Limitations

The attached Table 1 and Figures 1 through 3 detail the examination coverage attained during the Salem 1 RPV ISI. Specifically, the tables quantify the coverage in terms of percent of Code-required examination volume which was effectively covered with each beam component. The accompanying figures graphically depict the location and extent of the limitations with respect to weld metal and associated base material. The computed values for percent coverage do not include any consideration for beam spread. The percent coverage values for the 45-, 60-, and 50/70-degree examinations are calculated based on depth zone of calibration as specified in the procedure. The 50/70-degree examinations should be considered as supplemental to the Code-specified 45- and 60-degree examinations.

2.1 RPV Lower Head Welds

The Lower Head Dollar Plate Weld, 1-RPV-4043, received a limited examination due to scanner interference from the in-core instrumentation penetration tubes. Proximity of the instrumentation tubes prohibited scanning from two directions for indications oriented transverse to the weld plane; therefore, 45- and 60-degree beams were limited to single directional coverage at the extreme ends of the examination volume.

The abrupt transition of the lower shell-to-lower head weld at the azimuth of Lower Head Meridional Weld 1-RPV-1043A caused some loss of contact during 45- and 60-degree scans with beams oriented for detection of indications parallel to the weld plane. The extent of coverage with this limitation is shown on Table 1. No such limitations were experienced during examination of Meridional Welds 1-RPV-1043B through F. The straight-beam examination of all welds was limited due to sound-beam entry surface interface noise.

2.2 RPV Circumferential Shell Welds

Except for 0-degree beam entry surface interface noise, no limitations were experienced during examination of the Lower Shell-to-Lower Head Circumferential Weld 1-RPV-10042, Middle Shell-to-Lower Shell Circumferential Weld 1-RPV-9042, nor Upper Shell-to-Middle Shell Circumferential Weld 1-RPV-8042.

Due to the transition at the Flange-to-Upper Shell Weld 1-RPV-7042, limitations were experienced during examination for indications oriented transverse to the weld plane. These limitations are quantified in Table 1 and depicted graphically in Figure 1. Examinations for indications oriented parallel to the weld plane were conducted from the flange seal surface without limitation. Supplementary scans were conducted from the shell side of the weld (beams directed up) and this examination was also limited (above the weld) by the shell transition. Examinations of the Flange-to-Upper Shell Weld were conducted for 100 percent of the weld length.

2.3 RPV Longitudinal Shell Welds

With the exception of the inherent 0-degree beam limitations previously described, no limitations were experienced during examination of the Lower Shell Vertical Welds 1-RPV-3042A, B, and C, nor Middle Shell Vertical Welds 1-RPV-2042A, B, and C, nor Upper Shell Vertical Welds 1-RPV-1042A, B, and C.

2.4 Nozzle-to-Shell Welds

The inlet and outlet nozzle-to-shell welds were examined from the vessel shell and from the nozzle bore. Transverse examinations performed from the vessel wall were limited on the outlet nozzle forging side of the weld due to the nozzle integral extension configuration. Nozzle configuration also shadowed the straight-beam and angle-beam examinations performed from the nozzle bores as shown in Figures 2 and 3. These figures also showed that the 6-degree or 10-degree and 45-degree beam examinations complement each other so full coverage was obtained by at least one of the primary beams. The Code-defined nozzle inner radius sections and nozzle bore regions were covered using 50/70-degree search units in the nozzle bores and on the radius itself in the case of the inlet nozzles. Table 1 lists the coverage achieved with each search unit beam component.

2.5 Closure Head Dollar Plate

The Closure Head Dollar Plate Weld 1-RPV-6046B could not be located for examination. Approximately 26 inches, 16 inches above and 10 inches below, the calculated location of the weld

(from drawing PSBP No. 138977) was buffed bright and etched with amonium persulfate in an effort to locate the weld for examination. The weld location effort subjected the personnel involved to approximately 1,000 millirem of radiation collectively.

3. Conclusions

Limitations to coverage of ASME Code-required examination volumes were experienced during the Salem 1 RPV ISI examinations due to component configuration and interference by vessel attachments. These limitations are identified in the figures and table provided in this appendix. The limitations were minimized to the maximum extent possible by supplementing the Code-defined examination techniques with the 50/70-degree scanning.

Table 1

RPV EXAMINATION COVERAGE

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
RPV Lower Head Welds			
Dollar Plate Weld 1-RPV-4043	0	75	0-degree limitation due to interface noise. Full 45T-degree and 60T-degree coverage obtained in one-direction. Two- direction coverage limited due to instrumentation tube interferences.
	45	100	
	60	100	
	50/70	100	
	45T	68	
	60T	79	
	50/70T	100	
Meridional Weld @ 30° 1-RPV-1043C	0	75	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Meridional Weld @ 90° 1-RPV-1043D	0	75	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Meridional Weld @ 150° 1-RPV-1043E	0	75	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Meridional Weld @ 210° 1-RPV-1043F	0	75	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	

Table 1

RPV EXAMINATION COVERAGE (Cont'd)

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
Meridional Weld @ 270°	0	75	0-degree limitation due to
1-RPV-1043A	45	91	interface noise. 45-degree
	60	92	and 60-degree limitation
	50/70	100	due to liftoff at shell-to-
	45T	100	head transition.
	60T	100	
	50/70T	100	
Meridional Weld @ 330°	0	75	0-degree limitation due to
1-RPV-1043B	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
RPV Circumferential Shell Welds			
Lower Shell-Lower Head	0	83	0-degree limitation due to
1-RPV-10042	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Middle-Lower Shell	0	83	0-degree limitation due to
1-RPV-9042	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Upper-Middle Shell	0	83	0-degree limitation due to
1-RPV-8042	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	

Table 1

RPV EXAMINATION COVERAGE (Cont'd)

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
Flange-Upper Shell 1-RPV-7042	1.5 (from flange)	100	0-degree limitation due to interface noise and scanning interference by shell taper. All shell-side examinations limited by shell taper. See Figure 1.
	5.7 (from flange)	100	
	12.5 (from flange)	100	
	0	80	
	45 (supplemental)	81	
	60 (supplemental)	83	
	50/70	62	
	45T	42	
	60T	42	
	50/70T	42	
RPV Longitudinal Shell Welds			
Lower Shell Vert. @ 105° 1-RPV-3042B	0	83	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Lower Shell Vert. @ 225° 1-RPV-3042C	0	83	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Lower Shell Vert. @ 345° 1-RPV-3042A	0	83	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	

Table 1

RPV EXAMINATION COVERAGE (Cont'd)

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
Middle Shell Vert. @ 60°	0	83	0-degree limitation due to
1- P -2042B	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Middle Shell Vert. @ 180°	0	83	0-degree limitation due to
1-RPV-2042C	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Middle Shell Vert. @ 300°	0	83	0-degree limitation due to
1-RPV-2042A	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Upper Shell Vert. @ 7°	0	86	0-degree limitation due to
1-RPV-1042B	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Upper Shell Vert. @ 127°	0	86	0-degree limitation due to
1-RPV-1042C	45	100	interface noise.
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	

Table 1

RPV EXAMINATION COVERAGE (Cont'd)

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
Upper Shell Vert. @ 247° 1-RPV-1042A	0	86	0-degree limitation due to interface noise.
	45	100	
	60	100	
	50/70	100	
	45T	100	
	60T	100	
	50/70T	100	
Nozzle-to-Shell Welds and Inside Radius Sections			
Inlet Nozzle @ 67° 27.5-RPV-1140-1	6 (bore)	94	6-degree and 45-degree bore examination limited by nozzle configuration. See Figure 2. 0-degree shell examination limitation due to interface noise.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IRS)	100	
	0 (shell)	86	
	45T (shell)	100	
	60T (shell)	100	
	50/70T (shell)	100	
Inlet Nozzle @ 113° 27.5-RPV-1130-1	6 (bore)	94	6-degree and 45-degree bore examination limited by nozzle configuration. See Figure 2. 0-degree shell examination limitation due to interface noise.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IRS)	100	
	0 (shell)	86	
	45T (shell)	100	
	60T (shell)	100	
	50/70T (shell)	100	
Inlet Nozzle @ 247° 27.5-RPV-1110-1	6 (bore)	94	6-degree and 45-degree bore examination limited by nozzle configuration. See Figure 2. 0-degree shell examination limitation due to interface noise.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IRS)	100	
	0 (shell)	86	
	45T (shell)	100	
	60T (shell)	100	
	50/70T (shell)	100	

Table 1

RPV EXAMINATION COVERAGE (Cont'd)

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
Inlet Nozzle @ 293° 27.5-RPV-1120-1	6 (bore)	94	6-degree and 45-degree bore examination limited by nozzle configuration. See Figure 2. 0-degree shell examination limitation due to interface noise.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IRS)	100	
	0 (shell)	86	
	45T (shell)	100	
	60T (shell)	100	
	50/70T (shell)	100	
Outlet Nozzle @ 7° 29-RPV-1140-1	10 (bore)	96	Bore examinations limited by nozzle configuration. Shell examinations limited by Integral Extension interference. See Figure 3. 0-degree limitations due to interface noise and Integral Extension interference.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IE)	100	
	0 (shell)	40	
	45T (shell)	46	
	60T (shell)	46	
	50/70T (shell)	46	
Outlet Nozzle @ 158° 29-RPV-1130-1	10 (bore)	96	Bore examinations limited by nozzle configuration. Shell examinations limited by Integral Extension interference. See Figure 3. 0-degree limitations due to interface noise and Integral Extension interference.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IE)	100	
	0 (shell)	40	
	45T (shell)	46	
	60T (shell)	46	
	50/70T (shell)	46	
Outlet Nozzle @ 202° 29-RPV-1110-1	10 (bore)	96	Bore examinations limited by nozzle configuration. Shell examinations limited by Integral Extension interference. See Figure 3. 0-degree limitations due to interface noise and Integral Extension interference.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IE)	100	
	0 (shell)	40	
	45T (shell)	46	
	60T (shell)	46	
	50/70T (shell)	46	

Table 1

RPV EXAMINATION COVERAGE (Cont'd)

Weld Description and Weld Number	Exam Angle	Percent of Req'd Volume Examined	Description of Limitation
Outlet Nozzle @ 338° 29-RPV-1120-1	10 (bore)	96	Bore examinations limited by nozzle configuration. Shell examinations limited by Integral Extension interference. See Figure 3. 0-degree limitations due to interface noise and Integral Extension interference.
	45 (bore)	98	
	50/70 (bore)	100	
	50/70T (bore and IRS)	100	
	0 (shell)	40	
	45T (shell)	46	
	60T (shell)	46	
	50/70T (shell)	46	

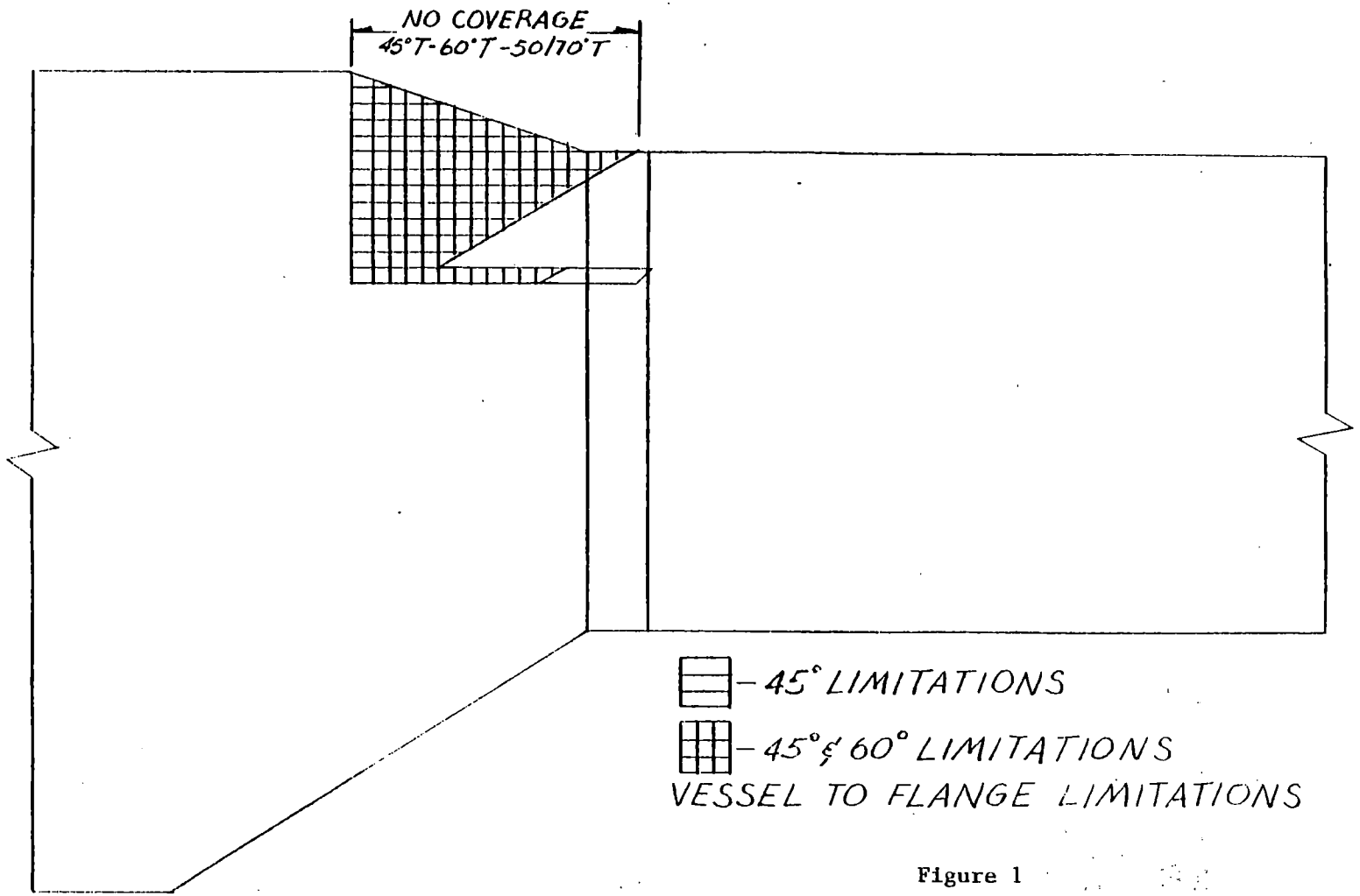
NO COVERAGE
45°T-60°T-50/70°T
-45° LIMITATIONS
-45° & 60° LIMITATIONS
VESSEL TO FLANGE LIMITATIONS

Figure 1

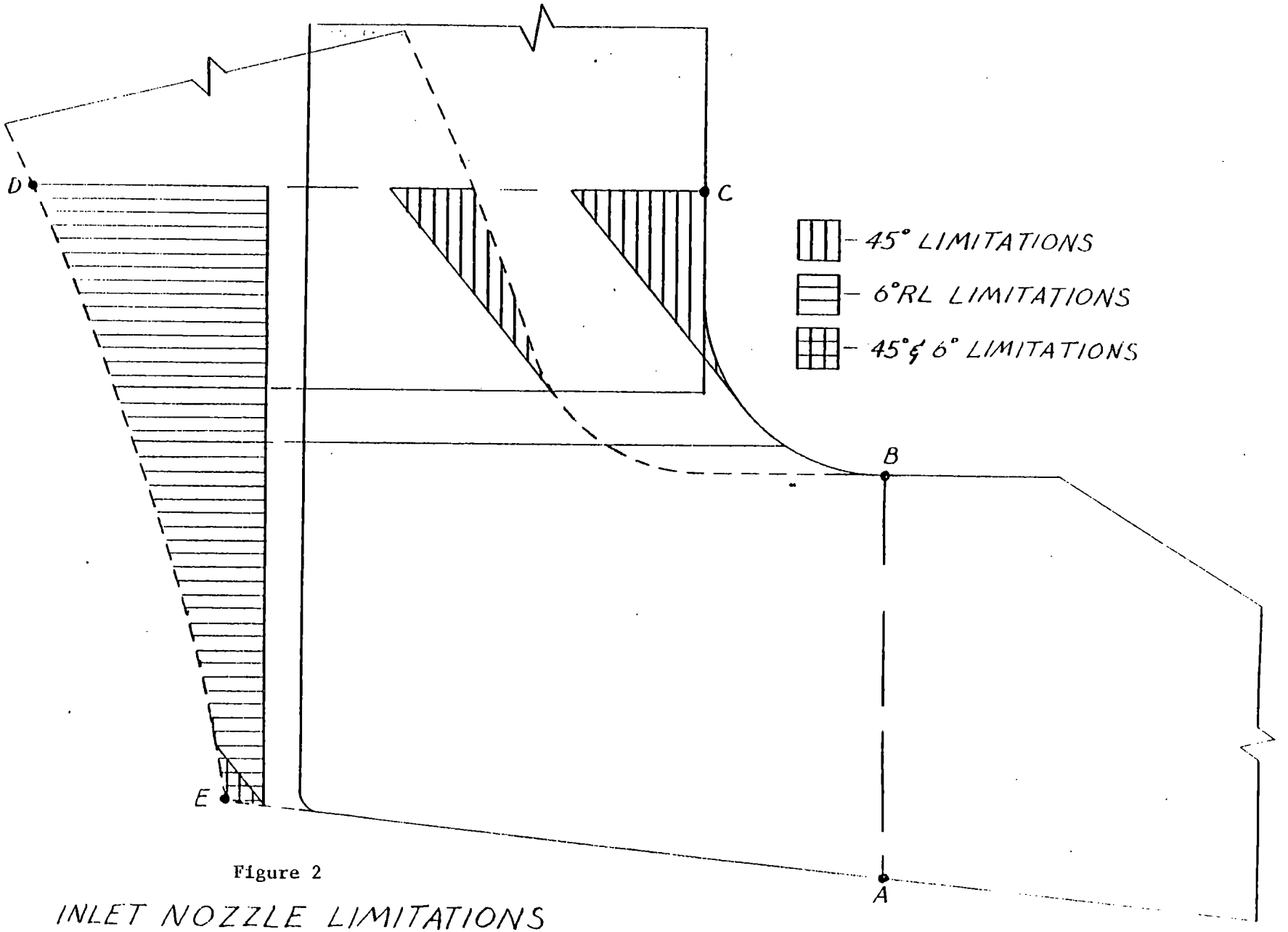

Figure 2

INLET NOZZLE LIMITATIONS

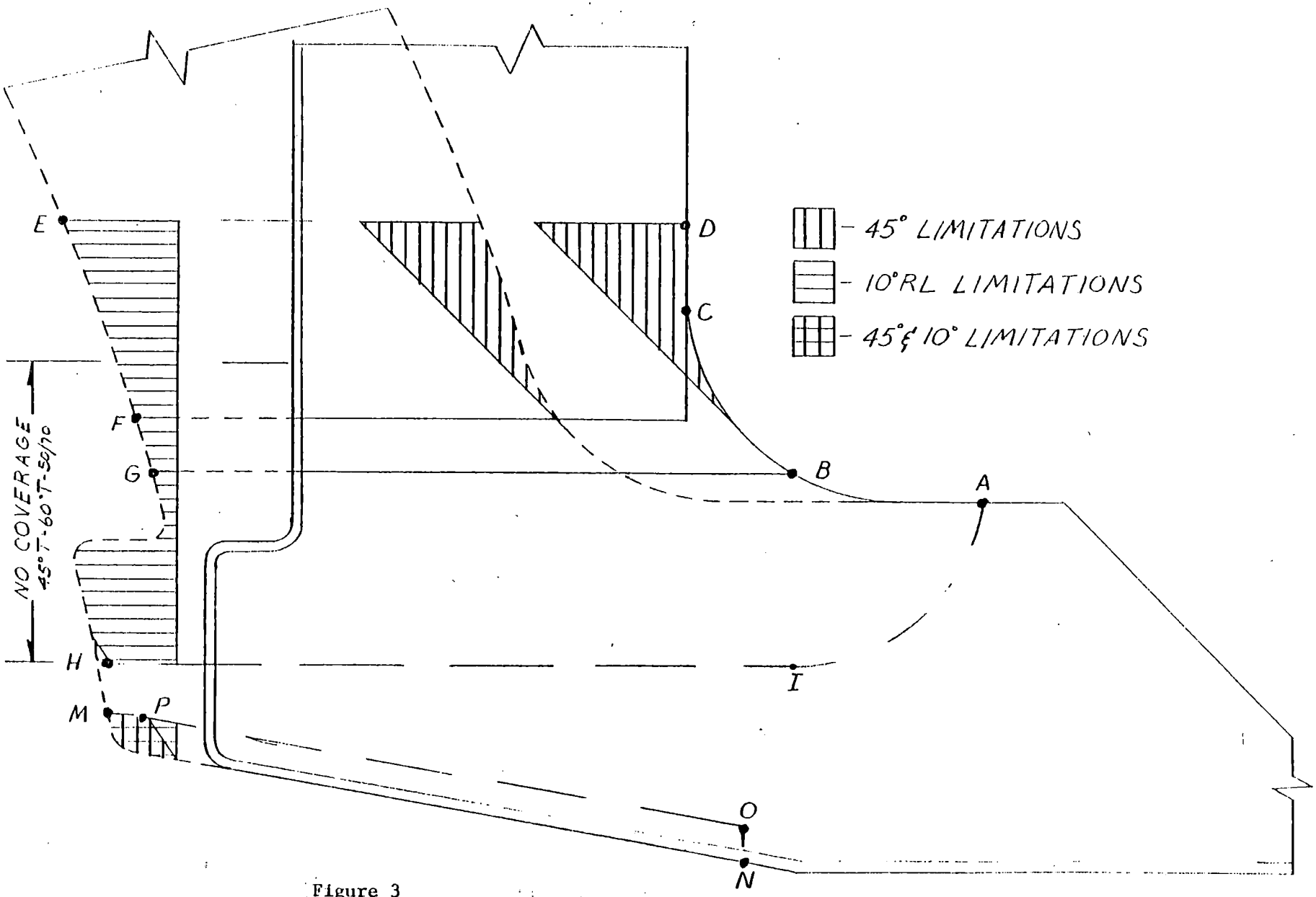

Figure 3

OUTLET NOZZLE LIMITATIONS

APPENDIX J

SCAN PLAN TEXT, COMPLETED PARAMETER RECORDS,
SCAN SHEETS, AND EXAMINATION TABLES

SCAN PLAN FOR MECHANIZED ULTRASONIC EXAMINATION OF SELECTED COMPONENTS AT SALEM GENERATING STATION, UNIT 1

Final Scan Plan
SwRI Project 17-1552

Prepared for

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September 1987

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TABLE OF CONTENTS

1. INTRODUCTION

1.1 Purpose

1.1.1 This plan provides the information required to perform mechanized ultrasonic examinations of selected areas of the reactor pressure vessel and adjacent piping at Salem Generation Station, Unit 1.

1.2 Scope

1.2.1 This plan is prepared in accordance with Southwest Research Institute (SwRI) Nuclear Projects Operating Procedure V-FE-101-4, "Preparation of Mechanized Scan Plan," and satisfies the requirements of SwRI Procedures NDT-700-11, Rev. 7, "Mechanized Ultrasonic Inside Surface Examination of Ferritic Vessels Greater than 2.5 Inches in Thickness," NDT-700-11, Rev. 8, "Mechanized Ultrasonic Inside Surface Examination of Ferritic Vessels Greater than 2 Inches in thickness," and NDT-700-10, Revs. 3 and 4, "Mechanized Ultrasonic Examination of Austenitic Pressure Piping Welds."

1.2.2 The information specified is that required to perform mechanized ultrasonic examinations of the welds and adjacent base metal from the inside of the reactor pressure vessel, examination of the reactor pressure vessel nozzle inside radiused sections (IRS)/ inside corner region (ICR) and piping welds from the nozzle bore, using Fast PaR Model ISI-2 Inservice Inspection Positioning System (Device). For each mechanized ultrasonic examination, the SwRI Data Acquisition System will be used for observing and permanently recording the results.

1.2.3 This plan was generated from information and drawings obtained from the December 1975/August 1982 Salem 1 Mechanized Scan Plans. The information provided in the plan is limited to the parameters available at the time of writing. Parameters deviating or omitted from the plan must be provided on site preceding the examinations. Prior to the commencement of any particular examination, all applicable parameters must be defined and recorded in the appropriate Scan Plan Examination Table and text.

1.2.4 For the mechanized examinations of the reactor pressure vessel, the information provided is limited to that required to perform examinations of the following areas:

(1) Outlet Shell-to-Nozzle Welds and Inside Corner Region (ICR) (From Nozzle Bore)

29-RPV-1110-1 (202°)	29-RPV-1130-1 (158°)
29-RPV-1120-1 (338°)	29-RPV-1140-01 (22°)

(2) Outlet Shell-to-Nozzle Welds (From Vessel Wall)

29-RPV-1140-1 (22°) 29-RPV-1110-1 (202°)
29-RPV-1130-1 (158°) 29-RPV-1120-1 (338°)

(3) Inlet Nozzle-to-Shell Welds

27.5-RPV-1110-1 (247°) 27.5-RPV-1120-1 (293°)
27.5-RPV-1130-1 (113°) 27.5-RPV-1140-1 (67°)

(4) Inlet Nozzle Inside Radiused Section (IRS)

27.5-RPV-1110-IRS (247°) 27.5-RPV-1120-IRS (293°)
27.5-RPV-1130-IRS (113°) 27.5-RPV-1140-IRS (67°)

(5) Longitudinal Welds

1-RPV-2042A, 1-RPV-2042B, 1-RPV-2042C (10%, 10.9" each weld)
1-RPV-3042A, 1-RPV-3042B, 1-RPV-3042C (10%, 10.9" each weld)
1-RPV-1042A, 1-RPV-1042B, 1-RPV-1042C (10%, 9.9" each weld)

(6) Circumferential Welds

1-RPV-9042 (5%, 27.2"), 1-RPV-8042 (5%, 27.2"), 1-RPV-10042 (5%, 27.2"), 1-RPV-7042 (100% from vessel wall, 33-1/3%, 179.5" from flange seal surface), 1-RPV-4043 (5%, 16.47")

(7) Meridional Welds (10%, 6.9" Each Weld)

1-RPV-1043A, 1-RPV-1043B, 1-RPV-1043C, 1-RPV-1043D, 1-RPV-1043E, 1-RPV-1043F

(8) Elbow-to-Safe End Welds (Only From Safe End Side)

27.5-RC-1140-4, 27.5-RC-1130-4, 27.5-RC-1120-4, 27.5-RC-1110-4

(9) Safe End-to-Nozzle Welds

27.5-RC-1140-5, 27.5-RC-1130-5, 27.5-RC-1120-5, 27.5-RC-1110-5

(10) Nozzle-to-Safe End Welds

29-RC-1110-1, 29-RC-1120-1, 29-RC-1130-1, 29-RC-1140-1

(11) Safe End-to-Pipe Welds

29-RC-1110-2, 29-RC-1120-2, 29-RC-1130-2, 29-RC-1140-2

2. PARAMETER RECORDS, EXAMINATION TABLES, AND SCAN SHEETS

The Scan Plan Parameter Records, Examination Tables, and the SwRi PaR Scan Sheets (Appendix A) provide necessary information about the examination areas, sequence of examinations, device configuration, and examination and calibration parameters. In conjunction with the requirements of V-FE-101-4, "Preparation of Mechanized Examination Scan Plan," the following required information is provided in the parameter records, examination tables, and scan sheets with supplemental remarks and special instructions where necessary.

2.1 SwRI Scan Plan Parameter Records

2.1.1 Examination Parameters

- Site Name. Identifies the site where examinations will be performed.
- Project No. SwRI Project number for the examinations.
- Exam No. Identifies the numerical sequence of each examination.
- Weld No. This is the weld identification number.
- Component. Identifies the major system where examination is to be performed such as Reactor Pressure Vessel or Steam Generator.
- Subassembly. Identifies the specific area where examination is to be performed such as Lower Head or Middle shell.
- Procedure/Rev./Dev. Identifies the procedure number, revision, and, if applicable, deviation number.
- Scan Path Sketch No. Identifies the scan path sketch which illustrates the specific area being examined. A complete listing of the Scan Path Sketches is located in Appendix E of Volume II. Blueline drawings are provided in Appendix E of Volume III.
- Cal. Blk. No. UT calibration block number to be utilized during the examination. A complete listing of the applicable UT calibration blocks to be utilized during the examinations is located in Appendix D of Volume II. Blueline drawings are provided in Appendix D of Volume III.
- Device Dwg. No. Specifies the applicable SwRI device drawing number. Appendix F of Volume II contains a listing of all applicable device configuration drawings, and Appendix G of Volume II contains a listing of miscellaneous drawings. Bluelines are provided in the respective appendices of Volume III.

2.1.2 Calibration and Device Parameters

NOTE: The following information may or may not appear under "Calibration and Device Parameters," depending on the type and method of examination to be performed.

- Weld, Loc. Location of the weld in respect to vessel zero reference.
- Vessel Dia. The diameter of the vessel inside surface at the examination area.
- Wall Thickness. The thickness of the examination area. This dimension is required to permit the computer to calculate the proper number of scans to cover the examination area. It is derived from customer supplied drawings.
- X-Start Pos. The scan mode device readout counts for the start of the scan when scanning axially to the weld.
- X-Stop Pos. The scan mode device readout counts for the end of the scan when scanning axially to the weld.
- Cal. Blk. Thickness (In.). The thickness of the UT calibration block to be utilized for the examination.
- Nozzle Azimuth. The location of the nozzle to be examined in degrees from vessel zero.
- Weld Length. The length of the weld as calculated at the weld centerline.
- Weld Diameter. The diameter of the weld as calculated at the weld centerline.
- Nozzle Bore Diameter. The diameter of the nozzle bore being examined taken at the point of the last scan.
- Offset (Piv. to RPV C/L). The distance from the Reactor pressure Vessel centerline to the module pivot point with the horizontal boom device readout at zero counts.
- Hoist Position. The calculated distance from the hoist zero reference point to the nozzle centerline.
- First Cal. Reflector. The distance from the calibration surface to the first calibration reflector, measured perpendicular to the calibration surface.
- Second Cal. Reflector. The distance from the calibration surface to the second calibration reflector, measured perpendicular to the calibration surface.

- Third Cal. Reflector. The distance from the calibration surface to the third calibration reflector, measured perpendicular to the calibration surface.

- Exam. Angle #2. The examination angle for instrument #2 for nozzle-to-shell examinations from the bore, normally determined by the inside taper of the nozzle.

- Beam Dir./Beam Component. The direction of the search unit sound beam relative to the examination area.

- Inc. Dir. The direction the increment device is moved during scan incrementing.

- Start Pos. (FM. C/L). The increment mode device readout counts for the start of the examination.

- Coverage in Inches. The distance in inches from the first to the last scan.

- Noz. Blend Radius. The radius of the nozzle blend area.

- Noz. Type. Type of nozzle being examined (Inlet or Outlet).

- Lower Head Radius (In.). The radius of the lower head from the tangent point.

- Lower Head Rad. Pt. (In. Below Ref.). The dimension from vessel zero reference to the lower head tangent point.

2.1.3 X-Y Conversion Parameters

NOTE: The following information may or may not appear under "X-Y Conversion Parameters" depending on the type and method of examination to be performed.

- Inches per Degree. The number of inches in one degree of X or Y movement.

- Degrees per Inch. The number of degrees in one inch of X or Y movement.

- Inches per Count. The number of inches per device X or Y movement counts.

- Counts per Inch. The number of device X or Y movement counts per inch.

- Counts per Degree. The number of device X or Y movement counts per degree.

2.2 SwRI Scan Plan Examination Tables

General information such as that presented on the Parameter Record is listed (i.e., site name, project no., weld no., etc.). In addition, the following is also presented:

- Weld Type. Identifies the type of weld such as nozzle-to-shell, nozzle-to-safe end, etc.
- Scan Type. Indicates whether the examination is for indications oriented parallel with, perpendicular to, or radial to the examination area.

2.2.1 Calibration Parameters

- Transducer Size. The search unit piezoelectric element size for that instrument.
- Freq. The frequency, in megahertz (MHz), of the examination search unit for that instrument.
- Nom. Beam Angle (Deg.). The nominal beam inspection angle for that instrument.
- Beam Component. The direction of the search unit sound beam relative to the examination area.
- Sweep Distance. The sweep distance on each instrument in inches.
- Cal. Nodes/Sweep Dist. Calibration nodes or response and metal path for each instrument.
- Gate Settings. The start and stop gate settings for each scan for each instrument.

2.2.2 Module Parameters

- X-Y OFFSET. Prescribes the distance the centerline of the search unit is offset from the centerline of the module in both X and Y dimensions. It may be either a plus or minus and is measured in inches.
- Module Configuration No. Module configuration number as referenced in Appendix B.

2.3 SwRI PaR Scan Sheets

2.3.1 Parameters

- Scan Inc. (In.). The distance the module is moved prior to each scan.

- X-Function. The mechanical device used to move the module axially to the weld.
- Y-Function. The mechanical device used to move the module perpendicular to the weld.
- Dir. Direction of scan movement.
- Y-Pos. The Y-mechanical device readout counts for each scan when scanning axially to the weld.
- X-Start/X-Stop. The scan limits defining the start and stop counts on the X-mechanical device readouts for each scan when scanning axially to the weld.
- X-Pos. The X-mechanical device readout counts for each scan when scanning perpendicular to the weld.
- Y-Start/Y-Stop. The scan limits defining the start and stop counts on the Y-mechanical device readouts for each scan when scanning perpendicular to the weld.

3. GENERAL EXAMINATION TECHNIQUES

3.1 Scan Increments

During the mechanized ultrasonic examination scans, a minimum overlap of 25 percent will be used with SwRI Procedures NDT-700-10 and 700-11. Search units used during the examination will have the following maximum scan increments.

Search Unit Size	Maximum Scan Increment
1.00" (1"0	0.75"
0.75" (3/4")	0.56"
0.50" (1/2")	0.37"

NOTE: For the 50/70-degree inside radius examination from the inlet nozzle bore, the increment will be 0.10 inch.

3.2 Angle Designations

For the purpose of this Scan Plan, unless otherwise indicated, angles between 40 and 60 degrees shall be refracted shear waves, and other angles shall be straight-beam or refracted longitudinal waves.

3.3 Examination Methods

Ultrasonic examination methods to be used are as follows:

3.3.1 The circumferential, meridional, and longitudinal welds will be examined from the vessel wall with search units producing 0-degree longitudinal waves (UTOL) for detection of laminar reflectors which affect interpretation of the angle-beam results.

3.3.2 The circumferential, meridional, and longitudinal welds will be examined from the vessel wall with search units producing 0-degree longitudinal waves (UTOW) for detection of reflectors in the weld and adjacent base material.

3.3.3 The circumferential, meridional, and longitudinal welds will be examined from the vessel wall with search units producing 45 ±2-degree and 60 ±2-degree shear waves (UT45 and UT60) for detection of reflectors oriented parallel with the weld and adjacent base material.

3.3.4 The circumferential, longitudinal, meridional, and nozzle-to-shell welds will be examined from the vessel wall with search units producing 45 ±2-degree and 60 ±2-degree shear waves (UT45T and UT60T) for detection of reflectors oriented transverse to the weld and adjacent base material.

3.3.5 The circumferential, longitudinal, meridional, and nozzle-to-shell welds will be examined from the vessel wall with 50/70-degree refracted longitudinal waves to detect underclad cracking and flaws in the near surface area of the weld and adjacent base material. All scanning will be done parallel with the beam component direction for the circumferential, meridional, and longitudinal welds.

3.3.6 The inlet nozzle-to-shell welds will be examined from the nozzle bore utilizing search units producing 6-degree refracted longitudinal waves and 45 ±2-degree shear waves for the detection of reflectors in the weld and adjacent base material.

3.3.7 The outlet nozzle-to-shell weld and the integral extension areas will be examined from the nozzle bore utilizing search units producing 10-degree longitudinal waves and 45 ±2-degree shear waves for the detection of reflectors in the weld, adjacent base material, and the nozzle integral extension region.

3.3.8 The inlet nozzle inside radius section will be examined from the nozzle bore with 50/70-degree refracted longitudinal waves to detect underclad cracking and flaws in the near surface area between the tangent point and the point along the nozzle bore as defined by Section XI as the extent of the required examination area.

3.3.9 The outlet nozzle inside corner region (ICR) will be examined from the nozzle bore with 50/70-degree refracted longitudinal waves to detect underclad cracking and flaws in the near surface area between the tangent point and the point along the nozzle bore as defined by Section XI as the extent of the required examination area.

3.3.10 The elbow-to-safe end and safe end-to-nozzle welds will be examined from the nozzle/pipe bore with search units producing 0-degree longitudinal waves (UTOL) for detection of laminar reflectors which affect interpretation of the angle-beam results.

3.3.11 The elbow-to-safe end and safe end-to-nozzle welds will be examined from the nozzle/pipe bore with search units producing 0-degree longitudinal waves (UTOW) for detection of reflectors in the weld and adjacent base material.

3.3.12 The elbow-to-safe end and safe end-to-nozzle welds will be examined from the nozzle/pipe bore with search units producing 45 ±2-degree and 60 ±2-degree shear waves (UT45 and UT60) for detection of reflectors oriented parallel with the weld and adjacent base material.

3.3.13 The elbow-to-safe end and safe end-to-nozzle welds will be examined from the nozzle/pipe bore with search units producing 45 ±2-degree shear waves (UT45T) for the detection of reflectors oriented transverse to the weld and adjacent base material.

3.3.14 The vessel-to-flange weld will be examined from the vessel seal surface with search units producing 1.5-degree, 5.7-degree and 12.5-degree refracted longitudinal waves for detection of reflectors in the weld and adjacent base material.

3.3.15 The nozzle-to-safe end and safe end-to-pipe welds will be examined from the nozzle/pipe bore with 50/70-degree refracted longitudinal waves to detect underclad cracking and flaws in the lower one-third area of the weld and adjacent base material.

- X-Function. The mechanical device used to move the module axially to the weld.
- Y-Function. The mechanical device used to move the module perpendicular to the weld.
- Dir. Direction of scan movement.
- Y-Pos. The Y-mechanical device readout counts for each scan when scanning axially to the weld.
- X-Start/X-Stop. The scan limits defining the start and stop counts on the X-mechanical device readouts for each scan when scanning axially to the weld.
- X-Pos. The X-mechanical device readout counts for each scan when scanning perpendicular to the weld.
- Y-Start/Y-Stop. The scan limits defining the start and stop counts on the Y-mechanical device readouts for each scan when scanning perpendicular to the weld.

3. GENERAL EXAMINATION TECHNIQUES

3.1 Scan Increments

During the mechanized ultrasonic examination scans, a minimum overlap of 25 percent will be used with SwRI Procedures NDT-700-10 and 700-11. Search units used during the examination will have the following maximum scan increments.

Search Unit Size	Maximum Scan Increment
1.00" (1"0	0.75"
0.75" (3/4")	0.56"
0.50" (1/2")	0.37"

NOTE: For the 50/70-degree inside radius examination from the inlet nozzle bore, the increment will be 0.10 inch.

3.2 Angle Designations

For the purpose of this Scan Plan, unless otherwise indicated, angles between 40 and 60 degrees shall be refracted shear waves, and other angles shall be straight-beam or refracted longitudinal waves.

3.3 Examination Methods

Ultrasonic examination methods to be used are as follows:

3.3.1 The circumferential, meridional, and longitudinal welds will be examined from the vessel wall with search units producing 0-degree longitudinal waves (UTOL) for detection of laminar reflectors which affect interpretation of the angle-beam results.

3.3.2 The circumferential, meridional, and longitudinal welds will be examined from the vessel wall with search units producing 0-degree longitudinal waves (UTOW) for detection of reflectors in the weld and adjacent base material.

3.3.3 The circumferential, meridional, and longitudinal welds will be examined from the vessel wall with search units producing 45 ±2-degree and 60 ±2-degree shear waves (UT45 and UT60) for detection of reflectors oriented parallel with the weld and adjacent base material.

3.3.4 The circumferential, longitudinal, meridional, and nozzle-to-shell welds will be examined from the vessel wall with search units producing 45 ±2-degree and 60 ±2-degree shear waves (UT45T and UT60T) for detection of reflectors oriented transverse to the weld and adjacent base material.

4. DEVICE CONFIGURATION PLAN

4.1 PaR Device

4.1.1 Guide Pin Location

(1) The PaR Device shall be positioned using guide pins installed in stud holes No. 44 (206.6°) and 12 (343.3°). Stud hole No. 1 is at 270°.

(2) The ultrasonic target shall be located on the foot of the PaR Device, which is placed over the guide pin in stud hole No. 12 so that the target center is 8 inches above the surface of the vessel stud flange surface.

4.1.2 PaR Hoist Reference

The vertical "zero reference" position of the PaR Device hoist shall be the vessel stud flange surface which is 8 inches below the center of the ultrasonic target.

4.1.3 Vessel and PaR Device Boom Rotate 0-Degree Reference

Vessel 0-degree coincides with the centerline of the ligament between studs Nos. 14 and 15 which, viewed from above the vessel, is 16.69 degrees clockwise from the ultrasonic target center.

4.1.4 Horizontal Boom Zero Reference

The horizontal boom zero reference is 45 inches from the outer edge of the boom flange face to the centerline of the PaR Device Vertical Mast Assembly. This dimension will be fixed with the horizontal boom fully retracted (00000 count).

4.1.5 Pivot Boom Zero Reference

The pivot boom zero reference position is 90 degrees from the PaR Device vertical mast assembly.

4.1.6 Nozzle Horizontal Boom Dimensions at 0 (Zero) Count

(1) The outer measurement of the nozzle slide assembly is 76 inches.

(2) The module pivot point of the nozzle slide assembly when attached to the horizontal boom is 73 inches from vertical mast centerline.

4.2 Device Configurations (Illustrated in Appendix F, Volume III)

(1) The Seam Weld Inspection Assembly is attached to the Pivot Boom with the SwRI Rotator for examination of the lower head-to-lower shell weld, the meridional welds, and the lower head-dome weld.

(2) The Seam Weld Inspection Assembly is attached to the Horizontal Boom with the SwRI Rotator for all examinations from the vessel wall except those welds listed in configuration No. 1.

(3) The Nozzle Inner Bore Assembly is attached to the Horizontal Boom with the SwRI Rotator for all examinations from the inlet and outlet nozzle bore.

(4) The Flange Inspection Assembly is attached to the Horizontal Boom with the SwRI Rotator for examination of the vessel-to-flange weld from the flange seal surface area.

5. IMPLEMENTATION

The Scan Plan shall be implemented as written and approved. It should be recognized that onsite conditions may necessitate changes from the Scan Plan. Changes may include but are not limited to PaR Device configuration, examination sequence, or gate changes. Any changes to the examination requirements, examination coverage, or calibration requirements shall be reviewed and approved by the Manager of the Mechanized and Automated Examination Section, or his designated representative, and a representative of Public Service electric and Gas Company.

It will be the responsibility of the mechanized examination team supervisor to implement the requirements of this Scan Plan and to assure that necessary modifications and/or deviations are documented according to Paragraph 1.2.3.

APPENDIX A

PARAMETER RECORDS, EXAMINATION TABLES, AND PaR SCAN SHEETS

APPENDIX A

PARAMETER RECORDS, EXAMINATION TABLES, AND PaR SCAN SHEETS

Index

Exam No.	Examination Area	Exam Angle	Module Config.	Beam Component
1	Meridional Weld 1-RPV-1043C @ 30°	0,45,60,50/70	50B	CCW
2	Meridional Weld 1-RPV-1043C @ 30°	0,45,60,50/70	50D	CW
3	Meridional Weld 1-RPV-1043C @ 30°	0,45T,60T,50/70T	50C	UP
4	Meridional Weld 1-RPV-1043C @ 30°	0,45T,60T,50/70T	50A	DN
5	Meridional Weld 1-RPV-1043D @ 90°	0,45,60,50/70	50B	CCW
6	Meridional Weld 1-RPV-1043D @ 90°	0,45,60,50/70	50D	CW
7	Meridional Weld 1-RPV-1043D @ 90°	0,45T,60T,50/70T	50C	UP
8	Meridional Weld 1-RPV-1043D @ 90°	0,45T,60T,50/70T	50A	DN
9	Meridional Weld 1-RPV-1043E @ 150°	0,45,60,50/70	50B	CCW
10	Meridional Weld 1-RPV-1043E @ 150°	0,45,60,50/70	50D	CW
11	Meridional Weld 1-RPV-1043E @ 150°	0,45T,60T,50/70T	50C	UP
12	Meridional Weld 1-RPV-1043E @ 150°	0,45T,60T,50/70T	50A	DN
13	Meridional Weld 1-RPV-1043F @ 210°	0,45,60,50/70	50B	CCW
14	Meridional Weld 1-RPV-1043F @ 210°	0,45,60,50/70	50D	CW
15	Meridional Weld 1-RPV-1043F @ 210°	0,45T,60T,50/70T	50C	UP
16	Meridional Weld 1-RPV-1043F @ 210°	0,45T,60T,50/70T	50A	DN
17	Meridional Weld 1-RPV-1043A @ 270°	0,45,60,50/70	50B	CCW
18	Meridional Weld 1-RPV-1043A @ 270°	0,45,60,50/70	50D	CW
19	Meridional Weld 1-RPV-1043A @ 270°	0,45T,60T,50/70T	50C	UP
20	Meridional Weld 1-RPV-1043A @ 270°	0,45T,60T,50/70T	50A	DN
21	Meridional Weld 1-RPV-1043B @ 330°	0,45,60,50/70	50B	CCW
22	Meridional Weld 1-RPV-1043B @ 330°	0,45,60,50/70	50D	CW
23	Meridional Weld 1-RPV-1043B @ 330°	0,45T,60T,50/70T	50C	UP
24	Meridional Weld 1-RPV-1043B @ 330°	0,45T,60T,50/70T	50A	DN
25	Lower Head-Dome Weld 1-RPV-4043	0,45,60,50/70	50A	DN
26	Lower Head-Dome Weld 1-RPV-4043	0,45,60,50/70	50C	UP
27	Lower Head-Dome Weld 1-RPV-4043	0,45T,60T,50/70T	50D	CW
28	Lower Head-Dome Weld 1-RPV-4043	0,45T,60T,50/70T	50B	CCW
29	Lower Shell-Lower Head Weld 1-RPV-10042	0,45,60,50/70	50A	DN
30	Lower Shell-Lower Head Weld 1-RPV-10042	0,45,60,50/70	50C	UP
31	Lower Shell-Lower Head Weld 1-RPV-10042	0,45T,60T,50/70T	50D	CW
32	Lower Shell-Lower Head Weld 1-RPV-10042	0,45T,60T,50/70T	50B	CCW
33	Middle-Lower Shell Weld 1-RPV-9042	0,45,60,50/70	50A	DN
34	Middle-Lower Shell Weld 1-RPV-9042	0,45,60,50/70	50C	UP
35	Middle-Lower Shell Weld 1-RPV-9042	0,45T,60T,50/70T	50D	CW
36	Middle-Lower Shell Weld 1-RPV-9042	0,45T,60T,50/70T	50B	CCW
37	Lower Shell Weld 1-RPV-3042B @ 105°	0,45,60,50/70	50B	CCW
38	Lower Shell Weld 1-RPV-3042B @ 105°	0,45,60,50/70	50D	CW
39	Lower Shell Weld 1-RPV-3042B @ 105°	0,45T,60T,50/70T	50C	UP
40	Lower Shell Weld 1-RPV-3042B @ 105°	0,45T,60T,50/70T	50A	DN
41	Lower Shell Weld 1-RPV-3042C @ 225°	0,45,60,50/70	50B	CCW
42	Lower Shell Weld 1-RPV-3042C @ 225°	0,45,60,50/70	50D	CW
43	Lower Shell Weld 1-RPV-3042C @ 225°	0,45T,60T,50/70T	50C	UP

APPENDIX A

PARAMETER RECORDS, EXAMINATION TABLES, AND PaR SCAN SHEETS

Index (Cont'd)

Exam No.	Examination Area	Exam Angle	Module Config.	Beam Component
44	Lower Shell Weld 1-RPV-3042C @ 225°	0,45T,60T,50/70T	50A	DN
45	Lower Shell Weld 1-RPV-3042A @ 345°	0,45,60,50/70	50B	CCW
46	Lower Shell Weld 1-RPV-3042A @ 345°	0,45,60,50/70	50D	CW
47	Lower Shell Weld 1-RPV-3042A @ 345°	0,45T,60T,50/70T	50C	UP
48	Lower Shell Weld 1-RPV-3042A @ 345°	0,45T,60T,50/70T	50A	DN
49	Middle Shell Weld 1-RPV-2042B @ 60°	0,45,60,50/70	50B	CCW
50	Middle Shell Weld 1-RPV-2042B @ 60°	0,45,60,50/70	50D	CW
51	Middle Shell Weld 1-RPV-2042B @ 60°	0,45T,60T,50/70T	50C	UP
52	Middle Shell Weld 1-RPV-2042B @ 60°	0,45T,60T,50/70T	50A	DN
53	Middle Shell Weld 1-RPV-2042C @ 180°	0,45,60,50/70	50B	CCW
54	Middle Shell Weld 1-RPV-2042C @ 180°	0,45,60,50/70	50D	CW
55	Middle Shell Weld 1-RPV-2042C @ 180°	0,45T,60T,50/70T	50C	UP
56	Middle Shell Weld 1-RPV-2042C @ 180°	0,45T,60T,50/70T	50A	DN
57	Middle Shell Weld 1-RPV-2042A @ 300°	0,45,60,50/70	50B	CCW
58	Middle Shell Weld 1-RPV-2042A @ 300°	0,45,60,50/70	50D	CW
59	Middle Shell Weld 1-RPV-2042A @ 300°	0,45T,60T,50/70T	50C	UP
60	Middle Shell Weld 1-RPV-2042A @ 300°	0,45T,60T,50/70T	50A	DN
61	Upper-Middle Shell Weld 1-RPV-8042	0,45,60,50/70	50A	DN
62	Upper-Middle Shell Weld 1-RPV-8042	0,45,60,50/70	50C	UP
63	Upper-Middle Shell Weld 1-RPV-8042	0,45T,60T,50/70T	50D	CW
64	Upper-Middle Shell Weld 1-RPV-8042	0,45T,60T,50/70T	50B	CCW
65	Vessel-Flange Weld 1-RPV-7042	0,45,60,50/70	50C	UP
66A	Vessel-Flange Weld 1-RPV-7042	0,45T,60T,50/70T	50D	CW
66B	Vessel-Flange Weld 1-RPV-7042	0,45T,60T,50/70T	50D	CW
67A	Vessel-Flange Weld 1-RPV-7042	0,45T,60T,50/70T	50B	CCW
67B	Vessel-Flange Weld 1-RPV-7042	0,45T,60T,50/70T	50B	CCW
68	Upper Shell Weld 1-RPV-1042B @ 7°	0,45,60,50/70	50D	CW
69	Upper Shell Weld 1-RPV-1042B @ 7°	0,45,60,50/70	50B	CCW
70	Upper Shell Weld 1-RPV-1042B @ 7°	0,45T,60T,50/70T	50C	UP
71	Upper Shell Weld 1-RPV-1042B @ 7°	0,45T,60T,50/70T	50A	DN
72	Upper Shell Weld 1-RPV-1042C @ 127°	0,45,60,50/70	50D	CW
73	Upper Shell Weld 1-RPV-1042C @ 127°	0,45,60,50/70	50B	CCW
74	Upper Shell Weld 1-RPV-1042C @ 127°	0,45T,60T,50/70T	50C	UP
75	Upper Shell Weld 1-RPV-1042C @ 127°	0,45T,60T,50/70T	50A	DN
76	Upper Shell Weld 1-RPV-1042A @ 247° above nozzle	0,45,60,50/70	50D	CW
77	Upper Shell Weld 1-RPV-1042A @ 247° above nozzle	0,45,60,50/70	50B	CCW
78	Upper Shell Weld 1-RPV-1042A @ 247° above nozzle	0,45T,60T,50/70T	50C	UP
79	Upper Shell Weld 1-RPV-1042A @ 247° above nozzle	0,45T,60T,50/70T	50A	DN

APPENDIX A

PARAMETER RECORDS, EXAMINATION TABLES, AND PaR SCAN SHEETS

Index (Cont'd)

Exam No.	Examination Area	Exam Angle	Module Config.	Beam Component
80	Outlet Shell-to-Nozzle (Computer) 29-RPV-1140-1 @ 22°	0,45T,60T,50/70T	10B	CW
81	Outlet Shell-to-Nozzle (Computer) 29-RPV-1140-1 @ 22°	0,45T,60T,50/70T	11B	CCW
82	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1140-1 @ 67°	0,45T,60T,50/70T	10B	CW
83	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1140-1 @ 67°	0,45T,60T,50/70T	11B	CCW
84	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1130-1 @ 113°	0,45T,60T,50/70T	10B	CW
85	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1130-1 @ 113°	0,45T,60T,50/70T	11B	CCW
86	Outlet Shell-to-Nozzle (Computer) 29-RPV-1130-1 @ 158°	0,45T,60T,50/70T	10B	CW
87	Outlet Shell-to-Nozzle (Computer) 29-RPV-1130-1 @ 158°	0,45T,60T,50/70T	11B	CCW
88	Outlet Shell-to-Nozzle (Computer) 29-RPV-1110-1 @ 202°	0,45T,60T,50/70T	10B	CW
89	Outlet Shell-to-Nozzle (Computer) 29-RPV-1110-1 @ 202°	0,45T,60T,50/70T	11B	CCW
90	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1110-1 @ 247°	0,45T,60T,50/70T	10B	CW
91	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1110-1 @ 247°	0,45T,60T,50/70T	11B	CCW
92	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1120-1 @ 293°	0,45T,60T,50/70T	10B	CW
93	Inlet Nozzle-to-Shell (Computer) 27.5-RPV-1120-1 @ 293°	0,45T,60T,50/70T	11B	CCW
94	Outlet Shell-to-Nozzle (Computer) 29-RPV-1120-1 @ 338°	0,45T,60T,50/70T	10B	CW
95	Outlet Shell-to-Nozzle (Computer) 29-RPV-1120-1 @ 338°	0,45T,60T,50/70T	11B	CCW
96	Inlet Nozzle-to-Shell (Bore) 27.5-RPV-1140-1 @ 67°	6°,45°,50/70	12	To Vessel C/L
97	Inlet Nozzle-to-Shell (Bore) 27.5-RPV-1140-1 @ 67°	50/70T	12A	CW/CCW
98	Inlet Nozzle-to-Shell (Bore) 27.5-RPV-1130-1 @ 113°	6°,45°,50/70	12	To Vessel C/L
99	Inlet Nozzle-to-Shell (Bore) 27.5-RPV-1130-1 @ 113°	50/70T	12A	CW/CCW
100	Inlet Nozzle-to-Shell (Bore) 27.5-RPV-1110-1 @ 247°	6°,45°,50/70	12	To Vessel C/L

EXAM.NO. 1

SCAN PLAN PARAMETER SHEET

SITE SALEM 1 PROJECT NO. 17-1532

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1532
3.EXAM NO.=1
4.WELD NO.=1-RPV-1043C
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @30 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSKC052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=30
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 DJK
5. X-STOP POS.=~~16.37~~ 20.07 DJK
6.WELD LENGTH=139
7.BEAM COMP.(CCW=0,CW=1)=0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=305

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.84 DEGREES PER INCH= .54

Completed 17 Nov 87 DJK

EXAM NO: 1

BWRI SCAN PLAN ENGINEERING SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1562 SCAN PLAN BY: [illegible]
COMPONENT RPV SUBASSEMBLY MERID 030 DEG WELD NO. 1-RPV-1 OR 2
TRACEABLE/REV.DEV 700-11/7 WELD TYPE MERIDIONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-OSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. 5/3MC2266

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.53
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.6

GATE SETTINGS		
SCAN	START	STOP
1-14	2	17 → 12 (SS)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5	~~5.0~~ 6

NAK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	1.50 IN.

MODULE CONFIGURATION NO. 30B

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME CALEY 1 PROJECT NO. 17-1822 TIME 1138 DATE 1 NOV 87

UNIT NO. 1 OPERATOR(S) J. ALEJANDRO (P. GAINES) WELD NO. 1-RW-1-102

PARAMETERS

WELD LOC. C8 VESSEL DIA. 174 WALL THICKNESS 6

SCAN INC.(IN.) .75 CTS..46 WELD LENGTH 139 HOIST POS. 111.175

X-FUNCTION PIVOT SWRI ROTATOR 9000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	2838	3890	
2	CCW	1085	3890	2838	
3	CW	1133	2838	3890	
4	CCW	1181	3890	2838	
5	CW	1229	2838	3890	Restart due to poor contact @
6	CCW	1277	3090	2838	Restarted @ scan 4 @
7	CW	1325	2838	3890	
8	CCW	1373	3890	2838	
9	CW	1421	2838	3890	
10	CCW	1469	3890	2838	
11	CW	1517	2838	3890	
12	CCW	1565	3890	2838	
13	CW	1613	2838	3890	
14	CCW	1661	3890	2838	

REVIEWED BY Carla M Barnes (LEVEL II) DATE (01 Nov, 87)

@	15 CW	1709	2838	3890
@	16 CCW	1757	3890	2838
@	17 CW	1805	2838	3890
@	18 CCW	1853	3890	2838
@	19 CW	1901	2838	3890
@	20 CCW	1949	3890	2838
@	21 CW	2007	2838	3890

EXAM.NO. 2

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=2
4.WELD NO.=1-RPV-1043C
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @30 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=30
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 BMF
5. X-STOP POS.=~~16.37~~ 20.07 BMF
6.WELD LENGTH=139
7.BEAM COMP.(CCW=0,CW=1)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.62
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .6[illegible]

Completed 1 Nov 87 BMF

EXAM NO. 2

SNAI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DS/DTSE 7-1
COMPONENT RPV SUBASSEMBLY MERID @30 DEG WELD NO. 3-RPV-10-TC
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERIDONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-CSDL-42-8A4 DEVICE DWG.NO./CONFIG.NO. STD-E2111

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	1.75
2/8	/	3.5
3/8	/	5.2
NOTCH	/	7
5/8	/	8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE.IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.55
2/8	/	5
3/8	/	7.5
NOTCH	/	10
5/8	/	12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	~~17~~ 12 (JK)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		
1/8	/	1.25
2/8	/	2.5
3/8	/	3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5	~~5~~ 6 (NK)

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.500

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME: 1409 DATE 1 Nov 87

SCAN I.D. 2 OPERATOR(S) P. CAINES WELD NO. 1 PT. 1

PARAMETERS

WELD LOC. IC VESSEL DIA. 176 WALL THICKNESS 6
SCAN INC.(IN.) .75 CT3..48 WELD LENGTH 139 HOIST POS. 300.375
X-FUNCTION PIVOT SWRI ROTATOR 27000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	2175	3223	Scans 1 to 3 deleted due to rough surface. (P2)
2	CCW	1085	3228	2175	
3	CW	1133	2175	3228	
4 (P2)	CCW	1181	3228	2175	
5 (P2)	CW	1229	2175	3228	
6 (P2)	CCW	1277	3228	2175	
7 (P2)	CW	1325	2175	3228	
8 (P2)	CCW	1373	3228	2175	
9 (P2)	CW	1421	2175	3228	
10 (P2)	CCW	1469	3228	2175	
11 (P2)	CW	1517	2175	3228	
12 (P2)	CCW	1565	3228	2175	
13 (P2)	CW	1613	2175	3228	
14 (P2)	CCW	1661	3228	2175	

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (01 Nov 87)

15 (P2)	CW	1709	2175	3228
16 (P2)	CCW	1757	3228	2175
17 (P2)	CW	1805	2175	3228
18 (P2)	CCW	1853	3228	2175
19 (P2)	CW	1901	2175	3228
20 (P2)	CCW	1949	3228	2175
21 (P2)	CW	2007	2175	3228

(P2)

EXAM.NO. 3

SWRI SCAN PLAN PARAMETER FORMAT

SITE NAME SALEM 1 PROJECT NO. 17-1352

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1352
3. EXAM NO.=3
4. WELD NO.=1-RPV-104JC
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @30 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-DSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=30
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10.~~84~~ OK
5. X-STOP POS.=~~23.84~~ 27.00 OK
6. WELD LENGTH=69.27
7. BEAM DIR.(DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=93.82
10. LOWER HEAD RADIUS(IN.)=89.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=305

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

Completed 1 Nov 87 BK

EXAM NO. 3

[illegible]

[illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5	1-20	2	10
3/8	/ 5.2			
NOTCH	/ 7			
5/8	/ 8.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.65	SCAN	START	STOP
2/8	/ 5	1-20	2	12
3/8	/ 7.5			
NOTCH	/ 10			
5/8	/ 12.5			

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5	1-20	1.5	~~5~~ 6
3/8	/ 3.7			

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-20	1 DIV.	7 DIV.
3	/ 4 DIV.			
4	/ 5 DIV.			
5	/ 6 DIV.			

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 300

SINGLE PIPE SCAN SHEET

SITE NAME (BLDG.) _____ PROJECT NO. (WORK REQUEST) NO. 1527 DATE 1 NOV 87

SCAN NO. 2 OPERATOR(S) P. GAINES N/A WELD NO. _____

PARAMETERS

WELD LOC. SR VESSEL DIA. 174 WALL THICKNESS .
SCAN DIR.(IN.) .75 STS..48 WELD LENGTH 69.27 NOZZ PROJ. ~~307.18~~ @ 307.18
X-FUNCTION PIVOT. SWRI ROTATOR 19000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	2577	10.84	~~23.56~~	27.00
2	UP	2625	~~23.56~~ 27.00	10.84	
3	DN	2673	10.84	~~23.56~~	27.00
4	UP	2721	~~23.56~~ 27.00	10.84	
5	DN	2769	10.84	~~23.56~~	27.00
6	UP	2817	~~23.56~~ 27.00	10.84	
7	DN	2865	10.84	~~23.56~~	27.00
8	UP	2913	~~23.56~~ 27.00	10.84	
9	DN	2961	10.84	~~23.56~~	27.00
10	UP	3009	~~23.56~~ 27.00	10.84	
11	DN	3057	10.84	~~23.56~~	27.00
12	UP	3105	~~23.56~~ 27.00	10.84	
13	DN	3153	10.84	~~23.56~~	27.00
14	UP	3201	~~23.56~~ 27.00	10.84	
15	DN	3249	10.84	~~23.56~~	27.00
16	UP	3297	~~23.56~~ 27.00	10.84	
17	DN	3345	10.84	~~23.56~~	27.00
18	UP	3393	~~23.56~~ 27.00	10.84	
19	DN	3441	10.84	~~23.56~~	27.00
20	UP	3489	~~23.56~~ 27.00	10.84	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(01 Nov 87)

EXAM.NO. 4

SWRI SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=4
4. WELD NO.=1-RPV-1043C
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @30 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=30
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~3.61~~ 4.05 DHK
5. X-STOP POS.=~~17.33~~ 21.00 DHK
6. WELD LENGTH=69.27
7. BEAM DIR.(DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

Completed 1 Nov 87 DHK

EXAM NO. 4

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1222 SCAN PATH BY: DEVICE(S):
COMPONENT REV. SUBASSEMBLY MARK NO 630 DEG WELD NO. 1-FW-10-3
PROCEDURE/REV/DATE 705-11/7 WELD TYPE MARK: SCAN TYPE PA/SHEAR
CAL.BLK.NO. E-0801-42-SAM DEVICE DWG.NO./SERIAL NO. DT1551.1

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.5E
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	12 OK

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5	~~5.56~~ RWK

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.123 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.5GA

SHEET NO. 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME 1605 DATE 1 Nov 87

EXAM NO. A OPERATOR(S) P. GAINES / J. ALEJANDRO WELD NO. 1-FW-41 (IP)

PARAMETERS

WELD LOC. ID VESSEL DIA. 174 WALL THICKNESS 8

SCAN INC.(IN.) .75 OTB..48 WELD LENGTH 62.27 OBJECT POS. ~~307.18~~ 307.18

X-FUNCTION PIVOT. SWRI ROTATOR 0 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	2577.	~~3.61~~ 4.05	~~17.33~~ 21.00	
2	UP	2625.	~~17.33~~ 21.00	~~3.61~~ 4.05	
3	DN	2673.	~~3.61~~ 4.05	~~17.33~~ 21.00	
4	UP	2721.	~~17.33~~ 21.00	~~3.61~~ 4.05	
5	DN	2769.	~~3.61~~ 4.05	~~17.33~~ 21.00	
6	UP	2817.	~~17.33~~ 21.00	~~3.61~~ 4.05	
7	DN	2865.	~~3.61~~ 4.05	~~17.33~~ 21.00	
8	UP	2913.	~~17.33~~ 21.00	~~3.61~~ 4.05	
9	DN	2961.	~~3.61~~ 4.05	~~17.33~~ 21.00	
10	UP	3009.	~~17.33~~ 21.00	~~3.61~~ 4.05	
11	DN	3057.	~~3.61~~ 4.05	~~17.33~~ 21.00	
12	UP	3105.	~~17.33~~ 21.00	~~3.61~~ 4.05	
13	DN	3153.	~~3.61~~ 4.05	~~17.33~~ 21.00	
14	UP	3201.	~~17.33~~ 21.00	~~3.61~~ 4.05	
15	DN	3249.	~~3.61~~ 4.05	~~17.33~~ 21.00	
16	UP	3297.	~~17.33~~ 21.00	~~3.61~~ 4.05	
17	DN	3345.	~~3.61~~ 4.05	~~17.33~~ 21.00	
18	UP	3393.	~~17.33~~ 21.00	~~3.61~~ 4.05	
19	DN	3441.	~~3.61~~ 4.05	~~17.33~~ 21.00	
20	UP	3489.	~~17.33~~ 21.00	~~3.61~~ 4.05	

REVIEWED BY Carl M Barnes (LEVEL II) DATE (01 Nov, 87)

EXAM.NO. 5

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=5
4. WELD NO.=1-RPV-1043D
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @90 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=90
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 DAK
5. X-STOP POS.=~~16.37~~ 20.07 DAK
6. WELD LENGTH=139
7. BEAM COMP.(CCW=0,CW=1)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=82.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

Completed 1/20/87 DAK

EXAM NO. 5

BASIC SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1550 SCAN DATE 5 / 28 / 87
COMPONENT RPV BLDG ASSEMBLY MERID 090 DEG WELD NO. 1-RPV-1 1/2
PROCEDURE/REV DEV 700-11.7 WELD TYPE MERIDONAL SCAN TYPE SINGLE
CAL.BLK.NO. 5-CBCL-12-SAM DEVICE DWG.NO./CONFIG.NO. 8011211

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	7 1/2 DLF

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1,5 DLF	5 6

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 502

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 1640 DATE 1 NOV 87

SCAN NO. 2 OPERATOR(S) JALEJANDRO N/A ILL [illegible]

PARAMETERS

WELD LOC. 90 VESSEL DIA. 174 WALL THICKNESS 8"
SCAN INC.(IN.) .75 STS..48 WELD LENGTH 139 HOIST POS. ~~SG1.1~~ 307.18
X-FUNCTION PIVOT SWRI ROTATOR 9000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	8837	9890	START @ SCAN 4 - 21"
2	CCW	1085	9890	8837	X = 1181 to 20.07"
3	CW	1133	8837	9890	
4	CCW	1181	9890	8837	
5	CW	1229	8837	9890	
6	CCW	1277	9890	8837	
7	CW	1325	8837	9890	
8	CCW	1373	9890	8837	
9	CW	1421	8837	9890	
10	CCW	1469	9890	8837	
11	CW	1517	8837	9890	
12	CCW	1565	9890	8837	
13	CW	1613	8837	9890	
14	CCW	1661	9890	8837	
15	CW	1709	8837	9890	
16	CCW	1757	9890	8837	
17	CW	1805	8837	9890	
18	CCW	1853	9890	8837	
19	CW	1901	8837	9890	
20	CCW	1949	9890	8837	
21	CW	2007	8837	9890	

REVIEWED BY (Carlos M Barrera) (LEVEL (II)) DATE (01 Nov 87)

CMB

EXAM.NO. 6

EVAL SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=6
4.WELD NO.=1-RPV-1043D
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @90 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=90
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 DNK
5. X-STOP POS.=~~16.37~~ 20.07 DNK
6.WELD LENGTH=139
7.BEAM COMP.(CCW=0,CW=1)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=323

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

Completed 17 Nov 87 DNK

EXAM NO. 6

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. 59X3.33? A
COMPONENT REV SUBASSEMBLY MERID @90 DEG WELD NO. 1-RPV-[illegible]
PROCEDURE/REV DEV 700-11/7 WELD TYPE MERIDONAL SCAN TYPE PARALLEL
CAL.BLK.NO. 5-CSCL-4C-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 9.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	~~17~~ 12

RLK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5	~~5.6~~

RLK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET 1 of 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1082 TIME: ~~1705~~ 1703 DATE: 1 NOV 87

SCAN NO. 6 OPERATOR(S) (JALEJANDRO) (N/A) WELD [illegible]

PARAMETERS

WELD LOC. 90 VESSEL DIA. 174 WALL THICKNESS .8

SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 139 HOIST POS. ~~307.18~~ 307.18

X-FUNCTION PIVOT SWRI ROTATOR 27000 Y-FUNCTION SCAN ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	8175	9228	Start @ scan 4, Run thru scan 20 X = 11.81 To 20.07
2	CCW	1085	9228	8175	
3	CW	1133	8175	9228	
4	CCW	1181 -	9228	8175	
5	CW	1229 -	8175	9228	
6	CCW	1277 -	9228	8175	
7	CW	1325 -	8175	9228	
8	CCW	1373 -	9228	8175	
9	CW	1421 -	8175	9228	
10	CCW	1469 -	9228	8175	
11	CW	1517 -	8175	9228	
12	CCW	1565 -	9228	8175	
13	CW	1613 -	9175	9228	
14	CCW	1661 -	9228	8175	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(02 Nov 87)

15	CW	1709	
16	CCW	1757	
17	CW	1805	
18	CCW	1853	(mg)
19	CW	1901	
20	CCW	1949	
21	CW	2007	

EXAM.NO. 7

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=7
4. WELD NO.=1-RPV-1043D
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID 090 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=90
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10.~~1484~~ DAK
5. X-STOP POS.=~~23.6827~~.00 DAK
6. WELD LENGTH=69.27
7. BEAM DIR.(DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.62
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=323

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

Completed 1/20/87 DAK

EXAM NO. 7

SWRI SCAN PLAN ELIMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1352 SCAN PATH SK. SK1310T
COMPONENT RPV SUBASSEMBLY MERID 090 DEG WELD NO. 1-RV
PROCEDURE/REV/DEV 700-1.7 WELD TYPE MERID. SCAN TYPE TRANSFER
CAL.BLK.NO. S-OSCL-42-SAM DEVICE INS.NO./CONFIG.NO. D70S1361

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	17 12 WK

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1,5 WK	5 6

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET 1 of 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1222 TIME 1734 DATE 1 NOV 87

SCAN NO. 1 OPERATOR(S) JALEJANDRO / N/A

PARAMETERS

WELD LOC. 90 VESSEL DIA. 174 WALL THICKNESS .5

SCAN INC.(IN.) .73 CTS. .48 WELD LENGTH 87.27 START POS. 360 CW

X-FUNCTION PIVOT SWRI ROTATOR 18000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	8577	10.14	23.86	X = 1084 - 2700 B
2	UP	8625	23.86	10.14	
3	DN	8673	10.14	23.86	
4	UP	8721	23.86	10.14	
5	DN	8769	10.14	23.86	
6	UP	8817	23.86	10.14	
7	DN	8865	10.14	23.86	
8	UP	8913	23.86	10.14	
9	DN	8961	10.14	23.86	
10	UP	9009	23.86	10.14	
11	DN	9057	10.14	23.86	
12	UP	9105	23.86	10.14	
13	DN	9153	10.14	23.86	
14	UP	9201	23.86	10.14	
15	DN	9249	10.14	23.86	
16	UP	9297	23.86	10.14	
17	DN	9345	10.14	23.86	
18	UP	9393	23.86	10.14	
19	DN	9441	10.14	23.86	
20	UP	9489	23.86	10.14	

REVIEWED BY Carlos M Bauer (LEVEL II) DATE (02 Nov 87)

EXAM.NO. 8

BARE SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=8
4.WELD NO.=1-RPV-1043D
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @90 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=90
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~3.61~~ 4.05 DSF
5. X-STOP POS.=~~17.33~~ 21.00 DSF
6.WELD LENGTH=69.27
7.BEAM DIR.(DN=1,UP=0)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=80.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

Completed 1/30/87 DSK

EXAM NO. 6

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1302 SCAN PATH SK. DESCRIPTION
COMPONENT RPV SUBASSEMBLY MERID 090 DEG WELD NO. 1-RPV-11 TO
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 5-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DEVICE

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.35
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	12 RVK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5	5.6 RVK

INST.NO.4 / 30/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 3

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.30A

SHEET [illegible]

SWRI PAR SCAN SHEET

SITE VAPE SALEM 1 PROJECT NO. 17-1532 TIME(1750 DATE(1 NOV.87

SCAN NO. 8 OPERATOR(S) (J.ALEJANDRO ; N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 90 VESSEL DIA. 174 WALL THICKNESS = 11

SCAN INC.(IN.) .75 CTS..40 WELD LENGTH 87.27 HOIST POS. ~~[illegible]~~ 307.18

X-FUNCTION PIVOT. SWRI ROTATOR 0 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	8577	3.61	17.33	X = 4.05 - 21.00 IN
2	UP	8625	17.33	3.61	
3	DN	8673	3.61	17.33	
4	UP	8721	17.33	3.61	
5	DN	8769	3.61	17.33	
6	UP	8817	17.33	3.61	
7	DN	8865	3.61	17.33	
8	UP	8913	17.33	3.61	
9	DN	8961	3.61	17.33	
10	UP	9009	17.33	3.61	
11	DN	9057	3.61	17.33	
12	UP	9105	17.33	3.61	
13	DN	9153	3.61	17.33	
14	UP	9201	17.33	3.61	
15	DN	9249	3.61	17.33	
16	UP	9297	17.33	3.61	
17	DN	9345	3.61	17.33	
18	UP	9393	17.33	3.61	
19	DN	9441	3.61	17.33	
20	UP	9489	17.33	3.61	

REVIEWED BY Edson M Barrera (LEVEL(II) DATE(02 Nov 87)

EXAM.NO. 9

BARE SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=9
4. WELD NO.=1-RPV-1043E
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @150 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=D8K3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=150
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 BMK
5. X-STOP POS.=16.37 20.07 BMK
6. WELD LENGTH=139
7. BEAM COMP.(CCW=0,CW=1)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 1 Nov. 1987

INCHES PER DEGREE= 1.31 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 9

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH S.G. DISCHARGE NOZZLE
COMPONENT RPV SUBASSEMBLY MERID @130 DEG WELD NO. 1-RPV-11 ID
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERIDONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. D10E1564

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.3

GATE SETTINGS		
SCAN	START	STOP
1-14	2	~~10~~ 12 RWK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1,5 RWK	~~5.5~~ 6

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 505

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2057 DATE 1 NOV 87

SCAN NO. 7 OPERATOR(S) JALEJANDRO / L.R. MATHENA WELD ID. 1-RPV-1-101

PARAMETERS

WELD LOC. 150 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC.(IN.) .75 CTE..48 WELD LENGTH 139 JOIST POS. 306.172
X-FUNCTION PIVOT SWRI ROTATOR 9000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1057	14837	15890 ✓	due to poor contact ERNST
2	CCW	1085	15890	14837 ✓	FIRST 3 SCAN NOT RUN.
3	CW	1133	14837	15890 ✓	SCAN 1 STARTED @ 11.81 TO 20.07
4	CCW	1181	15890	14837 ✓	
5	CW	1229	14837	15890 ✓	
6	CCW	1277	15890	14837 ✓	
7	CW	1325	14837	15890 ✓	
8	CCW	1373	15890	14837 ✓	
9	CW	1421	14837	15890 ✓	
10	CCW	1469	15890	14837 ✓	
11	CW	1517	14837	15890 ✓	
12	CCW	1565	15890	14837 ✓	
13	CW	1613	14837	15890 ✓	
14	CCW	1661	15890	14837 ✓	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (02 Nov 87)

15	CW	1709	CMS
16	CCW	1757	
17	CW	1805	
18	CCW	1853	
19	CW	1901	
20	CCW	1949	
21	CW	2007	

EXAM.NO. 10

EWRI SCAN PLAN PARAMETER FEEDBACK

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=10
4.WELD NO.=1-RPV-104JE
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @150 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CECL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=150
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 ADK
5. X-STOP POS.=16.37 20.07 ADK
6.WELD LENGTH=139
7.BEAM COMP.(CCW=0,CW=1)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 1 Nov. 1987

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 10

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SW. CENTERLINE
COMPONENT RPV SUBASSEMBLY MERID @ 150 DEG WELD NO. 1-RPV-1 TO
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERIDIONAL SCAN TYPE 0 & AXIAL
CAL.BLK.NO. S-OSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DOUBLE

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5	1-14	2	10
3/8	/ 5.2			
NOTCH	/ 7			
5/8	/ 8.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.35	SCAN	START	STOP
2/8	/ 5	1-14	2	12
3/8	/ 7.3			
NOTCH	/ 10			
5/8	/ 12.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5	1-14	1.5	~~5.56~~
3/8	/ 3.7			

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-14	1 DIV.	7 DIV.
3	/ 4 DIV.			
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.30 IN.

MODULE CONFIGURATION NO.500

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME 2134 DATE 1 Nov 87

EXAM NO. IC OPERATOR(S) L.R. Mathena (N/A) WELD NO. 1-RPV-1-108

PARAMETERS

WELD LOC. 180 VESSEL DIA. 174 WALL THICKNESS 8
SCAN INC.(IN.) .75 DTS..46 WELD LENGTH 139 HOIST POS. 100.275
X-FUNCTION PIVOT SWRI ROTATOR 27000 Y-FUNCTION: 360M ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	14175	15227 ✓	
2	CCW	1085	15227	14175 ✓	
3	CW	1133	14175	15227 ✓	
4	CCW	1181	15227	14175 ✓	
5	CW	1229	14175	15227 ✓	
6	CCW	1277	15227	14175 ✓	
7	CW	1325	14175	15227 ✓	
8	CCW	1373	15227	14175 ✓	
9	CW	1421	14175	15227 ✓	
10	CCW	1469	15227	14175 ✓	
11	CW	1517	14175	15227 ✓	
12	CCW	1565	15227	14175 ✓	
13	CW	1613	14175	15227 ✓	
14	CCW	1661	15227	14175 ✓	

4-21 SCAN ~~1-18~~ (CMB) x CTS 11.81 TO 20.07 CTS. CMB

PIVOT EXT. @ 4389

SCANS 1-3 NOT RUN DUE TO POOR CONTACT CMB

REVIEWED BY Carlos M Barrera (LEVEL II) DATE (02 Nov 87)

15	CW	1709	CMB
16	CCW	1757	
17	CW	1805	
18	CCW	1853	
19	CW	1901	
20	CCW	1949	
21	CW	2007	

EXAM.NO. 11

BWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1032

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=11
4.WELD NO.=1-RPV-1043E
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @150 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=150
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10.~~1484~~ OK
5. X-STOP POS.=~~23.26~~ 27.00 OK
6.WELD LENGTH=69.27
7.BEAM DIR.(DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 1 Nov 87

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 11

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT ID. 17-1332 SCAN PAT. BY. DEMICHELIS
COMPONENT ADV SUBASSEMBLY MERID @150 DEG WELD NO. 1-RT, 1-LT,
PROCEDURE/REV. DEV 730-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. 33-5111.1

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	12

12 OK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5	~~5.5~~ 6

OK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-10	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	+1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SNRI FAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME 2300 DATE 1 Nov 87

SCAN NO. 11 OPERATOR(S) L.R. MATHENA N/A WELD NO. 1-8 THRU 11

PARAMETERS

WELD LOC. 150 VESSEL DIA. 174 WALL THICKNESS .5
SCAN INC. (IN.) .75 CTS..48 WELD LENGTH 69.27 HOIST POS. 31.375
X-FUNCTION PIVOT. SNRI ROTATOR 18000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	14577	10.14	23.86	10.84 To 27.00 in X (HP)
2	UP	14625	23.86	10.14	
3	DN	14673	10.14	23.86	
4	UP	14721	23.86	10.14	
5	DN	14769	10.14	23.86	
6	UP	14817	23.86	10.14	
7	DN	14865	10.14	23.86	
8	UP	14913	23.86	10.14	
9	DN	14961	10.14	23.86	
10	UP	15009	23.86	10.14	
11	DN	15057	10.14	23.86	
12	UP	15105	23.86	10.14	
13	DN	15153	10.14	23.86	
14	UP	15201	23.86	10.14	
15	DN	15249	10.14	23.86	
16	UP	15297	23.86	10.14	
17	DN	15345	10.14	23.86	
18	UP	15393	23.86	10.14	
19	DN	15441	10.14	23.86	
20	LP	15489	23.86	10.14	

REVIEWED BY Carla M Barnes (LEVEL II) DATE (02 Nov 87)

EXAM.NO. 12

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=12
4.WELD NO.=1-RPV-1043E
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @150 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=150
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~3.61~~ ~~4.05~~ OK ~~10.84~~ 13.00 JS
5. X-STOP POS.=~~17.33~~ 21.00 OK
6.WELD LENGTH=69.27
7.BEAM DIR.(DN=1,UP=0)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.62
10.LOWER HEAD RADIUS(IN.)=83.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 Nov. 87 JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 12

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME CALCM 1 PROJECT NO. 17-1532 SCAN PATH SK. DENTICITY
COMPONENT APV SUBASSEMBLY MERID @130 DEG WELD NO. 1-TP/1-PLATE
PROCEDURE/REV.DE/ 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. D0056L68

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5			
3/8	/ 5.2	1-20	2	10
NOTCH	/ 7			
5/8	/ 8.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.53	SCAN	START	STOP
2/8	/ 5			
3/8	/ 7.5	1-20	2	1/2 PEAK
NOTCH	/ 10			
3/8	/ 12.5			

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INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5			
3/8	/ 3.7	1-20	1.5 PEAK	~~5.5~~ 6

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-20	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1350 TIME(1155) DATE(2 Nov 87

EXAM(C, I) OPERATOR'S L.R. MATHENA N/A WELD NO. 1-RT-FW

PARAMETERS

WELD LOC. ISC VESSEL DIA. 174 WALL T-ICI VESS =
SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 69.27 HOIST POS. 316.5TC
X-FUNCTION PIVOT. SWRI ROTATOR 0 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	14577 ✓	3.61	17.33	
2	UP	14625 ✓	17.33	3.61	~~4.05 TO 21.00 X CTS.~~
3	DN	14673 ✓	3.61	17.33	
4	UP	14721 ✓	17.33	3.61	
5	DN	14769 ✓	3.61	17.33	13.00 TO 21.00 X CTS.
6	UP	14817 ✓	17.33	3.61	
7	DN	14865 ✓	3.61	17.33	
8	UP	14913 ✓	17.33	3.61	
9	DN	14961 ✓	3.61	17.33	
10	UP	15009 ✓	17.33	3.61	
11	DN	15057 ✓	3.61	17.33	
12	UP	15105 ✓	17.33	3.61	
13	DN	15153 ✓	3.61	17.33	
14	UP	15201 ✓	17.33	3.61	
15	DN	15249 ✓	3.61	17.33	
16	UP	15297 ✓	17.33	3.61	
17	DN	15345 ✓	3.61	17.33	
18	UP	15393 ✓	17.33	3.61	
19	DN	15441 ✓	3.61	17.33	
20	UP	15489 ✓	17.33	3.61	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(02 Nov 87)

EXAM.NO. 13

BWRI SCAN PLAN PARAMETER PROFILE

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=13
4. WELD NO.=1-RPV-1043F
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @210 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=210
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~16.27~~ 11.81 DSK
5. X-STOP POS.=~~16.27~~ 20.07 DSK
6. WELD LENGTH=139
7. BEAM COMP.(CCW=0,CW=1)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=96.92
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 NOV 87 (JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 13

BASIC SCAN PLAN EXAMINATION TABLE

SITE NAME BALL 1 PROJECT NO. 7-1002 SCAN PERF BY: DELOITTE
COMPONENT RF/ SUBASSEMBLY MERID @210 DEG WELD NO. 1-RPV 1107
MATERIAL/REF DEV 700-11/7 WELD TYPE MERIDIONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-CECL-42-SAM DEVICE DWG.NO./CONFIG.NO. DELOITTE

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	12

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5	~~5.5~~ 6.0

(12)

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 509

SWRI PAR SCAN SHEET

SITE NAME SILEX I PROJECT NO. 17-1552 TI = 0020.50 DATE 2 NOV 87

SCAN NO. 15 OPERATOR P.C. TURNER N/A

PARAMETERS

WELD LOC. 2&3 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC. (IN.) .75 CTS. 48 WELD LENGTH 139 MOIST POL. FILTER
X-FUNCTION PIVOT SWRI ROTATOR 9000 Y-FUNCTION DRUM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	20837	21890	1-3 NOT RUN, TRANSITION, Lower shell, Lower Lead
2	CCW	1085	21890	20837	11.81 TO 20.07 X CTS.
3	CW	1133	20837	21890	
4	CCW	1181 ✓	21890	20837	
5	CW	1229 ✓	20837	21890	
6	CCW	1277 ✓	21890	20837	
7	CW	1325 ✓	20837	21890	
8	CCW	1373 ✓	21890	20837	
9	CW	1421 ✓	20837	21890	
10	CCW	1469 ✓	21890	20837	
11	CW	1517	20837	21890	
12	CCW	1565	21890	20837	
13	CW	1613	20837	21890	
14	CCW	1661	21890	20837	
15	CW	1709			
16	CCW	1757			
17	CW	1805			
18	CCW	1853			
19	CW	1901			
20	CCW	1949			
21	CW	2007			

REVIEWED BY: (Carter M Barnes) (LEVEL: II) DATE: 02 Nov 87

EXAM.NO. 14

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=14
4. WELD NO.=1-RPV-1043F
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @210 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=210
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.77~~ 11.81 DWK
5. X-STOP POS.=~~16.77~~ 20.07 DWK
6. WELD LENGTH=139
7. BEAM COMP.(CCW=0,CW=1)=1
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=98.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 Nov 87

(15)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 14

EVERI SCAN PLAN EXAMINATION TABLE

SITE LAKE ERIE 1 PROJECT NO. 17-1553 SCAN PATH BM. CENTERLINE
COMPONENT ID. SUBASSEMBLY MERID 0210 DEG WELD NO. 1 CRV-1041
MODEL/REV/DE/ 700-11/7 WELD TYPE MERIDIONAL SCAN TYPE [illegible]
CAL.BLK.NO. E-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5	1-14	2	10
3/8	/ 5.2			
NOTCH	/ 7			
5/8	/ 8.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.5	SCAN	START	STOP
2/8	/ 5	1-14	2	~~10~~ 12 JS
3/8	/ 7.5			
NOTCH	/ 10			
5/8	/ 12.5			

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5	1-14	1.5	~~5.5~~ 6.0 JS
3/8	/ 3.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-14	1 DIV.	7 DIV.
3	/ 4 DIV.			
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.500

SHEET 1 OF 1

SWRI FAP SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 09:43 DATE 2 NOV 87

EXAM NO. 14 OPERATOR(S) (P.P. TURNER) (N/A) WELD ID. 1-ST-1-87

PARAMETERS

WELD LOC. 210 VESSEL DIA. 174 WALL THICKNESS 8
SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 139 HOIST POS. 206.375
X-FUNCTION PIVOT SWRI ROTATOR 27000 Y-FUNCTION SCAN ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	20175	21227	SCAN 1-3 NOT RUN TAPER/TRANSITION (B)
2	CCW	1085	21227	20175	
3	CW	1133	20175	21227	
4	CCW	1181	21227	20175	
5	CW	1229	20175	21227	
6	CCW	1277	21227	20175	
7	CW	1325	20175	21227	
8	CCW	1373	21227	20175	
9	CW	1421	20175	21227	
10	CCW	1469	21227	20175	
11	CW	1517	20175	21227	
12	CCW	1565	21227	20175	
13	CW	1613	20175	21227	
14	CCW	1661	21227	20175	

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (02 Nov, 87)

15	CW	1709
16	CCW	1757
17	CW	1805
18	CCW	1853
19	CW	1901
20	CCW	1949
21	CW	2007

EXAM.NO. 15

S.R.I. SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=15
4. WELD NO.=1-RPV-1043F
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @210 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-DSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=210
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10.~~1~~ 84 OK
5. X-STOP POS.=~~27.38~~ 27.00 OK
6. WELD LENGTH=69.27
7. BEAM DIR.(DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=305

Y-CONVERSION PARAMETERS

Comp 2 Nov. 87

(15)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREE PER INCH= .64

EXAM NO. 15

SWRI SCAN PLAN EXAMINATION TITLE

SITE NAME SALEM 1 PROJECT NO. 17-1592 SCAN PATH DK. DEMONSTR.
COMPONENT RPV SUBASSEMBLY MERID 9210 DEG WELD NO. 1-RPV-LONGT
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO 8515224

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.35
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	7 (12)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5 (5.5)	6.0

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.30 IN.	+1.30 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 500

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1502 TAPE 119 DATE 2 NOV 87

EXAM NO. 15 OPERATOR(S) (P.C. TURNER) WELD NO. 1-88 [illegible]

PARAMETERS

WELD LOC. 21 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC.(IN.) .75 CTS. 48 WELD LENGTH 69.27 HOIST POS. 30[illegible].175
X-FUNCTION PIVOT. SWRI ROTATOR 19000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	20577	10.~~14~~ 84	~~23.86~~ 27.00	10.84 - 27.00
2	UP	20625	23.86	10.14	
3	DN	20673	10.14	23.86	
4	UP	20721	23.86	10.14	
5	DN	20769	10.14	23.86	
6	UP	20817	23.86	10.14	
7	DN	20865	10.14	23.86	
8	UP	20913	23.86	10.14	
9	DN	20961	10.14	23.86	
10	UP	21009	23.86	10.14	
11	DN	21057	10.14	23.86	
12	UP	21105	23.86	10.14	
13	DN	21153	10.14	23.86	
14	UP	21201	23.86	10.14	
15	DN	21249	10.14	23.86	
16	UP	21297	23.86	10.14	
17	DN	21345	10.14	23.86	
18	UP	21393	23.86	10.14	
19	DN	21441	10.14	23.86	
20	UP	21489	23.86	10.14	

REVIEWED BY (Hector Diaz) (LEVEL (III) DATE: 2 NOV 87

EXAM.NO. 16

BWRI SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=16
4. WELD NO.=1-RPV-1043F
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @210 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=210
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~3.51~~ ~~4.05 DNF~~ 13.00 JS
5. X-STOP POS.=~~17.33~~ 21.00 ~~DNF~~
6. WELD LENGTH=69.27
7. BEAM DIR.(DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.62
10. LOWER HEAD RADIUS(IN.)=98.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 16

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1500 SCAN PATH SK. SGATSSET-1
COMPONENT RPV SUBASSEMBLY MERID @210 DEG WELD I.D. 1-RPV-1, UT
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-OSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. SGATSSET

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	1.75
2/8	/	3.5
3/8	/	5.2
NOTCH	/	7
5/8	/	8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.55
2/8	/	5
3/8	/	7.5
NOTCH	/	10
5/8	/	12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	~~10~~ 12 (JS)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		
1/8	/	1.25
2/8	/	2.5
3/8	/	3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5 (JS)	~~5.5~~ 6.0

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE: PALE DALEN 1 PROJECT NO. 17-1502 TUBE: 0141 SITE 2 Nov. 87

SCAN NO. 16 OPERATOR(S): L.R. MATHENA, P.C. TURNER FIELD NO. 1-PTL-1 TT

PARAMETERS

WELD LOC. 210 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 69.27 MOIST POS. 306.3TE
X-FUNCTION PIVOT. SWRI ROTATOR C Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	20577 ✓	~~3.61~~ 1300	~~17.33~~	21.00
2	UP	20625 ✓	17.33	3.61	
3	DN	20673 ✓	3.61	17.33	
4	UP	20721 ✓	17.33	3.61	
5	DN	20769 ✓	3.61	17.33	
6	UP	20817 ✓	17.33	3.61	
7	DN	20865 ✓	3.61	17.33	
8	UP	20913 ✓	17.33	3.61	
9	DN	20961 ✓	3.61	17.33	
10	UP	21009 ✓	17.33	3.61	
11	DN	21057 ✓	3.61	17.33	
12	UP	21105 ✓	17.33	3.61	
13	DN	21153 ✓	3.61	17.33	
14	UP	21201 ✓	17.33	3.61	
15	DN	21249 ✓	3.61	17.33	
16	UP	21297 ✓	17.33	3.61	
17	DN	21345 ✓	3.61	17.33	
18	UP	21393 ✓	17.33	3.61	
19	DN	21441 ✓	3.61	17.33	
20	UP	21489 ✓	17.33	3.61	

REVIEWED BY(Heather Diaz) (LEVEL(III) DATE(2 NOV 87)

EXAM.NO. 17

EWRI SCAN PLAN PARAMETER RECORD

SITE JAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=17
4.WELD NO.=1-RPV-1043A
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @270 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=D8K3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=270
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10 ~~.37~~ 11.81 DSK
5. X-STOP POS.=16 ~~.37~~ 20.07 DSK
6.WELD LENGTH=139
7.BEAM COMP.(CCW=0,CW=1)=0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 17

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1550 SCAN PATH SK. DSK[illegible]
COMPONENT RPV SUBASSEMBLY MERID @270 DEG WELD NO. 1-RPV-[illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERIDONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DI-[illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	13

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1	5.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50B

SHEET [illegible]

SWRI FAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME: 0233 DATE 2 NOV 87

EXAM NO. 17 OPERATOR(S): L.R. MATHEWS (N/A) WELD NO. 1-[illegible]-[illegible]

PARAMETERS

WELD LOC. 270 VESSEL DIA. 174 WALL THICKNESS 8

SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 139 HOIST POS. 33.375

X-FUNCTION PIVOT SWRI ROTATOR 9000 Y-FUNCTION SCAN ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	26837	27890	
2	CCW	1085	27890	26837	
3	CW	1133	26837	27890	11.81 TO 20.07 CTS. IN X
4	CCW	1181	27890	26837	
5	CW	1229	26837	27890	
6	CCW	1277	27890	26837	
7	CW	1325	26837	27890	
8	CCW	1373	27890	26837	
9	CW	1421	26837	27890	
10	CCW	1469	27890	26837	
11	CW	1517	26837	27890	
12	CCW	1565	27890	26837	
13	CW	1613	26837	27890	
14	CCW	1661	27890	26837	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(2 NOV 87)

15- 17.09

16- 17.57

17- 18.05

18- 18.53

19- 19.01

20- ~~[illegible]~~ 19.49

21- 19.97

EXAM.NO. 18

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=18
4. WELD NO.=1-RPV-1043A
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @270 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=270
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10.27 ~~11.81~~ DSK
5. X-STOP POS.=16.37 ~~20.07~~ DSK
6. WELD LENGTH=139
7. BEAM COMP.(CCW=0,CW=1)=1
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.62
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87 JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 19

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH 3V, DOWNSTEP
COMPONENT RPV SUBASSEMBLY MERID 0270 DEG WELD NO. 1-RPV-1,2,3
PROCEDURE/REV/DEV 730-11/7 WELD TYPE MERIDIONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. 8016D246

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	~~12~~

(JS)

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5	~~5.5~~ 6.0

(JS)

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1.	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. 1.3.1.

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1052 TIME 0257 DATE 2 NOV 87

EXAM NO. 13 OPERATOR(S) (L.R. MATHELA ; N/A) CABLE NO. 1 TYPE T

PARAMETERS

WELD LOC. 270 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC. (IN.) .75 CTS..48 WELD LENGTH 139 HOIST POS. 306.272 S
X-FUNCTION PIVOT SWRI ROTATOR 27000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037 ✓	26175	27227	not Rec 1-3
2	CCW	1085 ✓	27227	26175	
3	CW	1133 ✓	26175	27227	
4	CCW	1181 ✓	27227	26175	no credit 4-6.
5	CW	1229 ✓	26175	27227	
6	CCW	1277 ✓	27227	26175	
7	CW	1325 ✓	26175	27227	
8	CCW	1373 ✓	27227	26175	
9	CW	1421 ✓	26175	27227	
10	CCW	1469 ✓	27227	26175	
11	CW	1517 ✓	26175	27227	
12	CCW	1565 ✓	27227	26175	
13	CW	1613 ✓	26175	27227	
14	CCW	1661 ✓	27227	26175	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(2 NOV 87)

15 -	1709 ✓	
16 -	1757 ✓	
17 -	1805 ✓	
18 -	1853 ✓	
19 -	1901 ✓ CW	
20 -	1949 ✓	
21 -	1997 ✓	

EXAM.NO. 19

EMRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=19
4.WELD NO.=1-RPV-1043A
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @270 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052264

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=270
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10.~~1484~~ DAK
5. X-STOP POS.=~~27.8627~~00 DAK
6.WELD LENGTH=69.27
7.BEAM DIR.(DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
Q

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.34 DEGREES PER INCH= .74

EXAM NO. 19

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1352 SCAN PATH SK. 12 (REV 1)
COMPONENT RPV SUBASSEMBLY MERID @270 DEG WELD NO. 1-RPV-11 (R)
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. 5015CC12

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5			
3/8	/ 5.2	1-20	2	10
NOTCH	/ 7			
5/8	/ 8.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.5	SCAN	START	STOP
2/8	/ 5			
3/8	/ 7.5	1-20	1	~~11~~ 12 (JS)
NOTCH	/ 10			
5/8	/ 12.5			

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5			
3/8	/ 3.7	1-20	1.5 (JS)	~~5.5~~ 6.0

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-20	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1332 TIME 0335 DATE 2 NOV 87

SCAN NO. 19 OPERATOR(S) L.R. MATHERA ; N/A WELD NO. 1-FW-11

PARAMETERS

WELD LOC. 270 VESSEL DIA. 174 WALL THICKNESS 6 1/2

SCAN INC.(IN.) .78 CTS..48 WELD LENGTH 67.37 CIRC FED. 301.77

X-FUNCTION PIVOT. SWRI ROTATOR 18000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	26577 ✓	10.14	23.86	
2	UP	26625 ✓	23.86	10.14	
3	DN	26673 ✓	10.14	23.86	
4	UP	26721 ✓	23.86	10.14	
5	DN	26769 ✓	10.14	23.86	
6	UP	26817 ✓	23.86	10.14	
7	DN	26865 ✓	10.14	23.86	
8	UP	26913 ✓	23.86	10.14	
9	DN	26961 ✓	10.14	23.86	
10	UP	27009 ✓	23.86	10.14	
11	DN	27057 ✓	10.14	23.86	
12	UP	27105 ✓	23.86	10.14	
13	DN	27153 ✓	10.14	23.86	
14	UP	27201 ✓	23.86	10.14	
15	DN	27249 ✓	10.14	23.86	
16	UP	27297 ✓	23.86	10.14	
17	DN	27345 ✓	10.14	23.86	
18	UP	27393 ✓	23.86	10.14	
19	DN	27441 ✓	10.14	23.86	
20	UP	27489 ✓	23.86	10.14	

REVIEWED BY Carlos M Ramirez (LEVEL(II) DATE(02 Nov 87)

EXAM NO. 20

SWRI SCAN PLAN EXAMINATION TABLE

SITE SALEM 1 PROJECT NO. 17-1352 SCAN PATH SK. DSK0557A1
COMPONENT RPV SUBASSEMBLY MERID @270 DEG WELD NO. 1-RP-...
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 5-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DTC5211L

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	~~17~~ 12

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5 (1.5)	~~8.0~~ 6.0

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

EXAM.NO. 20

SWRI SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=20
4.WELD NO.=1-RPV-1043A
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @270 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=270
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~3.61~~ ~~4.05 BLK~~ 13.00 (J3)
5. X-STOP POS.=1~~7.33~~ 21.00 BLK
6.WELD LENGTH=69.27
7.BEAM DIR.(DN=1,UP=0)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

SHEET 1 OF 1

SWRI PAP SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1502 TIME 0905 DATE 2 NOV 87

EXAM NO. 20 OPERATOR(S) (P.C. TURNER) N/A) WELD NO. 1-FW-1-1T

PARAMETERS

WELD LOC. 270 VESSEL DIA. 174 WALL THICKNESS .

SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 69.27 HOIST POS. 306.2TI

X-FUNCTION PIVOT. SWRI ROTATOR 0 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	26577	3.61	17.33	
2	UP	26625	17.33	3.61	
3	DN	26673	3.61	17.33	
4	UP	26721	17.33	3.61	
5	DN	26769	3.61	17.33	
6	UP	26817	17.33	3.61	
7	DN	26865	3.61	17.33	
8	UP	26913	17.33	3.61	
9	DN	26961	3.61	17.33	
10	UP	27009	17.33	3.61	
11	DN	27057	3.61	17.33	
12	UP	27105	17.33	3.61	
13	DN	27153	3.61	17.33	
14	UP	27201	17.33	3.61	
15	DN	27249	3.61	17.33	
16	UP	27297	17.33	3.61	
17	DN	27345	3.61	17.33	
18	UP	27393	17.33	3.61	
19	DN	27441	3.61	17.33	
20	UP	27489	17.33	3.61	

X ~~#~~ (2)
13.~~21~~ TO 21.00 (UNP)

REVIEWED BY (Linda M Bowers) (LEVEL (II) DATE (02 Nov 87)

EXAM.NO. 21

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=21
4. WELD NO.=1-RPV-1043B
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @330 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=330
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 DHK
5. X-STOP POS.=~~16.37~~ 20.07 DHK
6. WELD LENGTH=139
7. BEAM COMP.(CCW=0,CW=1)=0
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 21

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1852 SCAN PATH SK. DSK3CCT41
COMPONENT RPV SUBASSEMBLY MERID 6000 DEG WELD NO. 1-RP-1 UNIT 1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERIDONAL SCAN TYPE PARALLEL
CAL.BLK.NO. 3-CBCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DC0822L1

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	12 (12)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5 (12)	~~5.5~~ 6.0

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 508

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (4:48) DATE 2 NOV 87

EXAM NO. 21 OPERATOR(S) (P.C.TURNER) (N/A) WELD NO. 1-[illegible]-[illegible]-[illegible]

PARAMETERS

WELD LOC. 330 VESSEL DIA. 174 WALL THICKNESS 8
SCAN INC.(IN.) .73 CTS..48 WELD LENGTH 139 HOIST POS. 106.37I
X-FUNCTION PIVOT SWRI ROTATOR 9000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	32837	33890	scan 1-3 NOT Rec'd due to taper. (1)
2	CCW	1085	33890	32837	
3	CW	1133	32837	33890	
4	CCW	1181	33890	32837	
5	CW	1229	32837	33890	
6	CCW	1277	33890	32837	
7	CW	1325	32837	33890	
8	CCW	1373	33890	32837	
9	CW	1421	32837	33890	
10	CCW	1469	33890	32837	
11	CW	1517	32837	33890	
12	CCW	1565	33890	32837	
13	CW	1613	32837	33890	
14	CCW	1661	33890	32837	

REVIEWED BY (Carlos M Ramirez) (LEVEL(II) DATE (02 Nov, 87)

15 CW 1709
16 CCW 1757
17 CW 1806
18 CCW 1854
19 CW 1902
20 CCW 1950
21 CW 2007

EXAM.NO. 22

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=22
4.WELD NO.=1-RPV-1043B
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @330 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=330
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~10.37~~ 11.81 DHK
5. X-STOP POS.=~~16.37~~ 21.00 DHK
6.WELD LENGTH=139
7.BEAM COMP.(CCW=0,CW=1)=1
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 NOV- 87
(JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 22

SAFE SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM . PROJECT NO. 17-1832 SCAN PATH SK. DSK1SET1
COMPONENT RPV SUBASSEMBLY MERID 0300 DEG WELD NO. 1-17 / 1-18
PROCEDURE REV/DEV 700-11/7 WELD TYPE MERIDONAL SCAN TYPE PARALLEL
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. STANDARD

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-14	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-14	2	11 / 12 (02)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-14	1.5	~~5.5~~ 6.0 (05)

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-14	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.500

SHEET NO. 11.

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(501 DATE(2 Nov 87

EXAM NO. 22 OPERATOR(S): P.C. Turner), N/A) WELD ID. [illegible]

PARAMETERS

WELD LOC. 330 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.. .75 CTS..48 WELD LENGTH 139 HOIST POS. [illegible]
X-FUNCTION PIVOT SWRI ROTATOR 27000 Y-FUNCTION SCAN ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	1037	32175	33227	Not run (CMB)
2	CCW	1085	33227	32175	
3	CW	1133	32175	33227	
4	CCW	1181	33227	32175	
5	CW	1229	32175	33227	
6	CCW	1277	33227	32175	
7	CW	1325	32175	33227	
8	CCW	1373	33227	32175	
9	CW	1421	32175	33227	
10	CCW	1469	33227	32175	
11	CW	1517	32175	33227	
12	CCW	1565	33227	32175	
13	CW	1613	32175	33227	
14	CCW	1661	33227	32175	

REVIEWED BY(Carla M Barnes) (LEVEL(II) DATE(02 Nov 87

15. CW 1709
16. CCW 1757
17. CW 1806
18. CCW 1854
19. CW 1902
20. CCW 1950
21. CW 2007

EXAM.NO. 23

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=23
4.WELD NO.=1-RPV-1043B
5.COMPONENT=RPV
6.SUBASSEMBLY=MERID @330 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052740
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=330
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=10. ~~14840~~ OK
5. X-STOP POS.=~~27.86~~ 27.00 NOK
6.WELD LENGTH=69.27
7.BEAM DIR.(DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.625
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
(JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 23

BWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1152 SCAN PATH SK. DSM3NCE7+0
COMPONENT RPV SUBASSEMBLY MERID @330 DEG WELD NO. 1-RPV-[illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSFER
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DI0E0[illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	~~11~~ 12 (JS)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-20	1.5	~~3.760~~ (JS)

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET 0. OF 1.

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 0540 DATE 2 NOV 87

EXAM NO. 20 OPERATOR(S) L R Mattera N/A WELD NO. 1-RC-1-[illegible]

PARAMETERS

WELD LOC. 330 VESSEL DIA. 174 WALL THICKNESS 8
SCAN INC.(IN.) .75 CTS..48 WELD LENGTH 69.27 HOIST POS. 104.375
X-FUNCTION PIVOT. SWRI ROTATOR 18000 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	32577	10.14	23.86	
2	UP	32625	23.86	10.14	
3	DN	32673	10.14	23.86	10.84 TO 27.00 CTS IN X
4	UP	32721	23.86	10.14	
5	DN	32769	10.14	23.86	
6	UP	32817	23.86	10.14	
7	DN	32865	10.14	23.86	RUN IN MANUEL
8	UP	32913	23.86	10.14	
9	DN	32961	10.14	23.86	
10	UP	33009	23.86	10.14	
11	DN	33057	10.14	23.86	
12	UP	33105	23.86	10.14	
13	DN	33153	10.14	23.86	
14	UP	33201	23.86	10.14	
15	DN	33249	10.14	23.86	
16	UP	33297	23.86	10.14	
17	DN	33345	10.14	23.86	
18	UP	33393	23.86	10.14	
19	DN	33441	10.14	23.86	
20	UP	33489	23.86	10.14	

REVIEWED BY Carla M Barrera (LEVEL(II) DATE(02 Nov 87)

EXAM.NO. 24

SARI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=24
4. WELD NO.=1-RPV-1043B
5. COMPONENT=RPV
6. SUBASSEMBLY=MERID @330 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052740
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=330
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~3.61~~ ~~4.25~~ 13.00 (JS)
5. X-STOP POS.=~~17.33~~ 21.00
6. WELD LENGTH=69.27
7. BEAM DIR.(DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=88.625
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=225

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87 (JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

EXAM NO. 24

BWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. D305E611
COMPONENT RPV SUBASSEMBLY MERID @330 DEG WELD NO. 1-RPV-1,2,3
PROCEDURE/REV/DEV 700-11/7 WELD TYPE MERID. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 3-C3CL-42-SAM DEVICE DWG.NO./CONFIG.NO. D305E646

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5			
3/8	/ 5.2	1-20	2	10
NOTCH	/ 7			
5/8	/ 8.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.55	SCAN	START	STOP
2/8	/ 5			
3/8	/ 7.5	1-20	2	~~11~~ 12 (15)
NOTCH	/ 10			
5/8	/ 12.5			

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5			
3/8	/ 3.7	1-20	1.5 (15)	~~5.5~~ 6.0

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-20	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 034111

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0600) DATE(2 NOV 87

EXAM NO. 24 OPERATOR(S) L.R. MATHENA ( ) WELD NO. 1-RPV-11-FD

PARAMETERS

WELD LOC. 330 VESSEL DIA. 174 WALL THICKNESS 6 3/8
SCAN INC.(IN.) .75 CTS..46 WELD LENGTH 69.27 HOIST POS. 304.375
X-FUNCTION PIVOT. SWRI ROTATOR 0 Y-FUNCTION BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	32577	3.61	17.33	
2	UP	32625	17.33	3.61	
3	DN	32673	3.61	17.33	13.00 TO 21.00 IN X DIR
4	UP	32721	17.33	3.61	
5	DN	32769	3.61	17.33	
6	UP	32817	17.33	3.61	
7	DN	32865	3.61	17.33	RAN IN MANUEL
8	UP	32913	17.33	3.61	
9	DN	32961	3.61	17.33	
10	UP	33009	17.33	3.61	
11	DN	33057	3.61	17.33	
12	UP	33105	17.33	3.61	
13	DN	33153	3.61	17.33	
14	UP	33201	17.33	3.61	
15	DN	33249	3.61	17.33	
16	UP	33297	17.33	3.61	
17	DN	33345	3.61	17.33	
18	UP	33393	17.33	3.61	
19	DN	33441	3.61	17.33	
20	UP	33489	17.33	3.61	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(02 Nov 87)

EXAM.NO. 25

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=25
4. WELD NO.=1-RPV-4043
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW HEAD-DOME
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052747
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.(PIV.POS.) 56
2. VESSEL DIA.=172
3. WALL THICKNESS=6
4. X-START POS.=135
5. X-STOP POS.=155
6. WELD LENGTH=310.48
7. BEAM DIR.(UP=0,DN=1)= 1
8. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.82
10. LOWER HEAD RADIUS(IN.)=88.4
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=335

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87 (JS)

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .26 DEGREES PER INCH= 1.16

EXAM NO. 25

BLAH SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1002 SCAN PATH SK. SCHEDULE-7
COMPONENT RPV SUBASSEMBLY LOW HEAD-DOME WELD NO. 1-RPV-A1AC
PROCEDURE/REV/DEV 730-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. S-OSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. D3052236

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-31	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-31	2	~~10~~ 12 (12)

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

LAM only

GATE SETTINGS		
SCAN	START	STOP
1-31	1.5	~~5.5~~ 6.0 (12)

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 7

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-31	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO.50A

SHEET 12 OF 13

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 0643 DATE 2 NOV. 87

EXAM NO. 25 OPERATOR(S) L.R. MATHELO (N/A) WELD NO. 1-RPV-V-12

PARAMETERS

WELD LOC. 56 VESSEL DIA. 172 WALL THICKNESS 6
SCAN INC.(IN.)-.75CTS.-.71 WELD LENGTH-310.48 HOIST POS.-304.375
X-FUNCTION BOOM ROT. SWRI ROTATOR 0 Y-FUNCTION PIVOT

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	13500	4787	5760	
2	UP	13571	5760	4787	
3	DN	13642	4787	5760	
4	UP	13713	5760	4787	
5	DN	13784	4787	5760	
6	UP	13855	5760	4787	
7	DN	13926	4787	5760	
8	UP	13997	5760	4787	
9	DN	14068	4787	5760	
10	UP	14139	5760	4787	
11	DN	14210	4787	5760	
12	UP	14281	5760	4787	
13	DN	14352	4787	5760	
14	UP	14423	5760	4787	
15	DN	14494	4787	5760	
16	UP	14565	5760	4787	
17	DN	14636	4787	5760	
18	UP	14707	5760	4787	
19	DN	14778	4787	5760	
20	UP	14849	5760	4787	
21	DN	14920	4787	5760	
22	UP	14991	5760	4787	
23	DN	15062	4787	5760	
24	UP	15133	5760	4787	
25	DN	15204	4787	5760	
26	UP	15275	5760	4787	
27	DN	15346	4787	5760	
28	UP	15417	5760	4787	
29	DN	15488	4787	5760	
30	UP	15559	5760	4787	
31	DN	15630	4787	5760	

REVIEWED BY (Carlos M Barrera) (LEVEL(II) DATE(03 Nov 87)

EXAM.NO. 26

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=26
4.WELD NO.=1-RPV-4043
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW HEAD-DOME
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052747
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.(PIV.POS.) 56
2. VESSEL DIA.=172
3. WALL THICKNESS=6
4. X-START POS.=135
5. X-STOP POS.=155
6.WELD LENGTH=310.48
7.BEAM DIR.(UP=0,DN=1)= 0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.4
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .86 DEGREES PER INCH= 1.16

completed 2 Nov 87 DSK

EXAM NO. 26

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1692 SCAN PLAN SAL 2R-[illegible]
COMPONENT RPV CUBEASSEMBLY LOW HEAD-DOME WELD NO. [illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE [illegible]
CAL.BLK.NO. S-CBCL-42-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.75	SCAN	START	STOP
2/8	/ 3.5			
3/8	/ 5.2	1-31	2	10
NOTCH	/ 7			
5/8	/ 8.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.55	SCAN	START	STOP
2/8	/ 5			
3/8	/ 7.5	1-31	2	~~11~~ 12 Q
NOTCH	/ 10			
5/8	/ 12.5			

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.25	SCAN	START	STOP
2/8	/ 2.5			
3/8	/ 3.7	1-31	1.5	~~5.5~~ 6.0

LAM only Q2

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-31	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50C

SHEET (1 OF 1)

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (0810) DATE 2 NOV 87

EXAM NO. 5A OPERATOR(S) JALEJANDRO) (N/A) WELD NO. 1-RPV-1

PARAMETERS

WELD LOC. 5A VESSEL DIA. 172 WALL THICKNESS 6
SCAN INC.(IN.)-.75CTS.-.71 WELD LENGTH-310.48 HOIST POS.-302.373
X-FUNCTION BOOM ROT. SWRI ROTATOR 18000 Y-FUNCTION PIVOT

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	13500	5440	6413	EXAM RAN IN 2 SECTIONS
2	UP	13571	6413	5440	① Y = 54.4 to 57.6
3	DN	13642	5440	6413	X = 135 to 147.07
4	UP	13713	6413	5440	
5	DN	13784	5440	6413	
6	UP	13855	6413	5440	
7	DN	13926	5440	6413	
8	UP	13997	6413	5440	② Y = 54.4 to 64.13
9	DN	14068	5440	6413	X = 147.78 to 156.30
10	UP	14139	6413	5440	
11	DN	14210	5440	6413	
12	UP	14281	6413	5440	
13	DN	14352	5440	6413	
14	UP	14423	6413	5440	
15	DN	14494	5440	6413	
16	UP	14565	6413	5440	
17	DN	14636	5440	6413	
18	UP	14707	6413	5440	
19	DN	14778	5440	6413	
20	UP	14849	6413	5440	
21	DN	14920	5440	6413	
22	UP	14991	6413	5440	
23	DN	15062	5440	6413	
24	UP	15133	6413	5440	
25	DN	15204	5440	6413	
26	UP	15275	6413	5440	
27	DN	15346	5440	6413	
28	UP	15417	6413	5440	
29	DN	15488	5440	6413	
30	UP	15559	6413	5440	
31	DN	15630	5440	6413	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE 03 Nov, 87)

EXAM.NO. 27

EMPIRE SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=27
4. WELD NO.=1-RPV-4043
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW HEAD-DOME
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=D8K3052747
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.(PIV.POS.) 56
2. VESSEL DIA.=172
3. WALL THICKNESS=6
4. X-START POS.=121.43
5. X-STOP POS.=155
6. WELD LENGTH=310.48
7. BEAM COMPONENT (CW=1,CCW=0)= 1
9. CAL.BLK.THICKNESS(IN.)=5
9. DOLLAR PLATE WELD DIA.(IN.)=98.02
10. LOWER HEAD RADIUS(IN.)=88.4
11. LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .86 DEGREES PER INCH= 1.16

Completed 2 Nov 87 DAK

EXAM NO. 27

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1052 SCAN PATH SK. DS(CONSTANT
COMPONENT RPV SUBASSEMBLY LOW HEAD-DOME WELD NO. 1-RPV-AOUT
PROCEDURE/REV/DEV 700-11.7 WELD TYPE DIRD. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. DTC50281

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-16	2	10

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.3

GATE SETTINGS		
SCAN	START	STOP
1-16	2	13 OK

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INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-16	1.5 OK	5.56 OK

TCG ON FOR WELD SCAN OK

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50D

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME GALEY 1 PROJECT NO. 17-1552 TIME: 0848 DATE 02 Nov 87

EXAM NO. 17 OPERATOR(S) JALEJANDRO / N/A / WELD ID [illegible]

PARAMETERS

WELD LOC. 56 VESSEL DIA. 172 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75 CTS..47 WELD LENGTH 310.48 HOIST FCT. [illegible]
X-FUNCTION BOOM ROT. SWPI ROTATOR 27000 Y-FUNCTION RIVET

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	5248	121.43	155	
2	CCW	5295	155	121.43	STARTED FROM SCAN #3
3	CW	5342	121.43	155	
4	CCW	5389	155	121.43	
5	CW	5436	121.43	155	
6	CCW	5483	155	121.43	
7	CW	5530	121.43	155	
8	CCW	5577	155	121.43	
9	CW	5624	121.43	155	
10	CCW	5671	155	121.43	
11	CW	5718	121.43	155	
12	CCW	5765	155	121.43	SCANS 14 thru 16
13	CW	5812	121.43	155	X = 139.50 — 155 #4
14	CCW	5859	155	121.43	
15	CW	5906	121.43	155	
16	CCW	5953	155	121.43	

#4

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(03,Nov,87)

EXAM.NO. 28

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=28
4.WELD NO.=1-RPV-4043
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW HEAD-DOME
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052747
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.(PIV.POS.) 56
2. VESSEL DIA.=172
3. WALL THICKNESS=6
4. X-START POS.=135
5. X-STOP POS.=168.57
6.WELD LENGTH=310.48
7.BEAM COMPONENT (CW=1,CCW=0)= 0
8.CAL.BLK.THICKNESS(IN.)=5
9.DOLLAR PLATE WELD DIA.(IN.)=98.82
10.LOWER HEAD RADIUS(IN.)=88.4
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .86 DEGREES PER INCH= 1.16

Completed 2 NOV 87 RMC

EXAM NO. 29

BORE SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1330 SCAN PATH ID. DEPTHSEAT
COMPONENT ID. SUBASSEMBLY LOW HEAD-DOME WELD NO. 1-RPV-SEAT
PROCEDURE,REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CBCL-42-BAM DEVICE DWG.NO./CONFIG.NO. 1000122

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-16	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-16	2	12 DAC

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-16	1.5	5.6 DAC

TCG OFF LAM ONLY

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 3

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50B

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1350 TIME 0957 DATE 2 Nov 87

EXAM NO. 03 OPERATOR(S) J. ALEJANDRO N/A WELD NO. 1-RPV-10A

PARAMETERS

WELD LOC. 36 VESSEL DIA. 172 WALL THICKNESS 6
SCAN INC.(IN.) .73 CTS..47 WELD LENGTH 310.48 HOIST POS. 306.375
X-FUNCTION BOOM ROT. SWRI ROTATOR 9000 Y-FUNCTION PIVOT

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	5248	135	168.57	~~X STOP @ 155~~
2	CCW	5295	168.57	135	
3	CW	5342	135	168.57	start EXAM on scan #5
4	CCW	5389	168.57	135	
5	CW	5436	135	168.57	
6	CCW	5483	168.57	135	
7	CW	5530	135	168.57	
8	CCW	5577	168.57	135	
9	CW	5624	135	168.57	
10	CCW	5671	168.57	135	
11	CW	5718	135	168.57	
12	CCW	5765	168.57	135	
13	CW	5812	135	168.57	SCANS 14 thru 16
14	CCW	5859	168.57	135	X = 13950 — 16857 lb
15	CW	5906	135	168.57	
16	CCW	5953	168.57	135	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(03 Nov, 87)

EXAM.NO. 29

SWRI SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=29
4. WELD NO.=1-RPV-10042
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SH-LOW HEAD
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052741
9. CAL.BLK.NO.=5-CSCL-42-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=342.6
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=20
5. X-STOP POS.=40
6. WELD LENGTH=546.637
7. BEAM DIR.(UP=0,DN=1)=1
8. CAL.BLK.THICKNESS(IN.)=5
9. LOWER HEAD RADIUS (IN.)= 88.6
10. LOWER HEAD RAD. PT. (IN. BELOW REF.)= 325

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

Completed 1 Nov 87 DAK

EXAM NO. 29

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH 2K. DOWNCOMER
COMPONENT RPV SUBASSEMBLY LOW SH-LOW HEAD WELD NO. 1-RPV-10-3
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 5-CSCL-4C-SAM DEVICE DWG.NO./CONFIG.NO. DC1502L&E

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-44	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-44	2	12 OK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-44	1.5 OK	5.5 6

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-44	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. NOT...

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1SEC TIME 1220 DATE 1 NOV 87

EXAM NO. 2P OPERATOR(S) J.ALEJANDRO) (N/A) WELD NO. 1-PSV-...

PARAMETERS

WELD LOC. 342.6 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC.(IN.) .75(CTS.) .48 WELD LENGTH 51.5"
X-FUNCTION - BOOM ROTATE SWRI ROTATOR C Y-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	2000	31127	32598	Pivot EXT 2655 ft
2	UP	2048	32598	31127	
3	DN	2096	31127	32598	
4	UP	2144	32598	31127	
5	DN	2192	31127	32598	
6	UP	2240	32598	31127	
7	DN	2288	31127	32598	
8	UP	2336	32598	31127	
9	DN	2384	31127	32598	
10	UP	2432	32598	31127	
11	DN	2480	31127	32598	
12	UP	2528	32598	31127	
13	DN	2576	31127	32598	
14	UP	2624	32598	31127	
15	DN	2672	31127	32598	
16	UP	2720	32598	31127	
17	DN	2768	31127	32598	
18	UP	2816	32598	31127	
19	DN	2864	31127	32598	
20	UP	2912	32598	31127	
21	DN	2960	31127	32598	
22	UP	3008	32598	31127	
23	DN	3056	31127	32598	
24	UP	3104	32598	31127	
25	DN	3152	31127	32598	
26	UP	3200	32598	31127	
27	DN	3248	31127	32598	
28	UP	3296	32598	31127	
29	DN	3344	31127	32598	
30	UP	3392	32598	31127	
31	DN	3440	31127	32598	
32	UP	3488	32598	31127	
33	DN	3536	31127	32598	
34	UP	3584	32598	31127	
35	DN	3632	31127	32598	
36	UP	3680	32598	31127	
37	DN	3728	31127	32598	
38	UP	3776	32598	31127	
39	DN	3824	31127	32598	

B

EXAM NO. 09 OPERATOR(S) J. ALEJANDRO N/A

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	3872	32598	31127	
41	DN	3920	31127	32598	
42	UP	3968	32598	31127	
43	DN	4016	31127	32598	
44	UP	4064	32598	31127	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(01,Nov,87)

EXAM.NO. 30

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=30
4.WELD NO.=1-RPV-10042
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SH-LOW HEAD
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052741
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.(PIV.POS.) 11.1
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=20
5. X-STOP POS.=40
6.WELD LENGTH=546.637
7.BEAM DIR.(UP=0,DN=1)= 0
8.CAL.BLK.THICKNESS(IN.)=5
9.WELD LOCATION(FROM REF.)=342.6
10.LOWER HEAD RADIUS(IN.)=88.6
11.LOWER HEAD RAD.PT.(IN.BELOW REF.)=325

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.54 DEGREES PER INCH= .64

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .63

EXAM NO. 3C

EWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1002 SCAN PATH SK. 2BK0602T4.
COMPONENT RPV SUBASSEMBLY LOW SH-LOW HEAD WELD NO. 1-RPV-11 IC
PROCEDURE REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 5 CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. 2BK0602a

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1 - 44	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1 - 44	2	~~12~~ 12 OK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1 - 44	1.5	~~5.6~~ OK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-44	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1052 TIME: 1148 DATE: 2 NOV 87

EXAM NO. 10 OPERATOR(S) J. ALEJANDRO (N/A). WELD ID 1-SIH-11-XL

PARAMETERS

WELD LOC. 342.6 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC.(IN.)-.75CTS.-.48 WELD LENGTH-546.637 HOIST POS.-551.575
X-FUNCTION BOOM ROT. SWRI ROTATOR 1800C Y-FUNCTION PIVOT

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	2000	950	1923	
2	UP	2048	1923	950	
3	DN	2096	950	1923	
4	UP	2144	1923	950	
5	DN	2192	950	1923	
6	UP	2240	1923	950	
7	DN	2288	950	1923	
8	UP	2336	1923	950	
9	DN	2384	950	1923	
10	UP	2432	1923	950	
11	DN	2480	950	1923	
12	UP	2528	1923	950	
13	DN	2576	950	1923	
14	UP	2624	1923	950	
15	DN	2672	950	1923	
16	UP	2720	1923	950	
17	DN	2768	950	1923	
18	UP	2816	1923	950	
19	DN	2864	950	1923	
20	UP	2912	1923	950	
21	DN	2960	950	1923	
22	UP	3008	1923	950	
23	DN	3056	950	1923	
24	UP	3104	1923	950	
25	DN	3152	950	1923	
26	UP	3200	1923	950	
27	DN	3248	950	1923	
28	UP	3296	1923	950	
29	DN	3344	950	1923	
30	UP	3392	1923	950	
31	DN	3440	950	1923	
32	UP	3488	1923	950	
33	DN	3536	950	1923	
34	UP	3584	1923	950	
35	DN	3632	950	1923	
36	UP	3680	1923	950	
37	DN	3728	950	1923	
38	UP	3776	1923	950	
39	DN	3824	950	1923	

EXAM NO. 3) OPERATOR(S) J. ALEXANDER (N/A) SHEET NO. 12 OF ...
) WELD NO. ...

BOOK	DIR	Y-POS	Y-START	Y-STOP	REMARKS
40	UP	3872	1923	750	
41	DN	3920	950	1923	
42	UP	3968	1923	950	
43	DN	4016	950	1923	
44	UP	4064	1923	950	

REVIEWED BY(Carlos M. Barrera (LEVEL(II) DATE:03 Nov. 87)

EXAM.NO. 31

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1332

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=31
4.WELD NO.=1-RPV-10042
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SH-LOW HEAD
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052741
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=342.6
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=~~11.7~~ 13 DAK
5. X-STOP POS.=40
6.WELD LENGTH=546.637
7.BEAM DIR.(CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=5
9. LOWER HEAD RADIUS (IN.)= 68.6
10. LOWER HEAD RAD. PT. (IN. BELOW REF.)= 320

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

Completed 2 Nov 87 DAK

EXAM NO. 31

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. D0K1SE1T41
COMPONENT RPV SUBASSEMBLY LOW SH-LOW HEAD WELD NO. 1-RPV-1/1-42
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. S-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. 23053244

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-15	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-15	2	12 DAC

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-15	1.5	5.5 6 DAC

TCG ON WELD EXAM

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-15	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.30D

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 1250 DATE 2 NOV 87

EXAM NO. 31 OPERATOR(S) J. ALEJANDRO (N/A) WELD NO. 1-RPV-1

PARAMETERS

WELD LOC. 342.6 VESSEL DIA. 174 WALL THICKNESS 8
SCAN INC.(IN.) .75(CTS.) .75 WELD LENGTH 346.637
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	31847	11.9	40	X = 13.00 to 40.00
2	CCW	31922	40	11.9	
3	CW	31997	11.9	40	
4	CCW	32072	40	11.9	
5	CW	32147	11.9	40	
6	CCW	32222	40	11.9	
7	CW	32297	11.9	40	
8	CCW	32372	40	11.9	
9	CW	32447	11.9	40	
10	CCW	32522	40	11.9	
11	CW	32597	11.9	40	
12	CCW	32672	40	11.9	
13	CW	32747	11.9	40	
14	CCW	32822	40	11.9	
15	CW	32897	11.9	40	

REVIEWED BY (Carlos M Barrera) (LEVEL(II) DATE(03 Nov 87)

EXAM.NO. 32

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1352
3.EXAM NO.=32
4.WELD NO.=1-RPV-10042
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SH-LOW HEAD
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052741
9.CAL.BLK.NO.=5-CSCL-42-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=342.6
2. VESSEL DIA.=174
3. WALL THICKNESS=6
4. X-START POS.=20
5. X-STOP POS.=48.1
6.WELD LENGTH=546.637
7.BEAM DIR.(CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=5
9. LOWER HEAD RADIUS (IN.)= 88.6
10. LOWER HEAD RAD. PT. (IN. BELOW REF.)= 325

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

Compiled 2 Nov 87 DK

EXAM NO. 32

BWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1092 SCAN PATH BK. [illegible]
COMPONENT RPV SUBASSEMBLY LOW SH-LOW HEAD WELD NO. [illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE [illegible]
CAL.BLK.NO. 5-CSCL-42-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 1.75
2/8	/ 3.5
3/8	/ 5.2
NOTCH	/ 7
5/8	/ 8.7

GATE SETTINGS		
SCAN	START	STOP
1-15	2	10

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.55
2/8	/ 5
3/8	/ 7.5
NOTCH	/ 10
5/8	/ 12.5

GATE SETTINGS		
SCAN	START	STOP
1-15	2	12 DLK

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 1.25
2/8	/ 2.5
3/8	/ 3.7

GATE SETTINGS		
SCAN	START	STOP
1-15	1.5	5.6 DLK

TCG OFF DLK
LAMONLY

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-15	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.30 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50B

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM (PROJECT NO. 17-1552 TIME: 1317 DATE: 2 NOV 87

SCAN NO. 02 OPERATOR(S) (P. GAINES) (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 342.6 VESSEL DIA. 174 WALL THICKNESS 6
SCAN INC.(IN.) .75(CTS.) .75 WELD LENGTH 546.407
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	31847	20	48.1	
2	CCW	31922	48.1	20	
3	CW	31997	20	48.1	
4	CCW	32072	48.1	20	
5	CW	32147	20	48.1	
6	CCW	32222	48.1	20	
7	CW	32297	20	48.1	
8	CCW	32372	48.1	20	
9	CW	32447	20	48.1	
10	CCW	32522	48.1	20	
11	CW	32597	20	48.1	
12	CCW	32672	48.1	20	
13	CW	32747	20	48.1	
14	CCW	32822	48.1	20	
15	CW	32897	20	48.1	

REVIEWED BY Lola M Barrera (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. 33

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=33
4.WELD NO.=1-RPV-9042
5.COMPONENT=RPV
6.SUBASSEMBLY=MID-LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052742
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=236.12
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.(DEG.)=20
5. X-STOP POS.(DEG.)=40
6.WELD LENGTH=546.637
7.BEAM COMPONENT (DN=1,UP=0)=1
8.CAL.BLK.THICKNESS(IN.)=9

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

Completed 2 Nov 87 DAF

EXAM NO. 33

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSKD3037A1
COMPONENT RPV SUBASSEMBLY MID-LOW SHELL WELD NO. 1-RPV-R041
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
3/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-44	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-44	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-44	~~2~~ 1.2 DNK	~~8.5~~ 9.5 DNK

TCG OFF LAM ONLY DNK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-44	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME: 1638 DATE 2 NOV 87

EXAM NO. II OPERATOR(S) J. ALEJANDRO, N/A WELD NO. [illegible]

PARAMETERS

WELD LOC. 236.12 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 546.637
Y-FUNCTION-HOIST SWRI ROTATOR 0 X-FUNCTION - BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	1925	21582	24012	
2	UP	1973	24012	21582	
3	DN	2021	21582	24012	
4	UP	2069	24012	21582	
5	DN	2117	21582	24012	
6	UP	2165	24012	21582	
7	DN	2213	21582	24012	
8	UP	2261	24012	21582	
9	DN	2309	21582	24012	
10	UP	2357	24012	21582	
11	DN	2405	21582	24012	
12	UP	2453	24012	21582	
13	DN	2501	21582	24012	
14	UP	2549	24012	21582	
15	DN	2597	21582	24012	
16	UP	2645	24012	21582	
17	DN	2693	21582	24012	
18	UP	2741	24012	21582	
19	DN	2789	21582	24012	
20	UP	2837	24012	21582	
21	DN	2885	21582	24012	
22	UP	2933	24012	21582	
23	DN	2981	21582	24012	
24	UP	3029	24012	21582	
25	DN	3077	21582	24012	
26	UP	3125	24012	21582	
27	DN	3173	21582	24012	
28	UP	3221	24012	21582	
29	DN	3269	21582	24012	
30	UP	3317	24012	21582	
31	DN	3365	21582	24012	
32	UP	3413	24012	21582	
33	DN	3461	21582	24012	
34	UP	3509	24012	21582	
35	DN	3557	21582	24012	
36	UP	3605	24012	21582	
37	DN	3653	21582	24012	
38	UP	3701	24012	21582	
39	DN	3749	21582	24012	

BEAM NO. 33 OPERATOR(S) JALEJANDRO , NIA SHEET NO. 27 OF 28
) WELL ID, [illegible]

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	3797-	24012	21582	
41	DN	3845-	21582	24012	
42	UP	3893-	24012	21582	
43	DN	3941-	21582	24012	
44	UP	3989-	24012	21582	

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. 34

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=34
4. WELD NO.=1-RPV-9042
5. COMPONENT=RPV
6. SUBASSEMBLY=MID-LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052742
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=236.12
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.(DEG.)=20
5. X-STOP POS.(DEG.)=40
6. WELD LENGTH=546.637
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=9

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

Completed 2 Nov 87 DAK

EXAM NO. 34

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052743
COMPONENT RPV SUBASSEMBLY MID-LOW SHELL WELD NO. 1-RPV-SCN1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. 3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-44	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-44	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-44	12	8.5

TCGOFF LAM ONLY OK OK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-44	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 034101

SWRI PAR SCAN SHEET

SITE NAME ONLEY 1 PROJECT NO. 17-1552 TIME 1715 DATE 2 NOV 87

EXAM NO. 34 OPERATOR(S) JALEJANDRO (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 236.12 VESSEL DIA. 174 WALL THICKNESS 6"
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 546.637
Y-FUNCTION-HOIST SWRI ROTATOR 18000 X-FUNCTION - BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	1925.	23212	25542	
2	UP	1973.	25542	23212	
3	DN	2021.	23212	25542	
4	UP	2069.	25542	23212	
5	DN	2117.	23212	25542	
6	UP	2165.	25542	23212	
7	DN	2213.	23212	25542	
8	UP	2261.	25542	23212	
9	DN	2309.	23212	25542	
10	UP	2357.	25542	23212	
11	DN	2405.	23212	25542	
12	UP	2453.	25542	23212	
13	DN	2501.	23212	25542	
14	UP	2549.	25542	23212	
15	DN	2597.	23212	25542	
16	UP	2645.	25542	23212	
17	DN	2693.	23212	25542	
18	UP	2741.	25542	23212	
19	DN	2789.	23212	25542	
20	UP	2837.	25542	23212	
21	DN	2885.	23212	25542	
22	UP	2933.	25542	23212	
23	DN	2981.	23212	25542	
24	UP	3029.	25542	23212	
25	DN	3077.	23212	25542	
26	UP	3125.	25542	23212	
27	DN	3173.	23212	25542	
28	UP	3221.	25542	23212	
29	DN	3269.	23212	25542	
30	UP	3317.	25542	23212	
31	DN	3365.	23212	25542	
32	UP	3413.	25542	23212	
33	DN	3461.	23212	25542	
34	UP	3509.	25542	23212	
35	DN	3557.	23212	25542	
36	UP	3605.	25542	23212	
37	DN	3653.	23212	25542	
38	UP	3701.	25542	23212	
39	DN	3749.	23212	25542	

EXAM NO. 34 OPERATOR(S) JALGANDO : N/A SHEET NO. 17A-2
: WELD NO. 1-TPV-P-WI

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	3797-	25542	23212	
41	DN	3845-	23212	25542	
42	UP	3893-	25542	23212	
43	DN	3941-	23212	25542	
44	UP	3989-	25542	23212	

REVIEWED BY (Carlos M Barrera (LEVEL (II) DATE (03 Nov. 87)

EXAM.NO. 35

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=35
4.WELD NO.=1-RPV-9042
5.COMPONENT=RPV
6.SUBASSEMBLY=MID-LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=236.12
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=8.6
5. X-STOP POS.=40
6.WELD LENGTH=546.637
7.BEAM COMPONENT (CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=9
9.FIRST SCAN IF NOT 1 =0
10.LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

Completed 2 NOV 87 DAK

EXAM NO. 35

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK2/SET-3
COMPONENT RPV SUBASSEMBLY MID-LOW SHELL WELD NO. 1-RPV-2[illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D[illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

TCG ON DAC

GATE SETTINGS		
SCAN	START	STOP
1-20	[illegible] DAC	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1532 TIME(1738) DATE(2 NOV 87

EXAM NO. 33 OPERATOR(S) (JALEJANDRO (N/A) WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 236.12 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 546.637
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	22862	860	4000	
2	CCW	22937	4000	860	
3	CW	23012	860	4000	
4	CCW	23087	4000	860	
5	CW	23162	860	4000	
6	CCW	23237	4000	860	
7	CW	23312	860	4000	
8	CCW	23387	4000	860	
9	CW	23462	860	4000	
10	CCW	23537	4000	860	
11	CW	23612	860	4000	
12	CCW	23687	4000	860	
13	CW	23762	860	4000	
14	CCW	23837	4000	860	
15	CW	23912	860	4000	
16	CCW	23987	4000	860	
17	CW	24062	860	4000	
18	CCW	24137	4000	860	
19	CW	24212	860	4000	
20	CCW	24287	4000	860	

REVIEWED BY(Carlos M Barrera (LEVEL(II) DATE(03, Nov, 87)

EXAM.NO. 36

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=36
4.WELD NO.=1-RPV-9042
5.COMPONENT=RPV
6.SUBASSEMBLY=MID-LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=236.12
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=20
5. X-STOP POS.=51.4
6.WELD LENGTH=546.637
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.FIRST SCAN IF NOT 1 =0
10.LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

Completed 2 Nov 87 DSK

EXAM NO. 36

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1352 SCAN PATH SK. DEVICE TYPE
COMPONENT RPV SUBASSEMBLY MID-LOW SHELL WELD NO. 1-RPV-F,XC
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D305222T

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

TCG OFF DAK

GATE SETTINGS		
SCAN	START	STOP
1-20	1.2 DAK	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 305

SHEET NO. 0561 (

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 1757) DATE (2 NOV 87)

EXAM NO. 34 OPERATOR(S) JALEJANDRO (N/A) WELD NO. 1-RPV-[illegible]C

PARAMETERS

WELD LOC. 236.12 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 546.137
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	22862-	2000	5140	
2	CCW	22937-	5140	2000	
3	CW	23012-	2000	5140	
4	CCW	23087-	5140	2000	
5	CW	23162-	2000	5140	
6	CCW	23237-	5140	2000	
7	CW	23312-	2000	5140	
8	CCW	23387-	5140	2000	
9	CW	23462-	2000	5140	
10	CCW	23537-	5140	2000	
11	CW	23612-	2000	5140	
12	CCW	23687-	5140	2000	
13	CW	23762-	2000	5140	
14	CCW	23837-	5140	2000	
15	CW	23912-	2000	5140	
16	CCW	23987-	5140	2000	
17	CW	24062-	2000	5140	
18	CCW	24137-	5140	2000	
19	CW	24212-	2000	5140	
20	CCW	24287-	5140	2000	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (03 Nov, 87

EXAM.NO. 37

SIRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1551

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1551
3. EXAM NO.=37
4. WELD NO.=1-RPV-3042B
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=105
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 2 Nov 87 DKK

000500

EXAM NO. 37

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1532 SCAN PATH SK. DSK30S2745
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3042B
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D30S2LT

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

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INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

TCG OFF OK

GATE SETTINGS		
SCAN	START	STOP
1-19	~~2~~ OK	8.5

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50B

SHEET NO. [illegible]

SWRI PCR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TYPE 1828 DATE 2 NOV 87

CAL NO. 17 OPERATOR(S) ALEJANDRO / N/A FILE NO. [illegible]

PARAMETERS

WELD LOC. 103 VESSEL DIA. 174 WALL THICKNESS ?
SCAN IND.(IN.) 75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	23500	10240	11754	
2	CCW	23575	11754	10240	
3	CW	23650	10240	11754	
4	CCW	23725	11754	10240	
5	CW	23800	10240	11754	
6	CCW	23875	11754	10240	
7	CW	23950	10240	11754	
8	CCW	24025	11754	10240	
9	CW	24100	10240	11754	
10	CCW	24175	11754	10240	
11	CW	24250	10240	11754	
12	CCW	24325	11754	10240	
13	CW	24400	10240	11754	
14	CCW	24475	11754	10240	
15	CW	24550	10240	11754	
16	CCW	24625	11754	10240	
17	CW	24700	10240	11754	
18	CCW	24775	11754	10240	
19	CW	24850	10240	11754	

REVIEWED BY Linda M Barnes (LEVEL (II) DATE (03 , Nov 87)

EXAM.NO. 38

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=38
4. WELD NO.=1-RPV-30425
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=105
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 2 Nov 87 DF

EXAM NO. 32

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1222 SCAN PATH ST. SS/RPSET-3
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-37,43
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE [illegible]
CAL.BLK.NO. 9-CBCL-54-SAN DEVICE DWG.NO./CONFIG.NO. D1551287

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	~~12~~ AK	8.5

TCG OFF AK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 1841 DATE 2 NOV 87

EXAM NO. TE OPERATOR(S): SALESANDRO (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 10S VESSEL DIA. 174 WALL THICKNESS ?
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM RCTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	23500-	9246	10760	
2	CCW	23575-	10760	9246	
3	CW	23650-	9246	10760	
4	CCW	23725-	10760	9246	
5	CW	23800-	9246	10760	
6	CCW	23875-	10760	9246	
7	CW	23950-	9246	10760	
8	CCW	24025-	10760	9246	
9	CW	24100-	9246	10760	
10	CCW	24175-	10760	9246	
11	CW	24250-	9246	10760	
12	CCW	24325-	10760	9246	
13	CW	24400-	9246	10760	
14	CCW	24475-	10760	9246	
15	CW	24550-	9246	10760	
16	CCW	24625-	10760	9246	
17	CW	24700-	9246	10760	
18	CCW	24775-	10760	9246	
19	CW	24850-	9246	10760	

REVIEWED BY Carlos M Barrera) (LEVEL(II) DATE(03 Nov 87)

EXAM.NO. 39

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=39
4.WELD NO.=1-RPV-3042B
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=105
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6.WELD LENGTH=107
7.BEAM COMPONENT (DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS= 0
10.Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

Completed 2 Nov 87 OK

EXAM NO. 39

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK0CE2T1E
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-[illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TANGENTIAL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. DSC52267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

TCG OFF DSK

GATE SETTINGS		
SCAN	START	STOP
1-19	~~12~~ DSK 8.5	

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. CI9101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (1853) DATE: 2 NOV 87

EXAM NO. 39 OPERATOR(S) VALLEJANDRO (N/A) WELD NO. 1-RPV-CI-03

PARAMETERS

WELD LOC. 105 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC. (IN.) .75 (CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	10077	23200	26330	
2	UP	10125	26330	23200	
3	DN	10173	23200	26330	
4	UP	10221	26330	23200	
5	DN	10269	23200	26330	
6	UP	10317	26330	23200	
7	DN	10365	23200	26330	
8	UP	10413	26330	23200	
9	DN	10461	23200	26330	
10	UP	10509	26330	23200	
11	DN	10557	23200	26330	
12	UP	10605	26330	23200	
13	DN	10653	23200	26330	
14	UP	10701	26330	23200	
15	DN	10749	23200	26330	
16	UP	10797	26330	23200	
17	DN	10845	23200	26330	
18	UP	10893	26330	23200	
19	DN	10941	23200	26330	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (03 Nov, 87)

EXAM.NO. 40

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=40
4. WELD NO.=1-RPV-3042B
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=105
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

Completed 2 Nov 87 BK

EXAM NO. 40

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052748
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3042B
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D1052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

TCG ON RWK

GATE SETTINGS		
SCAN	START	STOP
1-19	12 RWK	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.30A

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1911) DATE 2 NOV,87.

EXAM NO. 40 OPERATOR(S) JALEJANDRO (N/A) WELD NO. 1-RPV-CC [illegible]

PARAMETERS

WELD LOC. 105 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR O Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	10077	21970	25100	
2	UP	10125	25100	21970	
3	DN	10173	21970	25100	
4	UP	10221	25100	21970	
5	DN	10269	21970	25100	
6	UP	10317	25100	21970	
7	DN	10365	21970	25100	
8	UP	10413	25100	21970	
9	DN	10461	21970	25100	
10	UP	10509	25100	21970	
11	DN	10557	21970	25100	
12	UP	10605	25100	21970	
13	DN	10653	21970	25100	
14	UP	10701	25100	21970	
15	DN	10749	21970	25100	
16	UP	10797	25100	21970	
17	DN	10845	21970	25100	
18	UP	10893	25100	21970	
19	DN	10941	21970	25100	

REVIEWED BY(Carlos M Barrera)(LEVEL(II) DATE(03,Nov,87)

EXAM.NO. 41

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=41
4.WELD NO.=1-RPV-3042C
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=225
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6.WELD LENGTH=107
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS=0
10.Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 2 Nov 87 DSK

EXAM NO. 41

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK0002783
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-30420
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. E0050367

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	+2 OK	8.5

TCG OFF OK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 5CB

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 1929 DATE 2 NOV 87

EXAM NO. 41 OPERATOR(S) JALEJANDRO (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 225 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	23500 -	22240	23755	
2	CCW	23575 -	23755	22240	
3	CW	23650 -	22240	23755	
4	CCW	23725 -	23755	22240	
5	CW	23800-	22240	23755	
6	CCW	23875 -	23755	22240	
7	CW	23950 -	22240	23755	
8	CCW	24025-	23755	22240	
9	CW	24100 -	22240	23755	
10	CCW	24175-	23755	22240	
11	CW	24250-	22240	23755	
12	CCW	24325-	23755	22240	
13	CW	24400 -	22240	23755	
14	CCW	24475-	23755	22240	
15	CW	24550 -	22240	23755	
16	CCW	24625-	23755	22240	
17	CW	24700-	22240	23755	
18	CCW	24775-	23755	22240	
19	CW	24850-	22240	23755	

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. 42

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=42
4.WELD NO.=1-RPV-3042C
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-8AM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=225
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6.WELD LENGTH=107
7.BEAM COMPONENT (CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS=0
10.Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
(JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 42

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSM3M53743
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-I.402
PROCEDURE/REV/DEV 700-11.7 WELD TYPE VERT. SCAN TYPE PAR LEVEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D1M52187

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	÷ 2 @	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME 1946) DATE 2 NOV 87

EXAM NO. 1C OPERATOR(S) JALEJANDRO (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 225 VESSEL DIA. 174 WALL THICKNESS ?
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	23500	21245	22760	
2	CCW	23575	22760	21245	
3	CW	23650	21245	22760	
4	CCW	23725	22760	21245	
5	CW	23800	21245	22760	
6	CCW	23875	22760	21245	
7	CW	23950	21245	22760	
8	CCW	24025	22760	21245	
9	CW	24100	21245	22760	
10	CCW	24175	22760	21245	
11	CW	24250	21245	22760	
12	CCW	24325	22760	21245	
13	CW	24400	21245	22760	
14	CCW	24475	22760	21245	
15	CW	24550	21245	22760	
16	CCW	24625	22760	21245	
17	CW	24700	21245	22760	
18	CCW	24775	22760	21245	
19	CW	24850	21245	22760	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (03 Nov, 87)

EXAM.NO. 43

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=43
4. WELD NO.=1-RPV-3042C
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=225
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Comp 2 NOV. 87
JS

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 43

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052743
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3042C
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	$\frac{+}{2}$ @	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2005 DATE 2 Nov 87

EXAM NO. 43 OPERATOR(S) L.R. Mathela (w/a) WELD NO. [illegible]

PARAMETERS

WELD LOC. 225 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	22077	23200	26330	
2	UP	22125	26330	23200	
3	DN	22173	23200	26330	Boom Ext @ 7.53 Th
4	UP	22221	26330	23200	
5	DN	22269	23200	26330	
6	UP	22317	26330	23200	
7	DN	22365	23200	26330	
8	UP	22413	26330	23200	
9	DN	22461	23200	26330	
10	UP	22509	26330	23200	
11	DN	22557	23200	26330	
12	UP	22605	26330	23200	
13	DN	22653	23200	26330	
14	UP	22701	26330	23200	
15	DN	22749	23200	26330	
16	UP	22797	26330	23200	
17	DN	22845	23200	26330	
18	UP	22893	26330	23200	
19	DN	22941	23200	26330	

REVIEWED BY (Carlos M Barrera) (LEVEL(II) DATE(03 Nov 87)

EXAM.NO. 44

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=44
4. WELD NO.=1-RPV-3042C
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=225
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
(JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 44

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1532 SCAN PATH BK. DSAC0CC274C
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3042C
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-84-SAM DEVICE DWG.NO./CONFIG.NO. DSVCCCC7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.35
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	± 2.5	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (2019) DATE (2 NOV 87)

EXAM NO. 44 OPERATOR(S) (L.R. MATHELA (N/A) WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 225 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC. (IN.) .75 (CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	22077	21970	25100	
2	UP	22125	25100	21970	
3	DN	22173	21970	25100	Boom Ext. @ 875 hr
4	UP	22221	25100	21970	
5	DN	22269	21970	25100	
6	UP	22317	25100	21970	
7	DN	22365	21970	25100	
8	UP	22413	25100	21970	
9	DN	22461	21970	25100	
10	UP	22509	25100	21970	
11	DN	22557	21970	25100	
12	UP	22605	25100	21970	
13	DN	22653	21970	25100	
14	UP	22701	25100	21970	
15	DN	22749	21970	25100	
16	UP	22797	25100	21970	
17	DN	22845	21970	25100	
18	UP	22893	25100	21970	
19	DN	22941	21970	25100	

REVIEWED BY (Linda M Barnes) (LEVEL (II) DATE (03 Nov, 87)

EXAM.NO. 45

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=45
4. WELD NO.=1-RPV-3042A
5. COMPONENT=RPV
6. SUBASSEMBLY=LOW SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=345
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87

(12)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 45

SNRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1382 SCAN PATH SK. 231017E
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3,4,5A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D0685267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	$\pm\frac{1}{2}$ @	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 508

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME: GALEM 1 PROJECT NO. 17-1502 TIME: 2040 DATE 2 NOV 87

EXAM NO. 43 OPERATOR(S): L.R. MATHEWS N/A WELD NO. 1-87-2-21

PARAMETERS

WELD LOC. 345 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	23500	34240	35754	
2	CCW	23575	35754	34240	
3	CW	23650	34240	35754	
4	CCW	23725	35754	34240	
5	CW	23800	34240	35754	
6	CCW	23875	35754	34240	
7	CW	23950	34240	35754	
8	CCW	24025	35754	34240	
9	CW	24100	34240	35754	
10	CCW	24175	35754	34240	
11	CW	24250	34240	35754	
12	CCW	24325	35754	34240	
13	CW	24400	34240	35754	
14	CCW	24475	35754	34240	
15	CW	24550	34240	35754	
16	CCW	24625	35754	34240	
17	CW	24700	34240	35754	
18	CCW	24775	35754	34240	
19	CW	24850	34240	35754	

REVIEWED BY(Carlos M Ballesteros (LEVEL(II) DATE(03 Nov, 87)

EXAM.NO. 46

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=46
4.WELD NO.=1-RPV-3042A
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=345
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6.WELD LENGTH=107
7.BEAM COMPONENT (CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS=0
10.Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
(JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 46

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. 23/CU SET 12
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3,4,5
PROCEDURE/REV/DEV 70C-11/7 WELD TYPE VERT. SCAN TYPE TAT + LL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D000222-7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	3.15
2/8	/	6.2
3/8	/	9.4
NOTCH	/	12.5
5/8	/	15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	4.55
2/8	/	9
3/8	/	13.5
NOTCH	/	18
5/8	/	22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.25
2/8	/	4.5
3/8	/	6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	±2 @ 2	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. 04.11

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME: 2103 DATE: 2 NOV 87

EXAM NO. 4e OPERATOR(S) L.R. MATHENA (N/A) WELD I.D. 1-RA-11

PARAMETERS

WELD LOC. 345 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC. (IN.) .75 (CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	23500	33246	34760	
2	CCW	23575	34760	33246	
3	CW	23650	33246	34760	
4	CCW	23725	34760	33246	Boom Ext. 7.25 TD
5	CW	23800	33246	34760	
6	CCW	23875	34760	33246	
7	CW	23950	33246	34760	
8	CCW	24025	34760	33246	
9	CW	24100	33246	34760	
10	CCW	24175	34760	33246	
11	CW	24250	33246	34760	
12	CCW	24325	34760	33246	
13	CW	24400	33246	34760	
14	CCW	24475	34760	33246	
15	CW	24550	33246	34760	
16	CCW	24625	34760	33246	
17	CW	24700	33246	34760	
18	CCW	24775	34760	33246	
19	CW	24850	33246	34760	

REVIEWED BY (Carlos M Barrera (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. 47

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=47
4.WELD NO.=1-RPV-3042A
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=345
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6.WELD LENGTH=107
7.BEAM COMPONENT (DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS= 0
10.Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp ZNOV. 87
(93)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 47

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3CE27T3
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3042A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	17
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	+2 (19)	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (2118) DATE 2 NOV 87

EXAM NO. 47 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 345 VESSEL DIA. 174 WALL THICKNESS ?
SCAN INC.(IN.) .73(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	34077 ✓	23200	26330	
2	UP	34125 ✓	26330	23200	
3	DN	34173 ✓	23200	26330	
4	UP	34221 ✓	26330	23200	Boom Ext @ 7.28 in
5	DN	34269 ✓	23200	26330	
6	UP	34317 ✓	26330	23200	
7	DN	34365 ✓	23200	26330	
8	UP	34413 ✓	26330	23200	
9	DN	34461 ✓	23200	26330	
10	UP	34509 ✓	26330	23200	
11	DN	34557 ✓	23200	26330	
12	UP	34605 ✓	26330	23200	
13	DN	34653 ✓	23200	26330	
14	UP	34701 ✓	26330	23200	
15	DN	34749 ✓	23200	26330	
16	UP	34797 ✓	26330	23200	
17	DN	34845 ✓	23200	26330	
18	UP	34893 ✓	26330	23200	
19	DN	34941 ✓	23200	26330	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. 48

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1532

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=48
4.WELD NO.=1-RPV-3042A
5.COMPONENT=RPV
6.SUBASSEMBLY=LOW SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=345
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=235
5. X-STOP POS.=248
6.WELD LENGTH=107
7.BEAM COMPONENT (DN=1,UP=0)=1
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS= 0
10.Y-STOP IF LIMITATIONS= 0

Comp 2 Nov. 87

Y-CONVERSION PARAMETERS

JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 48

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. D3K30E2745
COMPONENT RPV SUBASSEMBLY LOW SHELL WELD NO. 1-RPV-3042A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D3052247

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	+ 2 DB	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2135 DATE 2 NOV 87

SCAN NO. 48 OPERATOR(S) L.R. MATHENA / N/A / WELD NO. [illegible]

PARAMETERS

WELD LOC. 345 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	34077	21970	25100	
2	UP	34125	25100	21970	
3	DN	34173	21970	25100	
4	UP	34221	25100	21970	
5	DN	34269	21970	25100	
6	UP	34317	25100	21970	
7	DN	34365	21970	25100	
8	UP	34413	25100	21970	
9	DN	34461	21970	25100	
10	UP	34509	25100	21970	
11	DN	34557	21970	25100	
12	UP	34605	25100	21970	
13	DN	34653	21970	25100	
14	UP	34701	25100	21970	
15	DN	34749	21970	25100	
16	UP	34797	25100	21970	
17	DN	34845	21970	25100	
18	UP	34893	25100	21970	
19	DN	34941	21970	25100	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(3 NOV 87)

EXAM.NO. 49

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=49
4. WELD NO.=1-RPV-2042B
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=60
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87 JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 49

EVT-1 SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH EX. DEH2SELT-2
COMPONENT PRV SUBASSEMBLY MID SHELL WELD NO. 1-PRV-10-11
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PART
CAL.BLK.NO. 9-2SDL-S4-SAM DEVICE DWG.NO./CONFIG.NO. DEH2SELT

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	±2 DB	8.8

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 503

SHEET NO. 0[illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1232 TIME: 2156 DATE: 2 NOV 87

EXAM NO. 49 OPERATOR(S): L.R. MATHENA (N/A) WELD NO. 1-FW-[illegible]

PARAMETERS

WELD LOC. 60 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	12616	5740	7254	
2	CCW	12691	7254	5740	
3	CW	12766	5740	7254	
4	CCW	12841	7254	5740	
5	CW	12916	5740	7254	Boom Ext. @ 6.80 hr
6	CCW	12991	7254	5740	
7	CW	13066	5740	7254	
8	CCW	13141	7254	5740	
9	CW	13216	5740	7254	
10	CCW	13291	7254	5740	
11	CW	13366	5740	7254	
12	CCW	13441	7254	5740	
13	CW	13516	5740	7254	
14	CCW	13591	7254	5740	
15	CW	13666	5740	7254	
16	CCW	13741	7254	5740	
17	CW	13816	5740	7254	
18	CCW	13891	7254	5740	
19	CW	13966	5740	7254	

REVIEWED BY([signature]) (LEVEL(III) DATE: 3 NOV 87

EXAM.NO. 50

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=50
4.WELD NO.=1-RPV-2042B
5.COMPONENT=RPV
6.SUBASSEMBLY=MID SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=60
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6.WELD LENGTH=107
7.BEAM COMPONENT (CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS=0
10.Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87 JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 50

SHORT SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1092 SCAN TYPE BL SUBJECT IC
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-2C/CE
PROCEDURE/REV/DEV 700-11/7 WELD TYPE /ERT. SCAN TYPE [illegible]
CAL.BLK.NO. 9-CBCL-54-SAM DEVICE DWG.NO./CONFIG.NO. 9D9E2067

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	1/2 (2)	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1550 TIME 2208 DATE 2 Nov 87

EXAM NO. 30 OPERATOR(S) L.R. MATHENA N/A FILE NO. 1-[illegible]

PARAMETERS

WELD LOC. 40 VESSEL DIA. 174 WALL THICKNESS =
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	12616	4745	6260	
2	CCW	12691	6260	4745	
3	CW	12766	4745	6260	
4	CCW	12841	6260	4745	
5	CW	12916	4745	6260	
6	CCW	12991	6260	4745	
7	CW	13066	4745	6260	
8	CCW	13141	6260	4745	
9	CW	13216	4745	6260	
10	CCW	13291	6260	4745	
11	CW	13366	4745	6260	
12	CCW	13441	6260	4745	
13	CW	13516	4745	6260	
14	CCW	13591	6260	4745	
15	CW	13666	4745	6260	
16	CCW	13741	6260	4745	
17	CW	13816	4745	6260	
18	CCW	13891	6260	4745	
19	CW	13966	4745	6260	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(3 Nov 87)

EXAM.NO. 51

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=51
4.WELD NO.=1-RPV-2042B
5.COMPONENT=RPV
6.SUBASSEMBLY=MID SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=60
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6.WELD LENGTH=107
7.BEAM COMPONENT (DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS= 0
10.Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
(J2)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 51

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK1552A5
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-C04C2
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE MANUAL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. DSK552A7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	3.15
2/8	/	6.2
3/8	/	9.4
NOTCH	/	12.5
5/8	/	15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	4.55
2/8	/	9
3/8	/	13.5
NOTCH	/	18
5/8	/	22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.25
2/8	/	4.5
3/8	/	6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	$\frac{1}{2}$ P	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 500

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME: 2224 DATE: 2 NOV 87

EXAM NO. 51 OPERATOR(S) L.R. MATHENA N/A) WELD [illegible]

PARAMETERS

WELD LOC. 60 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 13000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	5577 ✓	12316	15446	
2	UP	5625 ✓	15446	12316	
3	DN	5673 ✓	12316	15446	
4	UP	5721 ✓	15446	12316	
5	DN	5769 ✓	12316	15446	
6	UP	5817 ✓	15446	12316	
7	DN	5865 ✓	12316	15446	
8	UP	5913 ✓	15446	12316	
9	DN	5961 ✓	12316	15446	
10	UP	6009 ✓	15446	12316	
11	DN	6057 ✓	12316	15446	
12	UP	6105 ✓	15446	12316	
13	DN	6153 ✓	12316	15446	
14	UP	6201 ✓	15446	12316	
15	DN	6249 ✓	12316	15446	
16	UP	6297 ✓	15446	12316	
17	DN	6345 ✓	12316	15446	
18	UP	6393 ✓	15446	12316	
19	DN	6441 ✓	12316	15446	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(3 NOV 87

EXAM.NO. 52

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=52
4. WELD NO.=1-RPV-2042B
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSKC052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=60
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp. 2 Nov 87

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 52

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. 09K1052715
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-204-22
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. 05052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	~~1~~ 2.5	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(2243) DATE 2 NOV 87

EXAM NO. 52 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RPV-10-CB

PARAMETERS

WELD LOC. 60 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 43 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	5577 ✓	11086	14216	
2	UP	5625 ✓	14216	11086	
3	DN	5673 ✓	11086	14216	
4	UP	5721 ✓	14216	11086	
5	DN	5769 ✓	11086	14216	
6	UP	5817 ✓	14216	11086	Boom Ext @ 6.30 TM
7	DN	5865 ✓	11086	14216	
8	UP	5913 ✓	14216	11086	
9	DN	5961 ✓	11086	14216	
10	UP	6009 ✓	14216	11086	
11	DN	6057 ✓	11086	14216	
12	UP	6105 ✓	14216	11086	
13	DN	6153 ✓	11086	14216	
14	UP	6201 ✓	14216	11086	
15	DN	6249 ✓	11086	14216	
16	UP	6297 ✓	14216	11086	
17	DN	6345 ✓	11086	14216	
18	UP	6393 ✓	14216	11086	
19	DN	6441 ✓	11086	14216	

TM

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(3 NOV 87)

EXAM.NO. 53

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=53
4.WELD NO.=1-RPV-2042C
5.COMPONENT=RPV
6.SUBASSEMBLY=MID SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=180
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6.WELD LENGTH=107
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS=0
10.Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 Nov. 87
JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 32

SHORT SCAN PLAN EXAMINATION SHEET

SITE SALEM 1 PROJECT NO. 97-1102 SCAN PLAN EX. 32(REV.)
UT PLANT RPV SUBASSEMBLY IRD SHELL WELD NO. LAST CAL.
PROCEDURE/REV. PDI-UT-10/7 WELD TYPE VERT. JOINT TYPE FULL
CAL.BLK.NO. 9-CBDL-54-SAM DEVICE DWG.NO./CONFIG.NO. DIRECT

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.6
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	$\frac{+}{2}$ @ 2	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 502

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2301 DATE: 2 NOV 87

EXAM NO. 53 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 180 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	12616 ✓	17740	19255	
2	CCW	12691 ✓	19255	17740	
3	CW	12766 ✓	17740	19255	
4	CCW	12841 ✓	19255	17740	
5	CW	12916 ✓	17740	19255	Boom Ext. @ 6.20"
6	CCW	12991 ✓	19255	17740	
7	CW	13066 ✓	17740	19255	
8	CCW	13141 ✓	19255	17740	
9	CW	13216 ✓	17740	19255	
10	CCW	13291 ✓	19255	17740	
11	CW	13366 ✓	17740	19255	
12	CCW	13441 ✓	19255	17740	
13	CW	13516 ✓	17740	19255	
14	CCW	13591 ✓	19255	17740	
15	CW	13666 ✓	17740	19255	
16	CCW	13741 ✓	19255	17740	
17	CW	13816 ✓	17740	19255	
18	CCW	13891 ✓	19255	17740	
19	CW	13966 ✓	17740	19255	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(3 NOV 87)

EXAM.NO. 54

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=54
4. WELD NO.=1-RPV-2042C
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=180
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 2 Nov. 87 JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. E4

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1382 SCAN PAT. SK 13-5001F-3
COMPONENT NAME SUBASSEMBLY MID SHELL WELD NO. 1-MRA-204-C
PROCEDURE/REV./DEV 700-11.7 WELD TYPE VERT. SCAN TYPE MANUAL
CAL.BLK.NO. 3-CSCL-54-54M DEVICE DWG.NO./CONFIG.NO. DI3E001F

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.65
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	±2@	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO.30D

SHEET NO. 01 OF 01

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1852 TIME (2315) DATE 2 NOV 87

EXAM NO. 54 OPERATOR(S) LR MATHENA ( ) WELD NO. 1-[illegible]-SG-07

PARAMETERS

WELD LOC. 180 VESSEL DIA. 174 WALL THICKNESS 7
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	12616 ✓	16745	18260	
2	CCW	12691 ✓	18260	16745	
3	CW	12766 ✓	16745	18260	
4	CCW	12841 ✓	18260	16745	Boom Ext @ 6.40
5	CW	12916 ✓	16745	18260	
6	CCW	12991 ✓	18260	16745	
7	CW	13066 ✓	16745	18260	
8	CCW	13141 ✓	18260	16745	
9	CW	13216 ✓	16745	18260	
10	CCW	13291 ✓	18260	16745	
11	CW	13366 ✓	16745	18260	
12	CCW	13441 ✓	18260	16745	
13	CW	13516 ✓	16745	18260	
14	CCW	13591 ✓	18260	16745	
15	CW	13666 ✓	16745	18260	
16	CCW	13741 ✓	18260	16745	
17	CW	13816 ✓	16745	18260	
18	CCW	13891 ✓	18260	16745	
19	CW	13966 ✓	16745	18260	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(3 NOV 87)

EXAM.NO. 55

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=55
4.WELD NO.=1-RPV-2042C
5.COMPONENT=RPV
6.SUBASSEMBLY=MID SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052745
9.CAL.BLK.NO.=9-CSCL-54-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=180
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6.WELD LENGTH=107
7.BEAM COMPONENT (DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=9
9.Y-START IF LIMITATIONS= 0
10.Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp 2 NOV. 87
JS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

EXAM NO. 55

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH #. 33X3133743
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-2043C
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. 33X822647

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	± 2	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 055.11

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (2335) DATE 2 Nov 87

EXAM NO. 59 OPERATOR(S) (P.L. TURNER) (N/A) WELD NO. 1-RPV-L-111

PARAMETERS

WELD LOC. 180 VESSEL DIA. 174 WALL THICKNESS 7
SCAN INC. (IN.) .75 (CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	17577	12316	15446	Boom EXT 640
2	UP	17625	15446	12316	
3	DN	17673	12316	15446	
4	UP	17721	15446	12316	
5	DN	17769	12316	15446	
6	UP	17817	15446	12316	
7	DN	17865	12316	15446	
8	UP	17913	15446	12316	
9	DN	17961	12316	15446	
10	UP	18009	15446	12316	
11	DN	18057	12316	15446	
12	UP	18105	15446	12316	
13	DN	18153	12316	15446	
14	UP	18201	15446	12316	
15	DN	18249	12316	15446	
16	UP	18297	15446	12316	
17	DN	18345	12316	15446	
18	UP	18393	15446	12316	
19	DN	18441	12316	15446	

REVIEWED BY Calvin M Barnes (LEVEL (II) DATE (03, Nov, 87)

EXAM.NO. 56

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=56
4. WELD NO.=1-RPV-2042C
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=180
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp 3 NOV. 87

(J2)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 56

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. [illegible]
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-2[illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSLATE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	±2 (12)	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 13 of 31

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME: 2357 DATE: 2 Nov 87

EXAM NO. 5A OPERATOR(S) (R.C. TURNER) (N/A) WELD NO. 1-RPV-1-CC

PARAMETERS

WELD LOC. 180 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	17577	11086	14216	609 Boom Encl.
2	UP	17625	14216	11086	
3	DN	17673	11086	14216	
4	UP	17721	14216	11086	
5	DN	17769	11086	14216	
6	UP	17817	14216	11086	
7	DN	17865	11086	14216	
8	UP	17913	14216	11086	
9	DN	17961	11086	14216	
10	UP	18009	14216	11086	
11	DN	18057	11086	14216	
12	UP	18105	14216	11086	
13	DN	18153	11086	14216	
14	UP	18201	14216	11086	
15	DN	18249	11086	14216	
16	UP	18297	14216	11086	
17	DN	18345	11086	14216	
18	UP	18393	14216	11086	
19	DN	18441	11086	14216	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. 57

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=57
4. WELD NO.=1-RPV-2042A
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=300
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 3 NOV-87

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 57

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DB1502217E
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-204CA
PROCEDURE/REV/DEV 700-1.7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. DB1502267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	[illegible]	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	$\frac{1}{2}$ (58)	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	[illegible] IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 506

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1222 TIME(0038) DATE 3 Nov 87

EXAM NO. ST OPERATOR(S) (P.L.TURNER) (S/G WELD NO. 1-FW-01 ST

PARAMETERS

WELD LOC. 300 VESSEL DIA. 174 WALL THICKNESS ?
BEAM INC.(IN.) .75(DTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	12616	29740	31254	
2	CCW	12691	31254	29740	
3	CW	12766	29740	31254	
4	CCW	12841	31254	29740	
5	CW	12916	29740	31254	
6	CCW	12991	31254	29740	
7	CW	13066	29740	31254	
8	CCW	13141	31254	29740	
9	CW	13216	29740	31254	
10	CCW	13291	31254	29740	
11	CW	13366	29740	31254	
12	CCW	13441	31254	29740	
13	CW	13516	29740	31254	
14	CCW	13591	31254	29740	
15	CW	13666	29740	31254	
16	CCW	13741	31254	29740	
17	CW	13816	29740	31254	
18	CCW	13891	31254	29740	
19	CW	13966	29740	31254	

REVIEWED BY(Carlos M Barrera (LEVEL(II) DATE(03 Nov, 87)

EXAM.NO. 58

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=58
4. WELD NO.=1-RPV-2042A
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=300
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=136.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 3 Nov. 87

(39)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 58

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1152 SCAN PATH B-L DRAWING NO.
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-C04C4
PROCEDURE/REV 700-11.7 WELD TYPE VERT. SCAN TYPE
CAL.BLK.NO. 9-CBCL-84-SAM DEVICE DWG.NO./CONFIG.NO. D305267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-19	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.85
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-19	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-19	+203	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-19	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. 1 [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 0055 DATE 3 NOV 87

EXAM NO. EE OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RCP-[illegible]

PARAMETERS

WELD LOC. 300 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 107
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	12616	28746	30260	
2	CCW	12691	30260	28746	
3	CW	12766	28746	30260	
4	CCW	12841	30260	28746	
5	CW	12916	28746	30260	
6	CCW	12991	30260	28746	
7	CW	13066	28746	30260	
8	CCW	13141	30260	28746	
9	CW	13216	28746	30260	
10	CCW	13291	30260	28746	
11	CW	13366	28746	30260	
12	CCW	13441	30260	28746	
13	CW	13516	28746	30260	
14	CCW	13591	30260	28746	
15	CW	13666	28746	30260	
16	CCW	13741	30260	28746	
17	CW	13816	28746	30260	
18	CCW	13891	30260	28746	
19	CW	13966	28746	30260	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE 03 Nov. 87

EXAM.NO. 59

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=59
4. WELD NO.=1-RPV-2042A
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=300
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp 3/10/87

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 57

EWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. E9K0552745
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-2042A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANS EXAM
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	$\pm\frac{2}{3}$	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 057.1.

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0108) DATE(3 NOV 87

EXAM NO. 59 OPERATOR(S) L.R. MATHENA N/A ; WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 300 VESSEL DIA. 174 WALL THICKNESS *
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	29577 ✓	12316	15446	
2	UP	29625 ✓	15446	12316	
3	DN	29673 ✓	12316	15446	
4	UP	29721 ✓	15446	12316	
5	DN	29769 ✓	12316	15446	
6	UP	29817 ✓	15446	12316	
7	DN	29865 ✓	12316	15446	
8	UP	29913 ✓	15446	12316	
9	DN	29961 ✓	12316	15446	
10	UP	30009 ✓	15446	12316	
11	DN	30057 ✓	12316	15446	
12	UP	30105 ✓	15446	12316	
13	DN	30153 ✓	12316	15446	
14	UP	30201 ✓	15446	12316	
15	DN	30249 ✓	12316	15446	
16	UP	30297 ✓	15446	12316	
17	DN	30345 ✓	12316	15446	
18	UP	30393 ✓	15446	12316	
19	DN	30441 ✓	12316	15446	

REVIEWED BY(Paul M Bowers (LEVEL(II) DATE(03,Nov,87)

EXAM.NO. 60

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=60
4. WELD NO.=1-RPV-2042A
5. COMPONENT=RPV
6. SUBASSEMBLY=MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=300
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=126.16
5. X-STOP POS.=139.16
6. WELD LENGTH=107
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .63

Comp 3 NOV 87

EXAM NO. 60

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. SK1308ET15
COMPONENT RPV SUBASSEMBLY MID SHELL WELD NO. 1-RPV-2042A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANS/EPRI
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. 0305226?

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-19	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-19	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-19	1.2 (comb)	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-19	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 6 of 6

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1132 TIME (0123) DATE 3 NOV 87

EXAM NO. 50 OPERATOR(S) L.R. Mathews (n/a) WELD NO. 1-CPV-2111

PARAMETERS

WELD LOC. 300 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC. (IN.) .75 (CTS.) 48 WELD LENGTH 107
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	29577 ✓	11086	14216	
2	UP	29625 ✓	14216	11086	
3	DN	29673 ✓	11086	14216	
4	UP	29721 ✓	14216	11086	
5	DN	29769 ✓	11086	14216	
6	UP	29817 ✓	14216	11086	
7	DN	29865 ✓	11086	14216	
8	UP	29913 ✓	14216	11086	
9	DN	29961 ✓	11086	14216	
10	UP	30009 ✓	14216	11086	
11	DN	30057 ✓	11086	14216	
12	UP	30105 ✓	14216	11086	
13	DN	30153 ✓	11086	14216	
14	UP	30201 ✓	14216	11086	
15	DN	30249 ✓	11086	14216	
16	UP	30297 ✓	14216	11086	
17	DN	30345 ✓	11086	14216	
18	UP	30393 ✓	14216	11086	
19	DN	30441 ✓	11086	14216	

REVIEWED BY Paula M Barrera (LEVEL (II) DATE (03 Nov 87)

EXAM.NO. =1

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1551

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=61
4. WELD NO.=1-RPV-8042
5. COMPONENT=RPV
6. SUBASSEMBLY=UP-MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052743
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127.28
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.(DEG.)=~~20~~ 70.00 (JS)
5. X-STOP POS.(DEG.)=~~46~~ 90.64 (JS)
6. WELD LENGTH=546.637
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=9

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 41

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. SS-1315[1]3
COMPONENT FPV SUBASSEMBLY UP-MID SHELL WELD NO. 1-FPV-SS-2
PROCEDURE REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-OSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. SS1552-7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-44	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.35	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-44	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-44	1 2	8.5

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-44	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 061...

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0210) DATE: 3 NOV 87

EXAM NO. 61 OPERATOR(S): LR MATHELA(N/A WELD NO. 1-RPV-B11

PARAMETERS

WELD LOC. 127.28 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 346.637
Y-FUNCTION-HOIST SWRI ROTATOR 0 X-FUNCTION - BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	1925	10698	13128	
2	UP	1973	13128	10698	
3	DN	2021	10698	13128	
4	UP	2069	13128	10698	
5	DN	2117	10698	13128	
6	UP	2165	13128	10698	
7	DN	2213	10698	13128	
8	UP	2261	13128	10698	
9	DN	2309	10698	13128	
10	UP	2357	13128	10698	RESTART ON SCAN #10
11	DN	2405	10698	13128	RESTART EXAM
12	UP	2453	13128	10698	
13	DN	2501	10698	13128	
14	UP	2549	13128	10698	
15	DN	2597	10698	13128	
16	UP	2645	13128	10698	
17	DN	2693	10698	13128	X CTS. FROM 70° TO 90.64°
18	UP	2741	13128	10698	IN BOOM ROTATE,
19	DN	2789	10698	13128	
20	UP	2837	13128	10698	
21	DN	2885	10698	13128	COULD NOT START @ 1925°
22	UP	2933	13128	10698	CAUSE OF I.E. ON NOZZLE
23	DN	2981	10698	13128	@ 22°
24	UP	3029	13128	10698	
25	DN	3077	10698	13128	
26	UP	3125	13128	10698	
27	DN	3173	10698	13128	
28	UP	3221	13128	10698	
29	DN	3269	10698	13128	
30	UP	3317	13128	10698	
31	DN	3365	10698	13128	
32	UP	3413	13128	10698	
33	DN	3461	10698	13128	
34	UP	3509	13128	10698	
35	DN	3557	10698	13128	
36	UP	3605	13128	10698	
37	DN	3653	10698	13128	
38	UP	3701	13128	10698	
39	DN	3749	10698	13128	

RUN NO. 61 OPERATOR(S): L.R. Mathena / N/A FIELD TECHNICIAN(S):

RUN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	3797 ✓	10128	10698	
41	DN	3845 ✓	10698	13128	
42	UP	3793 ✓	13128	10698	
43	DN	3941 ✓	10698	13128	
44	UP	3789 ✓	13128	10698	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE 03 Nov, 87

EXAM.NO. 62

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=62
4. WELD NO.=1-RPV-8042
5. COMPONENT=RPV
6. SUBASSEMBLY=UP-MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052743
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127.28
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.(DEG.) ~~=20~~ 70.00 (JS)
5. X-STOP POS.(DEG.) ~~=40~~ 90.64
6. WELD LENGTH=546.637
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=9

X-CONVERSION PARAMETERS. Comp 3 Nov. 87 (JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .63

EXAM NO. 62

EVRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. 05K3UE3T'C
COMPONENT RPV SUBASSEMBLY UP-MID SHELL WELD NO. 1-RPV-BC4L
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. DJC52267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-44	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-44	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-44	$\pm_2$ @	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-44	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1502 TIME (0307) DATE 3 NOV 87

EXAM NO. 42 OPERATOR(S) L.R. Mathena / N/A WELD ID [illegible]

PARAMETERS

WELD LOC. 137.29 VESSEL DIA. 174 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 48 WELD LENGTH 346.637
Y-FUNCTION-HOIST SWRI ROTATOR 18000 X-FUNCTION - BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	1925	12328	14658	X 70-90.64 CMB
2	UP	1973	14658	12328	
3	DN	2021	12328	14658	
4	UP	2069	14658	12328	
5	DN	2117	12328	14658	
6	UP	2165	14658	12328	
7	DN	2213	12328	14658	
8	UP	2261	14658	12328	
9	DN	2309	12328	14658	
10	UP	2357	14658	12328	
11	DN	2405	12328	14658	
12	UP	2453	14658	12328	
13	DN	2501	12328	14658	
14	UP	2549	14658	12328	
15	DN	2597	12328	14658	
16	UP	2645	14658	12328	
17	DN	2693	12328	14658	
18	UP	2741	14658	12328	RESTART ON SCAN 18
19	DN	2789	12328	14658	
20	UP	2837	14658	12328	
21	DN	2885	12328	14658	
22	UP	2933	14658	12328	
23	DN	2981	12328	14658	
24	UP	3029	14658	12328	
25	DN	3077	12328	14658	
26	UP	3125	14658	12328	
27	DN	3173	12328	14658	
28	UP	3221	14658	12328	
29	DN	3269	12328	14658	
30	UP	3317	14658	12329	
31	DN	3365	12328	14658	
32	UP	3413	14658	12328	
33	DN	3461	12328	14658	
34	UP	3509	14658	12329	
35	DN	3557	12328	14658	
36	UP	3605	14658	12328	
37	DN	3653	12328	14658	
38	UP	3701	14658	12328	
39	DN	3749	12328	14658	

EXAM NO. 02 OPERATOR(S) L.R. MATHENA

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	3777	14658	12328	
41	DN	3845	12328	14658	
42	UP	3897	14658	12328	
43	DN	3941	12328	14658	
44	UP	3987	14658	12328	

REVIEWED BY (Carlos M Barrera (LEVEL (II) DATE (03 Nov, 87

EXAM.NO. 63

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=63
4. WELD NO.=1-RPV-8042
5. COMPONENT=RPV
6. SUBASSEMBLY=UP-MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127.28
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=~~5.6~~ 60.87 (JS)
5. X-STOP POS.=~~40~~ 91.64
6. WELD LENGTH=546.637
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=9
9. FIRST SCAN IF NOT 1 =0
10. LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

Comp 3 Nov-87 (JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 63

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH 3R, DIN:1527*3
COMPONENT RPV SUBASSEMBLY UP-MID SHELL WELD NO. 1-RPV-3044
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D30E2367

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.15	SCAN	START	STOP
2/8	/ 6.2			
3/8	/ 9.4	1-20	2	14
NOTCH	/ 12.5			
5/8	/ 15.7			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 4.55	SCAN	START	STOP
2/8	/ 9			
3/8	/ 13.5	1-20	2	19
NOTCH	/ 18			
5/8	/ 22.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.25	SCAN	START	STOP
2/8	/ 4.5			
3/8	/ 6.7	1-20	$\pm \frac{1}{2}$	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-20	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.30 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. 1 of 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 0400 DATE 3 NOV 87

EXAM NO. 4C OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RPV-3?-?

PARAMETERS

WELD LOC. 127.28 VESSEL DIA. 174 WALL THICKNESS 9
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 546.637
X-FUNCTION - 300M ROTATE SWRI ROTATOR 27000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	11978 ✓	860	4000	X = 59.80 -92.70 ama
2	CCW	12053 ✓	4000	860	
3	CW	12128 ✓	860	4000	
4	CCW	12203 ✓	4000	860	
5	CW	12278 ✓	860	4000	
6	CCW	12353 ✓	4000	860	
7	CW	12428 ✓	860	4000	
8	CCW	12503 ✓	4000	860	
9	CW	12578 ✓	860	4000	
10	CCW	12653 ✓	4000	860	
11	CW	12728 ✓	860	4000	
12	CCW	12803 ✓	4000	860	
13	CW	12878 ✓	860	4000	
14	CCW	12953 ✓	4000	860	
15	CW	13028 ✓	860	4000	
16	CCW	13103 ✓	4000	860	
17	CW	13178 ✓	860	4000	
18	CCW	13253 ✓	4000	860	
19	CW	13328 ✓	860	4000	
20	CCW	13403 ✓	4000	860	

REVIEWED BY Paula M Barnes (LEVEL (II) DATE (03 Nov, 87)

EXAM.NO. 64

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=64
4. WELD NO.=1-RPV-8042
5. COMPONENT=RPV
6. SUBASSEMBLY=UP-MID SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052745
9. CAL.BLK.NO.=9-CSCL-54-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127.28
2. VESSEL DIA.=174
3. WALL THICKNESS=9
4. X-START POS.=~~20~~ 69.00 (JS)
5. X-STOP POS.=~~51.4~~ 100.77
6. WELD LENGTH=546.637
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=9
9. FIRST SCAN IF NOT 1 =0
10. LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

Comp 3 Nov. 87 (JS)

INCHES PER DEGREE= 1.51 DEGREES PER INCH= .65

EXAM NO. 64

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1332 SCAN PATH SK. DSK20SIT13
COMPONENT RPV SUBASSEMBLY UP-MID SHELL WELD NO. 1-RPV-SEAM
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 9-CSCL-54-SAM DEVICE DWG.NO./CONFIG.NO. D3053267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 3.15
2/8	/ 6.2
3/8	/ 9.4
NOTCH	/ 12.5
5/8	/ 15.7

GATE SETTINGS		
SCAN	START	STOP
1-20	2	14

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 4.55
2/8	/ 9
3/8	/ 13.5
NOTCH	/ 18
5/8	/ 22.5

GATE SETTINGS		
SCAN	START	STOP
1-20	2	19

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.25
2/8	/ 4.5
3/8	/ 6.7

GATE SETTINGS		
SCAN	START	STOP
1-20	~~+~~ 2 @	8.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-20	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	-0 IN.

MODULE CONFIGURATION NO. 5CB

SHEET NO. 064.01

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME: 0419 DATE: 3 Nov 87

EXAM NO. 64 OPERATOR(S) L.R. MATHENA N/A) WELD NO. 1-RPV-3142

PARAMETERS

WELD LOC. 127.28 VESSEL DIA. 174 WALL THICKNESS 7
SCAN INC. (IN.) .75 (CTS.) 75 WELD LENGTH 546.637
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	11978 ✓	2000	5140	X = 67.8 - 101.8 cmg
2	CCW	12053 ✓	5140	2000	
3	CW	12128 ✓	2000	5140	
4	CCW	12203 ✓	5140	2000	
5	CW	12278 ✓	2000	5140	
6	CCW	12353 ✓	5140	2000	
7	CW	12428 ✓	2000	5140	
8	CCW	12503 ✓	5140	2000	
9	CW	12578 ✓	2000	5140	
10	CCW	12653 ✓	5140	2000	
11	CW	12728 ✓	2000	5140	
12	CCW	12803 ✓	5140	2000	
13	CW	12878 ✓	2000	5140	
14	CCW	12953 ✓	5140	2000	
15	CW	13028 ✓	2000	5140	
16	CCW	13103 ✓	5140	2000	
17	CW	13178 ✓	2000	5140	
18	CCW	13253 ✓	5140	2000	
19	CW	13328 ✓	2000	5140	
20	CCW	13403 ✓	5140	2000	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (03 Nov, 87)

EXAM.NO. 65A

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=65A
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VESSEL TO FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052744
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.(DEG.)=5
5. X-STOP POS.(DEG.)=185
6. WELD LENGTH=538.15
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=11

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 3 Nov 87 DSK

EXAM NO. 65A

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052744
COMPONENT RPV SUBASSEMBLY VESSEL TO FLANGE WELD NO. 1-RPV-7042
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-370	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-370	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-370	+ 2 (35)	10.5

TCG OFF N/K

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-370	1 DIV.	7 DIV

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 06SA(1)

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1052 TIME (0640) DATE (3 NOV 87

EXAM NO. 15A OPERATOR(S) (L.R. Mathews) (n/a) WELD NO. 1-SAV-[illegible]

PARAMETERS

WELD LOC. 28.28 VESSEL DIA. 171.3 WALL THICKNESS [illegible]
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 529.15
Y-FUNCTION-HOIST SWRI ROTATOR 18000 X-FUNCTION - BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	425	2328	5198	
2	UP	474	5198	2328	
3	DN	523	2328	5198	
4	UP	572	5198	2328	
5	DN	621	2328	5198	
6	UP	670	5198	2328	
7	DN	719	2328	5198	
8	UP	768	5198	2328	
9	DN	817	2328	5198	
10	UP	866	5198	2328	
11	DN	915	2328	5198	
12	UP	964	5198	2328	
13	DN	1013	2328	5198	
14	UP	1062	5198	2328	
15	DN	1111	2328	5198	
16	UP	1160	5198	2328	
17	DN	1209	2328	5198	
18	UP	1258	5198	2328	
19	DN	1307	2328	5198	
20	UP	1356	5198	2328	
21	DN	1405	2328	5198	
22	UP	1454	5198	2328	
23	DN	1503	2328	5198	
24	UP	1552	5198	2328	
25	DN	1601	2328	5198	
26	UP	1650	5198	2328	
27	DN	1699	2328	5198	
28	UP	1748	5198	2328	
29	DN	1797	2328	5198	
30	UP	1846	5198	2328	
31	DN	1895	2328	5198	
32	UP	1944	5198	2328	
33	DN	1993	2328	5198	
34	UP	2042	5198	2328	
35	DN	2091	2328	5198	
36	UP	2140	5198	2328	
37	DN	2189	2328	5198	
38	UP	2238	5198	2328	
39	DN	2287	2328	5198	

Boom Ext. 586"

30.28 to 5198 (NEW Y CTS.) due to flange configuration

EXAM NO. 65A OPERATOR(S): L.R. Mattella (N/A) SHEET NO. [illegible]
WELD NO. [illegible]

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	2336	5198	2328	
41	DN	2385	2328	5198	
42	UP	2434	5198	2328	
43	DN	2483	2328	5198	
44	UP	2532	5198	2328	
45	DN	2581	2328	5198	
46	UP	2630	5198	2328	
47	DN	2679	2328	5198	
48	UP	2728	5198	2328	
49	DN	2777	2328	5198	
50	UP	2826	5198	2328	
51	DN	2875	2328	5198	
52	UP	2924	5198	2328	
53	DN	2973	2328	5198	
54	UP	3022	5198	2328	
55	DN	3071	2328	5198	
56	UP	3120	5198	2328	
57	DN	3169	2328	5198	
58	UP	3218	5198	2328	
59	DN	3267	2328	5198	
60	UP	3316	5198	2328	
61	DN	3365	2328	5198	
62	UP	3414	5198	2328	
63	DN	3463	2328	5198	
64	UP	3512	5198	2328	
65	DN	3561	2328	5198	
66	UP	3610	5198	2328	
67	DN	3659	2328	5198	
68	UP	3708	5198	2328	
69	DN	3757	2328	5198	
70	UP	3806	5198	2328	
71	DN	3855	2328	5198	
72	UP	3904	5198	2328	
73	DN	3953	2328	5198	
74	UP	4002	5198	2328	
75	DN	4051	2328	5198	
76	UP	4100	5198	2328	
77	DN	4149	2328	5198	
78	UP	4198	5198	2328	
79	DN	4247	2328	5198	
80	UP	4296	5198	2328	
81	DN	4345	2328	5198	
82	UP	4394	5198	2328	
83	DN	4443	2328	5198	
84	UP	4492	5198	2328	
85	DN	4541	2328	5198	
86	UP	4590	5198	2328	
87	DN	4639	2328	5198	
88	UP	4688	5198	2328	
89	DN	4737	2328	5198	

SHEET NO. 24JA113

EXAM NO. 65A OPERATOR(S) (L.K. MATHEWS J.ALEJANDRO) WELD NO. 1-SPV-7[illegible]

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
90	UP	4786	5198	2328	
91	DN	4835	2328	5198	
92	UP	4884	5198	2328	
93	DN	4933	2328	5198	
94	UP	4982	5198	2328	
95	DN	5031	2328	5198	
96	UP	5080	5198	2329	
97	DN	5129	2328	5198	
98	UP	5178	5198	2328	
99	DN	5227	2328	5198	
100	UP	5276	5198	2328	
101	DN	5325	2328	5198	
102	UP	5374	5198	2328	
103	DN	5423	2328	5198	
104	UP	5472	5198	2328	
105	DN	5521	2328	5198	
106	UP	5570	5198	2328	
107	DN	5619	2328	5198	
108	UP	5668	5198	2328	
109	DN	5717	2328	5198	
110	UP	5766	5198	2328	
111	DN	5815	2328	5198	
112	UP	5864	5198	2328	
113	DN	5913	2328	5198	
114	UP	5962	5198	2328	
115	DN	6011	2328	5198	
116	UP	6060	5198	2328	
117	DN	6109	2328	5198	
118	UP	6158	5198	2328	
119	DN	6207	2328	5198	
120	UP	6256	5198	2328	
121	DN	6305	2328	5198	
122	UP	6354	5198	2328	
123	DN	6403	2328	5198	
124	UP	6452	5198	2328	
125	DN	6501	2328	5198	
126	UP	6550	5198	2328	
127	DN	6599	2328	5198	
128	UP	6648	5198	2328	
129	DN	6697	2328	5198	
130	UP	6746	5198	2328	
131	DN	6795	2328	5198	
132	UP	6844	5198	2328	
133	DN	6893	2328	5198	
134	UP	6942	5198	2328	
135	DN	6991	2328	5198	
136	UP	7040	5198	2328	
137	DN	7089	2328	5198	
138	UP	7138	5198	2328	
139	DN	7187	2328	5198	

EXAM NO. 6EA OPERATOR(S) JALEJANDRO N/A SHEET NO. [illegible]
WELD NO. [illegible]

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
140	UP	7236.	5198	2328	
141	DN	7285.	2328	5198	
142	UP	7334.	5198	2328	
143	DN	7383.	2328	5198	
144	UP	7432.	5198	2328	
145	DN	7481.	2328	5198	
146	UP	7530.	5198	2328	
147	DN	7579.	2328	5198	
148	UP	7628.	5198	2328	
149	DN	7677.	2328	5198	
150	UP	7726.	5198	2328	
151	DN	7775.	2328	5198	
152	UP	7824.	5198	2328	
153	DN	7873.	2328	5198	
154	UP	7922.	5198	2328	
155	DN	7971.	2328	5198	
156	UP	8020.	5198	2328	
157	DN	8069.	2328	5198	
158	UP	8118.	5198	2328	
159	DN	8167.	2328	5198	
160	UP	8216.	5198	2328	
161	DN	8265.	2328	5198	
162	UP	8314.	5198	2328	
163	DN	8363.	2328	5198	
164	UP	8412.	5198	2328	
165	DN	8461.	2328	5198	
166	UP	8510.	5198	2328	
167	DN	8559.	2328	5198	
168	UP	8608.	5198	2328	
169	DN	8657.	2328	5198	
170	UP	8706.	5198	2328	
171	DN	8755.	2328	5198	
172	UP	8804.	5198	2328	
173	DN	8853.	2328	5198	
174	UP	8902.	5198	2328	
175	DN	8951.	2328	5198	
176	UP	9000.	5198	2328	
177	DN	9049.	2328	5198	
178	UP	9098.	5198	2328	
179	DN	9147.	2328	5198	
180	UP	9196.	5198	2328	
181	DN	9245.	2328	5198	
182	UP	9294.	5198	2328	
183	DN	9343.	2328	5198	
184	UP	9392.	5198	2328	
185	DN	9441.	2328	5198	
186	UP	9490.	5198	2328	
187	DN	9539.	2328	5198	
188	UP	9588.	5198	2328	
189	DN	9637.	2328	5198	

18

SHEET NO. 1 OF 1

EXAM I.D. 65A OPERATOR(S) (J.ALEJANDRO (N/A) WELD NO. 1-RPV-7C-12

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
190	UP	9686	5198	2328	
191	DN	9735	2328	5198	
192	UP	9784	5190	2328	
193	DN	9833	2328	5198	
194	UP	9882	5198	2328	
195	DN	9931	2328	5198	
196	UP	9980	5198	2328	
197	DN	10029	2328	5198	
198	UP	10078	5198	2328	
199	DN	10127	2328	5198	
200	UP	10176	5198	2328	
201	DN	10225	2328	5198	
202	UP	10274	5198	2328	
203	DN	10323	2328	5198	
204	UP	10372	5198	2328	
205	DN	10421	2328	5198	
206	UP	10470	5198	2328	
207	DN	10519	2328	5198	
208	UP	10568	5198	2328	
209	DN	10617	2328	5198	
210	UP	10666	5198	2328	
211	DN	10715	2328	5198	
212	UP	10764	5198	2328	
213	DN	10813	2328	5198	
214	UP	10862	5198	2328	
215	DN	10911	2328	5198	
216	UP	10960	5198	2328	
217	DN	11009	2328	5198	
218	UP	11058	5198	2328	
219	DN	11107	2328	5198	
220	UP	11156	5198	2328	
221	DN	11205	2328	5198	
222	UP	11254	5198	2328	
223	DN	11303	2328	5198	
224	UP	11352	5198	2328	
225	DN	11401	2328	5198	
226	UP	11450	5198	2328	
227	DN	11499	2328	5198	
228	UP	11548	5198	2328	
229	DN	11597	2328	5198	
230	UP	11646	5198	2328	
231	DN	11695	2328	5198	
232	UP	11744	5198	2328	
233	DN	11793	2328	5198	
234	UP	11842	5198	2328	
235	DN	11891	2328	5198	
236	UP	11940	5198	2328	
237	DN	11989	2328	5198	
238	UP	12038	5198	2328	
239	DN	12087	2328	5198	

EXAM NO.: 65A OPERATOR(S): (JALEJANDRO) (N/A SHEET NO.: 1 OF 1
WELL NO.: 1-PT-4-TC-1

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
240	UP	12126-	5198	2328	
241	DN	12185-	2328	5198	
242	UP	12234-	5198	2328	
243	DN	12283-	2328	5198	
244	UP	12332-	5198	2328	
245	DN	12381-	2328	5198	
246	UP	12430-	5198	2328	
247	DN	12479-	2328	5198	
248	UP	12528-	5198	2328	
249	DN	12577-	2328	5198	
250	UP	12626-	5198	2328	
251	DN	12675-	2328	5198	
252	UP	12724-	5198	2328	
253	DN	12773-	2328	5198	
254	UP	12822-	5198	2328	
255	DN	12871-	2328	5198	
256	UP	12920-	5198	2328	
257	DN	12969-	2328	5198	
258	UP	13018-	5198	2328	
259	DN	13067-	2328	5198	
260	UP	13116-	5198	2328	
261	DN	13165-	2328	5198	
262	UP	13214-	5198	2328	
263	DN	13263-	2328	5198	
264	UP	13312-	5198	2328	
265	DN	13361-	2328	5198	
266	UP	13410-	5198	2328	
267	DN	13459-	2328	5198	
268	UP	13508-	5198	2328	
269	DN	13557-	2328	5198	
270	UP	13606-	5198	2328	
271	DN	13655-	2328	5198	
272	UP	13704-	5198	2328	
273	DN	13753-	2328	5198	
274	UP	13802-	5198	2328	
275	DN	13851-	2328	5198	
276	UP	13900-	5198	2328	
277	DN	13949-	2328	5198	
278	UP	13998-	5198	2328	
279	DN	14047-	2328	5198	
280	UP	14096-	5198	2328	
281	DN	14145-	2328	5198	
282	UP	14194-	5198	2328	
283	DN	14243-	2328	5198	
284	UP	14292-	5198	2328	
285	DN	14341-	2328	5198	
286	UP	14390-	5198	2328	
287	DN	14439-	2328	5198	
288	UP	14488-	5198	2328	
289	DN	14537-	2328	5198	

SHEET NO.06EA107

EXAM NO. 65A OPERATOR(S) (JALEJANDRO (N/A) WELD NO. 1-RPV-7C&D

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
290	UP	14586	5198	2328	
291	DN	14635	2328	5198	
292	UP	14684	5198	2328	
293	DN	14733	2328	5198	
294	UP	14782	5196	2328	
295	DN	14831	2328	5198	
296	UP	14880	5198	2328	
297	DN	14929	2328	5198	
298	UP	14978	5198	2328	
299	DN	15027	2328	5198	
300	UP	15076	5198	2328	
301	DN	15125	2328	5198	
302	UP	15174	5198	2328	
303	DN	15223	2328	5198	
304	UP	15272	5198	2328	
305	DN	15321	2328	5198	
306	UP	15370	5198	2328	
307	DN	15419	2328	5198	
308	UP	15468	5196	2328	
309	DN	15517	2328	5198	
310	UP	15566	5198	2328	
311	DN	15615	2328	5198	
312	UP	15664	5198	2328	
313	DN	15713	2328	5198	
314	UP	15762	5198	2328	
315	DN	15811	2328	5198	
316	UP	15860	5198	2328	
317	DN	15909	2328	5198	
318	UP	15958	5198	2328	
319	DN	16007	2328	5198	
320	UP	16056	5198	2328	
321	DN	16105	2328	5198	
322	UP	16154	5199	2328	
323	DN	16203	2328	5198	
324	UP	16252	5198	2328	
325	DN	16301	2328	5198	
326	UP	16350	5198	2328	
327	DN	16399	2328	5198	
328	UP	16448	5198	2328	
329	DN	16497	2328	5198	
330	UP	16546	5198	2328	
331	DN	16595	2328	5198	
332	UP	16644	5198	2328	
333	DN	16693	2328	5198	
334	UP	16742	5198	2328	
335	DN	16791	2328	5198	
336	UP	16840	5198	2328	
337	DN	16889	2328	5198	
338	UP	16938	5199	2328	
339	DN	16987	2328	5198	

ND

EXAM NO. 65A OPERATOR(S): JALEJANDRO / N/A SHEET NO. 01 OF 02
WELD NO. 1-SRV-T1(

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
340	UP	17036	5198	2328	
341	DN	17085	2328	5198	
342	UP	17134	5198	2328	
343	DN	17183	2328	5198	
344	UP	17232	5198	2328	
345	DN	17281	2328	5198	
346	UP	17330	5198	2328	
347	DN	17379	2328	5198	
348	UP	17428	5198	2328	
349	DN	17477	2328	5198	
350	UP	17526	5198	2328	
351	DN	17575	2328	5198	
352	UP	17624	5198	2328	
353	DN	17673	2328	5198	
354	UP	17722	5198	2328	
355	DN	17771	2328	5198	
356	UP	17820	5198	2328	
357	DN	17869	2328	5198	
358	UP	17918	5198	2328	
359	DN	17967	2328	5198	
360	UP	18016	5198	2328	
361	DN	18065	2328	5198	
362	UP	18114	5198	2328	
363	DN	18163	2328	5198	
364	UP	18212	5198	2328	
365	DN	18261	2328	5198	
366	UP	18310	5198	2328	
367	DN	18359	2328	5198	
368	UP	18408	5198	2328	
369	DN	18457	2328	5198	
370	UP	18506	5198	2328	

REVIEWED BY: Carlos M Barrera (LEVEL II) DATE: 04 Nov 87

EXAM.NO. 65B

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=65B
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VESSEL TO FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052744
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.(DEG.)=185
5. X-STOP POS.(DEG.)=365
6. WELD LENGTH=538.15
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=11

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 3 Nov 87 RJK

EXAM NO. 65B

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052744
COMPONENT RPV SUBASSEMBLY VESSEL TO FLANGE WELD NO. 1-RPV-7042
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE PARALLEL
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-370	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-370	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-370	2	10.5

TCG OFF Ref/C

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-370	1 DIV.	7 DIV

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO.06ES101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1058) DATE(3 NOV87)

EXAM NO. 65B OPERATOR(S)(J.ALEJANDRO)(N/A) WELD NO. 1-RPV-7C-2

PARAMETERS

WELD LOC. 28.28 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 538.15
Y-FUNCTION-HOIST SWRI ROTATOR 18000 X-FUNCTION - BOOM ROTATE

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	DN	18425	2328	5198	CHANGE Y CTS. TO
2	UP	18474	5198	2328	3028 TO 5198 JA
3	DN	18523	2328	5198	
4	UP	18572	5198	2328	
5	DN	18621	2328	5198	
6	UP	18670	5198	2328	
7	DN	18719	2328	5198	
8	UP	18768	5198	2328	
9	DN	18817	2328	5198	
10	UP	18866	5198	2328	
11	DN	18915	2328	5198	
12	UP	18964	5198	2328	
13	DN	19013	2328	5198	
14	UP	19062	5198	2328	
15	DN	19111	2328	5198	
16	UP	19160	5198	2328	
17	DN	19209	2328	5198	
18	UP	19258	5198	2328	
19	DN	19307	2328	5198	
20	UP	19356	5198	2328	
21	DN	19405	2328	5198	
22	UP	19454	5198	2328	
23	DN	19503	2328	5198	
24	UP	19552	5198	2328	
25	DN	19601	2328	5198	
26	UP	19650	5198	2328	
27	DN	19699	2328	5198	
28	UP	19748	5198	2328	
29	DN	19797	2328	5198	
30	UP	19846	5198	2328	
31	DN	19895	2328	5198	
32	UP	19944	5198	2328	
33	DN	19993	2328	5198	
34	UP	20042	5198	2328	
35	DN	20091	2328	5198	
36	UP	20140	5198	2328	
37	DN	20189	2328	5198	
38	UP	20238	5198	2328	
39	DN	20287	2328	5198	

SHEET NO. 0459102

EXAM NO. 638 OPERATOR(S) (P. GAINES) (N/A) WELD NO. 1-RPV-704

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	UP	20336	5198	2328	
41	DN	20385	2328	5198	
42	UP	20434	5198	2328	
43	DN	20483	2328	5198	
44	UP	20532	5198	2328	
45	DN	20581	2328	5198	
46	UP	20630	5198	2328	
47	DN	20679	2328	5198	
48	UP	20728	5198	2328	
49	DN	20777	2328	5198	
50	UP	20826	5198	2328	
51	DN	20875	2328	5198	
52	UP	20924	5198	2328	
53	DN	20973	2328	5198	
54	UP	21022	5198	2328	
55	DN	21071	2328	5198	
56	UP	21120	5198	2328	
57	DN	21169	2328	5198	
58	UP	21218	5198	2328	
59	DN	21267	2328	5198	
60	UP	21316	5198	2328	
61	DN	21365	2328	5198	
62	UP	21414	5198	2328	
63	DN	21463	2328	5198	
64	UP	21512	5198	2328	
65	DN	21561	2328	5198	
66	UP	21610	5198	2328	
67	DN	21659	2328	5198	
68	UP	21708	5198	2328	
69	DN	21757	2328	5198	
70	UP	21806	5198	2328	
71	DN	21855	2328	5198	
72	UP	21904	5198	2328	
73	DN	21953	2328	5198	
74	UP	22002	5198	2328	
75	DN	22051	2328	5198	
76	UP	22100	5198	2328	
77	DN	22149	2328	5198	
78	UP	22198	5198	2328	
79	DN	22247	2328	5198	
80	UP	22296	5198	2328	
81	DN	22345	2328	5198	
82	UP	22394	5198	2328	
83	DN	22443	2328	5198	
84	UP	22492	5198	2328	
85	DN	22541	2328	5198	
86	UP	22590	5198	2328	
87	DN	22639	2328	5198	
88	UP	22688	5198	2328	
89	DN	22737	2328	5198	

SHEET NO.0638103

EXAM NO. 65B OPERATOR(S) (P.BAINES) (N/A) WELD NO.1-RPL-704C

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
90	UP	22786	5198	2328	
91	DN	22835	2328	5198	
92	UP	22884	5198	2328	
93	DN	22933	2328	5198	
94	UP	22982	5198	2328	
95	DN	23031	2328	5198	
96	UP	23080	5198	2328	
97	DN	23129	2328	5198	
98	UP	23178	5198	2328	
99	DN	23227	2328	5198	
100	UP	23276	5198	2328	
101	DN	23325	2328	5198	
102	UP	23374	5198	2328	
103	DN	23423	2328	5198	
104	UP	23472	5198	2328	
105	DN	23521	2328	5198	
106	UP	23570	5198	2328	
107	DN	23619	2328	5198	
108	UP	23668	5198	2328	
109	DN	23717	2328	5198	
110	UP	23766	5198	2328	
111	DN	23815	2328	5198	
112	UP	23864	5198	2328	
113	DN	23913	2328	5198	
114	UP	23962	5198	2328	
115	DN	24011	2328	5198	
116	UP	24060	5198	2328	
117	DN	24109	2328	5198	
118	UP	24158	5198	2328	
119	DN	24207	2328	5198	
120	UP	24256	5198	2328	
121	DN	24305	2328	5198	
122	UP	24354	5198	2328	
123	DN	24403	2328	5198	
124	UP	24452	5198	2328	
125	DN	24501	2328	5198	
126	UP	24550	5198	2328	
127	DN	24599	2328	5198	
128	UP	24648	5198	2328	
129	DN	24697	2328	5198	
130	UP	24746	5198	2328	
131	DN	24795	2328	5198	
132	UP	24844	5198	2328	
133	DN	24893	2328	5198	
134	UP	24942	5198	2328	
135	DN	24991	2328	5198	
136	UP	25040	5198	2328	
137	DN	25089	2328	5198	
138	UP	25138	5198	2328	
139	DN	25187	2328	5198	

SHEET NO. C605.04

EXAM NO. 65B OPERATOR(S) (P. GAINES) (JALEJANDRO) WELD NO. 1-RPV-704

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
140	UP	25236	5198	2328	
141	DN	25285	2328	5198	
142	UP	25334	5198	2328	
143	DN	25383	2328	5198	
144	UP	25432	5198	2328	
145	DN	25481	2328	5198	
146	UP	25530	5198	2328	
147	DN	25579	2328	5198	
148	UP	25628	5198	2328	
149	DN	25677	2328	5198	
150	UP	25726	5198	2328	
151	DN	25775	2328	5198	
152	UP	25824	5198	2328	
153	DN	25873	2328	5198	
154	UP	25922	5198	2328	
155	DN	25971	2328	5198	
156	UP	26020	5198	2328	
157	DN	26069	2328	5198	
158	UP	26118	5198	2328	
159	DN	26167	2328	5198	
160	UP	26216	5198	2328	
161	DN	26265	2328	5198	
162	UP	26314	5198	2328	
163	DN	26363	2328	5198	
164	UP	26412	5198	2328	
165	DN	26461	2328	5198	
166	UP	26510	5198	2328	
167	DN	26559	2328	5198	
169	UP	26608	5198	2328	
169	DN	26657	2328	5198	
170	UP	26706	5198	2328	
171	DN	26755	2328	5198	
172	UP	26804	5198	2328	
173	DN	26853	2328	5198	
174	UP	26902	5198	2328	
175	DN	26951	2328	5198	
176	UP	27000	5198	2328	
177	DN	27049	2328	5198	
178	UP	27098	5198	2328	
179	DN	27147	2328	5198	
180	UP	27196	5198	2328	
181	DN	27245	2328	5198	
182	UP	27294	5198	2328	
183	DN	27343	2328	5198	
184	UP	27392	5198	2328	
185	DN	27441	2328	5198	
186	UP	27490	5198	2328	
187	DN	27539	2328	5198	
188	UP	27588	5198	2328	
189	DN	27637	2328	5198	

SHEET NO. 043103

EXAM NO. 65B OPERATOR(S) (JALEJANDRO) (N/A) WELD NO. 1-RPV-7041

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
190	UP	27686	5196	2328	
191	DN	27735	2328	5198	
192	UP	27784	5198	2328	
193	DN	27833	2328	5198	
194	UP	27882	5198	2328	
195	DN	27931	2328	5198	
196	UP	27980	5198	2328	
197	DN	28029	2328	5198	
198	UP	28078	5198	2328	
199	DN	28127	2328	5198	
200	UP	28176	5198	2328	
201	DN	28225	2328	5198	
202	UP	28274	5198	2328	
203	DN	28323	2328	5198	
204	UP	28372	5198	2328	
205	DN	28421	2328	5198	
206	UP	28470	5198	2328	
207	DN	28519	2328	5198	
208	UP	28568	5198	2328	
209	DN	28617	2328	5198	
210	UP	28666	5198	2328	
211	DN	28715	2328	5198	
212	UP	28764	5198	2328	
213	DN	28813	2328	5198	
214	UP	28862	5198	2328	
215	DN	28911	2328	5198	
216	UP	28960	5198	2328	
217	DN	29009	2328	5198	
218	UP	29058	5198	2328	
219	DN	29107	2328	5198	
220	UP	29156	5198	2328	
221	DN	29205	2328	5198	
222	UP	29254	5198	2328	
223	DN	29303	2328	5198	
224	UP	29352	5198	2328	
225	DN	29401	2328	5198	
226	UP	29450	5198	2328	
227	DN	29499	2328	5198	
228	UP	29548	5198	2328	
229	DN	29597	2328	5198	
230	UP	29646	5198	2328	
231	DN	29695	2328	5198	
232	UP	29744	5198	2328	
233	DN	29793	2328	5198	
234	UP	29842	5198	2328	
235	DN	29891	2328	5198	
236	UP	29940	5198	2328	
237	DN	29989	2328	5198	
238	UP	30038	5198	2328	
239	DN	30087	2328	5198	

EXAM NO. 65B OPERATOR(S) J.ALEJANDRO (N/A) WELD NO. 1-RFW-70 SHEET NO. 6E33-6

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
240	UP	30136-	5198	2328	
241	DN	30185-	2328	5198	
242	UP	30234-	5198	2328	
243	DN	30283-	2328	5198	
244	UP	30332-	5198	2328	
245	DN	30381-	2328	5198	
246	UP	30430-	5198	2328	
247	DN	30479-	2328	5198	
248	UP	30528-	5198	2328	
249	DN	30577-	2328	5198	
250	UP	30626-	5198	2328	
251	DN	30675-	2328	5198	
252	UP	30724-	5198	2328	
253	DN	30773-	2328	5198	
254	UP	30822-	5198	2328	
255	DN	30871-	2328	5198	
256	UP	30920-	5198	2328	
257	DN	30969-	2328	5198	
258	UP	31018-	5198	2328	
259	DN	31067-	2328	5198	
260	UP	31116-	5198	2328	
261	DN	31165-	2328	5198	
262	UP	31214-	5198	2328	
263	DN	31263-	2328	5198	
264	UP	31312-	5198	2328	
265	DN	31361-	2328	5198	
266	UP	31410-	5198	2328	
267	DN	31459-	2328	5198	
268	UP	31508-	5198	2328	
269	DN	31557-	2328	5198	
270	UP	31606-	5198	2328	
271	DN	31655-	2328	5198	
272	UP	31704-	5198	2328	
273	DN	31753-	2328	5198	
274	UP	31802-	5198	2328	
275	DN	31851-	2328	5198	
276	UP	31900-	5198	2328	
277	DN	31949-	2328	5198	
278	UP	31998-	5198	2328	
279	DN	32047-	2328	5198	
280	UP	32096-	5198	2328	
281	DN	32145-	2328	5198	
282	UP	32194-	5198	2328	
283	DN	32243-	2328	5198	
284	UP	32292-	5198	2328	
285	DN	32341-	2328	5198	
286	UP	32390-	5198	2328	
287	DN	32439-	2328	5198	
288	UP	32488-	5198	2328	
289	DN	32537-	2328	5198	

SHEET NO.06CB107

EXAM NO. 65B OPERATOR(S) (JALEJANDRO) (N/A) WELD NO. 1-RPV-7043

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
290	UP	32586.	5198	2328	
291	DN	32635.	2328	5198	
292	UP	32684.	5198	2328	
293	DN	32733.	2328	5198	
294	UP	32782.	5198	2328	
295	DN	32831.	2328	5198	
296	UP	32880.	5198	2328	
297	DN	32929.	2328	5198	
298	UP	32978.	5198	2328	
299	DN	33027.	2328	5198	
300	UP	33076.	5198	2328	
301	DN	33125.	2328	5198	
302	UP	33174.	5198	2328	
303	DN	33223.	2328	5198	
304	UP	33272.	5198	2328	
305	DN	33321.	2328	5198	
306	UP	33370.	5198	2328	
307	DN	33419.	2328	5198	
308	UP	33468.	5198	2328	
309	DN	33517.	2328	5198	
310	UP	33566.	5198	2328	
311	DN	33615.	2328	5198	
312	UP	33664.	5198	2328	
313	DN	33713.	2328	5198	
314	UP	33762.	5198	2328	
315	DN	33811.	2328	5198	
316	UP	33860.	5198	2328	
317	DN	33909.	2328	5198	
318	UP	33958.	5198	2328	
319	DN	34007.	2328	5198	
320	UP	34056.	5198	2328	
321	DN	34105.	2328	5198	
322	UP	34154.	5198	2328	
323	DN	34203.	2328	5198	
324	UP	34252.	5198	2328	
325	DN	34301.	2328	5198	
326	UP	34350.	5198	2328	
327	DN	34399.	2328	5198	
328	UP	34448.	5198	2328	
329	DN	34497.	2328	5198	
330	UP	34546.	5198	2328	
331	DN	34595.	2328	5198	
332	UP	34644.	5198	2328	
333	DN	34693.	2328	5198	
334	UP	34742.	5198	2328	
335	DN	34791.	2328	5198	
336	UP	34840.	5198	2328	
337	DN	34889.	2328	5198	
338	UP	34938.	5198	2328	
339	DN	34987.	2328	5198	

EXAM NO. 658 OPERATOR(S) JALEJANDRO (N/A SHEET NO. 0033102
; WELD NO. -RPV-T1-J

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
340	UP	35036-	5198	2328	
341	DN	35085-	2328	5198	
342	UP	35134-	5198	2328	
343	DN	35183-	2328	5198	
344	UP	35232-	5198	2328	
345	DN	35281-	2328	5198	
346	UP	35330-	5198	2328	
347	DN	35379-	2328	5198	
348	UP	35428-	5198	2328	
349	DN	35477-	2328	5198	
350	UP	35526-	5198	2328	
351	DN	35575-	2328	5198	
352	UP	35624-	5198	2328	
353	DN	35673-	2328	5198	
354	UP	35722-	5198	2328	
355	DN	35771-	2328	5198	
356	UP	35820-	5198	2328	
357	DN	35869-	2328	5198	
358	UP	35918-	5198	2328	
359	DN	35967-	2328	5198	
360	UP	36016-	5198	2328	
361	DN	36065-	2328	5198	
362	UP	36114-	5198	2328	
363	DN	36163-	2328	5198	
364	UP	36212-	5198	2328	
365	DN	36261-	2328	5198	
366	UP	36310-	5198	2328	
367	DN	36359-	2328	5198	
368	UP	36408-	5198	2328	
369	DN	36457-	2328	5198	
370	UP	36506-	5198	2328	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(04 Nov 87)

EXAM.NO. 66A

BWFI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1551

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=66A
4.WELD NO.=1-RPV-7042
5.COMPONENT=RPV
6.SUBASSEMBLY=VESSEL-FLANGE
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052744
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=5
5. X-STOP POS.=125
6.WELD LENGTH=338.13
7.BEAM COMPONENT (CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=11
9.FIRST SCAN IF NOT 1 =0
10.LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 3 Nov 87 DSK

EXAM NO. 66A

BWRI SCAN PLAN EXAMINATION TABLES

SITE HANS BALEM . PROJECT NO. 17-1552 SCAN PATH DR. DETROIT-A
COMPONENT RPV SUBASSEMBLY VESSEL-FLANGE WELD I.D. 1-RPV-FW-1
PROCEDURE/REV/DEV 700-11.7 WELD TYPE CIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DSDE001

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	3.85
2/8	/	7.6
3/8	/	11.5
NOTCH	/	15.3
5/8	/	19.2

GATE SETTINGS		
SCAN	START	STOP
1-23	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE (IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	5.35
2/8	/	11
3/8	/	16.5
NOTCH	/	22
5/8	/	27.5

GATE SETTINGS		
SCAN	START	STOP
1-23	2	23

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE: 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.75
2/8	/	5.5
3/8	/	8.2

GATE SETTINGS		
SCAN	START	STOP
1-23	2 OK	10.5

TCGON OK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.
6	/	7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-23	1 DIV.	8 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.300

SHEET NO. 04 SA 111

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1052 TIME (1800) DATE 3 Nov 87

EXAM NO. 66A OPERATOR(S) (ALEJANDRO) (N/A) WELD NO. 1-RCP 7 RE

PARAMETERS

WELD LOC. 29.26 VESSEL DIA. 171.3 WALL THICKNESS .1
SCAN INC. (IN.) .75 (CTS.) 75 WELD LENGTH 508.15
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 Y-FUNCTION - MOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1973	500	12500	
2	CCW	2053	12500	500	
3	CW	2128	500	12500	
4	CCW	2203	12500	500	
5	CW	2278	500	12500	
6	CCW	2353	12500	500	
7	CW	2428	500	12500	
8	CCW	2503	12500	500	
9	CW	2578	500	12500	
10	CCW	2653	12500	500	
11	CW	2728	500	12500	
12	CCW	2803	12500	500	
13	CW	2878	500	12500	started @ SCAN 13 due to TAPER. JA
14	CCW	2953	12500	500	
15	CW	3028	500	12500	
16	CCW	3103	12500	500	
17	CW	3178	500	12500	
18	CCW	3253	12500	500	
19	CW	3328	500	12500	
20	CCW	3403	12500	500	
21	CW	3478	500	12500	
22	CCW	3553	12500	500	
23	CW	3628	500	12500	

JA

REVIEWED BY (Carla M Barnes) (LEVEL (II) DATE (04 Nov 87)

EXAM.NO. 663

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=663
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VESSEL-FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052744
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=125
5. X-STOP POS.=245
6. WELD LENGTH=538.15
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. FIRST SCAN IF NOT 1=0
10. LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.47 DEGREES PER INCH= .68

Completed 3 Nov 87 MK

EXAM NO. 66B

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1000 SCAN PATTERN DESIGNATION
COMPONENT RPV SUBASSEMBLY VESSEL-FLANGE WELD IDENTIFICATION
PROCEDURE/REV/DEV 700-1177 WELD TYPE SIZE SCAN TYPE
CAL BLK.NO. 11-CCCL-CC-EAM DEVICE DWG.NO./CONFIG.NO. MANUAL

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 16.7
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-2D	2	17

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.3
NOTCH	/ 22
5/5	/ 27.3

GATE SETTINGS		
SCAN	START	STOP
1-2D	1	27

INST.NO.3 / 0 DEG. INST.NO.4 / 30/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-2D	12 DAC	10.5

TCG ON DAC

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-2D	1 DIV.	8 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.30 IN.	-1.50 IN.	-1.30 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.500

SHEET NO. 1 of 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (1824) DATE 3 NOV 87

EXAM NO. 118 OPERATOR(S) JALEJANDRO (N/A) WELD NO. 1-RPV-FW-2

PARAMETERS

WELD LOC. 28.28 VESSEL DIA. 171.3 WALL THICKNESS .1
SCAN INC. (IN.) .75 (CTS.) 75 WELD LENGTH 538.15
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1978	12500	24500	
2	CCW	2053	24500	12500	
3	CW	2128	12500	24500	
4	CCW	2203	24500	12500	
5	CW	2278	12500	24500	
6	CCW	2353	24500	12500	
7	CW	2428	12500	24500	
8	CCW	2503	24500	12500	
9	CW	2578	12500	24500	
10	CCW	2653	24500	12500	
11	CW	2728	12500	24500	
12	CCW	2803	24500	12500	
13	CW	2878-	12500	24500	STARTED @ SCAN 13
14	CCW	2953-	24500	12500	due to taper, JB
15	CW	3028-	12500	24500	
16	CCW	3103-	24500	12500	
17	CW	3178-	12500	24500	
18	CCW	3253-	24500	12500	
19	CW	3328-	12500	24500	
20	CCW	3403-	24500	12500	
21	CW	3478-	12500	24500	
22	CCW	3553-	24500	12500	
23	CW	3628-	12500	24500	

JB

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (04 Nov 87)

EXAM.NO. 66C

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=66C
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VESSEL-FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052744
9. CAL.BLK.NO.=11-CSCL-33-SAM
10. DEVICE DWG.NO./CONFIG.NO.=03052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=245
5. X-STOP POS.=365
6. WELD LENGTH=538.15
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. FIRST SCAN IF NOT 1 =0
10. LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 3 Nov 87
AR

EXAM NO. 66C

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK21317A
COMPONENT RPV SUBASSEMBLY VESSEL-FLANGE WELD NO. 1-RPV-704C
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE .TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. 3305E267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.65
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-23	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.85
2/9	/ 11
3/8	/ 16.3
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-23	2	17

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-23	1/2 DAC	10.5

TCGON DAC

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-23	1 DIV.	3 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.302

SHEET NO. 062101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1102 TIME 1858 DATE 3 Nov 87

EXAM NO. S&C OPERATOR(S) JALEJANDRO (N/A) WELD NO. 1-ST-7 TO 8

PARAMETERS

WELD LOC. 20.22 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 538.15
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1978	24500	36500	
2	CCW	2053	36500	24500	
3	CW	2128	24500	36500	
4	CCW	2203	36500	24500	
5	CW	2278	24500	36500	
6	CCW	2353	36500	24500	
7	CW	2428	24500	36500	
8	CCW	2503	36500	24500	
9	CW	2578	24500	36500	
10	CCW	2653	36500	24500	
11	CW	2728	24500	36500	
12	CCW	2803	36500	24500	
13	CW	2878	24500	36500	started @ SCAN 13 due to taper. JA
14	CCW	2953	36500	24500	
15	CW	3028	24500	36500	
16	CCW	3103	36500	24500	
17	CW	3178	24500	36500	
18	CCW	3253	36500	24500	
19	CW	3328	24500	36500	
20	CCW	3403	36500	24500	
21	CW	3478	24500	36500	
22	CCW	3553	36500	24500	
23	CW	3628	24500	36500	

JA

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (04 Nov 87)

EXAM.NO. 67A

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=67A
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VESSEL TO FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=D8KI0EC744
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=5
5. X-STOP POS.=125
6. WELD LENGTH=538.15
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. FIRST SCAN IF NOT 1 =0
10. LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

Comp 3 Nov. 87 JS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .65

EXAM NO. 67A

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. [illegible]
COMPONENT RPV SUBASSEMBLY/ VESSEL TO FLANGE WELD NO. [illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE DIRC. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-SS-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.35
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-23	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.35
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-23	2	17

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-23	$\frac{1}{2}$ @	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 9

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-23	1 DIV.	9 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	-1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 502

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2002 DATE 3 NOV 87

EXAM NO. 67A OPERATOR(S) L.R. MATHENA (N/A) WELD NO. [illegible]

PARAMETERS

WELD LOC. 23.28 VESSEL DIA. 171.3 WALL THICKNESS 1.
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 538.15
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1978	500	12500	RESTART ON SCAN 1 @ 2012 TM.
2	CCW	2053	12500	500	
3	CW	2128	500	12500	
4	CCW	2203	12500	500	
5	CW	2278	500	12500	EXAM RAN FROM 5° TO 125° IN X. STARTED ON SCAN 13 DUE TO TAPER. TM
6	CCW	2353	12500	500	
7	CW	2428	500	12500	
8	CCW	2503	12500	500	
9	CW	2578	500	12500	
10	CCW	2653	12500	500	
11	CW	2728	500	12500	
12	CCW	2803	12500	500	
13	CW	2878 ✓	500	12500	
14	CCW	2953 ✓	12500	500	
15	CW	3028 ✓	500	12500	
16	CCW	3103 ✓	12500	500	
17	CW	3178 ✓	500	12500	
18	CCW	3253 ✓	12500	500	
19	CW	3328 ✓	500	12500	
20	CCW	3403 ✓	12500	500	
21	CW	3478 ✓	500	12500	
22	CCW	3553 ✓	12500	500	
23	CW	3628 ✓	500	12500	

NOZ CON

TM

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(4 Nov 87

EXAM.NO. 67B

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=67B
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VESSEL TO FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052744
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=DJ052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=125
5. X-STOP POS.=243
6. WELD LENGTH=530.15
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
7. FIRST SCAN IF NOT 1 =0
10. LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

Comp 3 Nov. 87
(JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 672

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH DX. DOWNCUT
COMPONENT RPV SUBASSEMBLY VESSEL TO FLANGE WELD NO. 1-RPV-WELD 2
PROCEDURE/REV/DEV 700-11/7 WELD TYPE CIRC. SCAN TYPE ATTACHED
CAL.BLK.NO. 11-DSCL-SS-SAM DEVICE DWG.NO./CONFIG.NO. 3009111

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-23	3	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-23	3	17

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-23	1/2 @	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE IN.) 8

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-23	1 DIV.	8 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 5008

SHEET NO. 17T12.

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1532 TIME (2046) DATE (3 Nov 87

EXAM NO. 679 OPERATOR(S L.R. MATHENA) (N/A) WELD NO. 1-RPV-7-12

PARAMETERS

WELD LOC. 29.29 VESSEL DIA. 171.3 WALL THICKNESS .1
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 538.15
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1978	12500	24500	SCAN 1 - 12 NOT RAN DUE TO TAPER. TW
2	CCW	2053	24500	12500	
3	CW	2128	12500	24500	
4	CCW	2203	24500	12500	
5	CW	2278	12500	24500	
6	CCW	2353	24500	12500	
7	CW	2428	12500	24500	
8	CCW	2503	24500	12500	
9	CW	2578	12500	24500	
10	CCW	2653	24500	12500	
11	CW	2728	12500	24500	
12	CCW	2803	24500	12500	
13	CW	2878	12500	24500	
14	CCW	2953	24500	12500	
15	CW	3028	12500	24500	
16	CCW	3103	24500	12500	
17	CW	3178	12500	24500	
18	CCW	3253	24500	12500	
19	CW	3328	12500	24500	
20	CCW	3403	24500	12500	
21	CW	3478	12500	24500	
22	CCW	3553	24500	12500	
23	CW	3628	12500	24500	

REVIEWED BY(TW Heath Reiz) (LEVEL(III) DATE(4 Nov 87

EXAM.NO. 67C

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=67C
4.WELD NO.=1-RPV-7042
5.COMPONENT=RPV
6.SUBASSEMBLY=VESSEL TO FLANGE
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSKC0527744
9.CAL.BLK.NO.=11-CSCL-53-3AM
10.DEVICE DWG.NO./CONFIG.NO.=C3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=29.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=245
5. X-STOP POS.=365
6.WELD LENGTH=338.15
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=11
9.FIRST SCAN IF NOT 1 =0
10.LAST SCAN IF LIMITATIONS=0

X-CONVERSION PARAMETERS

Comp 3 Nov. 87
(12)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .668

EXAM NO. 67C

BWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1332 SCAN PATH SK. DEVICE/TA
COMPONENT RFV SUBASSEMBLY VESSEL TO FLANGE WELD NO. 1-RFV-1-VE
PROCEDURE/REV.DEV 700-11.7 WELD TYPE CIRC. SEAM TYPE
ISAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. 8205210.67

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NOTCH/SWEEP DIST.	
1/8	/ 3.83
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-23	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NOTCH/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-23	1	15

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NOTCH/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-23	1/2 (13)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 8

CAL.NOTCH/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-23	1 DIV.	8 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 500

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME: 2136 DATE: 3 NOV 87

EXAM NO. 67C OPERATOR(S): L.R. MATHERA (N/A) WELD NO. 1-RT-7-IC

PARAMETERS

ELB LOC. 28.28 VESSEL DIA. 171.3 WALL THICKNESS 1.1
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 538.15
X-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 Y-FUNCTION - HOIST

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1978	24500	36500	
2	CCW	2053	36500	24500	
3	CW	2128	24500	36500	Run From 2878 to 3628
4	CCW	2203	36500	24500	in X. CTS. TW
5	CW	2278	24500	36500	
6	CCW	2353	36500	24500	
7	CW	2428	24500	36500	
8	CCW	2503	36500	24500	
9	CW	2578	24500	36500	
10	CCW	2653	36500	24500	
11	CW	2728	24500	36500	
12	CCW	2803	36500	24500	
~~13~~ 1	CW	2878 ✓	24500	36500	
~~14~~ 2	CCW	2953 ✓	36500	24500	
~~15~~ 3	CW	3028 ✓	24500	36500	
~~16~~ 4	CCW	3103 ✓	36500	24500	
~~17~~ 5	CW	3178 ✓	24500	36500	
~~18~~ 6	CCW	3253 ✓	36500	24500	
~~19~~ 7	CW	3328 ✓	24500	36500	
~~20~~ 8	CCW	3403 ✓	36500	24500	
~~21~~ 9	CW	3478 ✓	24500	36500	
~~22~~ 10	CCW	3553 ✓	36500	24500	
~~23~~ 11	CW	3628 ✓	24500	36500	

TW TW

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(4 NOV 87

EXAM.NO. 68

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=68
4. WELD NO.=1-RPV-1042B
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=367
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.16 (JS)
5. X-STOP POS.=~~38.28~~ 41.44
6. WELD LENGTH=99
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS Comp 3 Nov-87 (JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 68

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1852 SCAN PATH SK. [illegible]
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-[illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE [illegible]
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-16	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-16	2	33

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-16	+2@	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	+DIV. @

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.30D

SHEET NO. 032101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(2218) DATE(3 NOV 87

EXAM NO. 6E OPERATOR(S) LR/ATHENA)(N/A) WELD NO. 1-RF/-1X6E

PARAMETERS

WELD LOC. 367 VESSEL DIA. 171.3 WALL THICKNESS 1.1
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 99
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	2716	35136	37030	
2	CCW	2791	37030	35136	
3	CW	2866	35136	37030	
4	CCW	2941	37030	35136	
5	CW	3016	35136	37030	
6	CCW	3091	37030	35136	
7	CW	3166	35136	37030	
8	CCW	3241	37030	35136	
9	CW	3316	35136	37030	
10	CCW	3391	37030	35136	
11	CW	3466	35136	37030	
12	CCW	3541	37030	35136	
13	CW	3616	35136	37030	
14	CCW	3691	37030	35136	
15	CW	3766	35136	37030	
16	CCW	3841	37030	35136	
		3916			
		3991			
		4066			
		4141			

SCAN. 1 THUR 16 X CTS. ARE 3016 TO 4141 TW

RESTART SCAN 1 @ 2223

REVIEWED BY(Hector Alvarez) (LEVEL(III) DATE(6 NOV 87

TW

EXAM.NO. 69

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=69
4.WELD NO.=1-RPV-1042B
5.COMPONENT=RPV
6.SUBASSEMBLY=UPPER SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052746
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=7
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.18~~ 30.19 JS
5. X-STOP POS.=~~36.28~~ 41.91
6.WELD LENGTH=99
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=11
9.Y-START IF LIMITATIONS=0
10.Y-STOP IF LIMITATIONS=0

Comp 3 Nov 87
JS

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 69

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. ISKIISST1a
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1,403
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 11-C3CL-53-SAM DEVICE DWG.NO./CONFIG.NO. 000SEC57

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.85	SCAN	START	STOP
2/8	/ 7.6	1-16	2	17
3/8	/ 11.5			
NOTCH	/ 15.3			
5/8	/ 19.2			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 5.55	SCAN	START	STOP
2/8	/ 11	1-16	2	22
3/8	/ 16.5			
NOTCH	/ 22			
5/8	/ 27.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.75	SCAN	START	STOP
2/8	/ 5.5	1-16	~~1~~ 2@	10.5
3/8	/ 8.2			

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-16	1 DIV.	~~8~~ 7@ DIV.
3	/ 4 DIV.			
4	/ 5 DIV.			
5	/ 6 DIV.			
6	/ 7 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.30 IN.

MODULE CONFIGURATION NO. 50B

SHEET NO. 069.01

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(2249 DATE: 3 NOV 87

EXAM NO. 29 OPERATOR(S): L.R. MATHENA (N/A) WELD NO. 1-RPV-1-1.11

PARAMETERS

WELD LOC. 7 VESSEL DIA. 171.3 WALL THICKNESS 8.1
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 99
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN		DIR	X-POS	Y-START	Y-STOP	REMARKS
1		CW	2716	370	2264	
2		CCW	2791	2264	370	
3		CW	2866	370	2264	30.16 To 41.41 CTS
4		CCW	2941	2264	370	IN X Dir
5	1	CW	3016	370	2264	
6	2	CCW	3091	2264	370	
7	3	CW	3166	370	2264	
8	4	CCW	3241	2264	370	
9	5	CW	3316	370	2264	
10	6	CCW	3391	2264	370	
11	7	CW	3466	370	2264	
12	8	CCW	3541	2264	370	
13	9	CW	3616	370	2264	
14	10	CCW	3691	2264	370	
15	11	CW	3766	370	2264	
16	12	CCW	3841	2264	370	
	13		3916			
	14		3991			
	15		4066			
	16		4141			

REVIEWED BY: Hunter Ellis (LEVEL(III) DATE(4 NOV 87

EXAM.NO. 70

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=70
4.WELD NO.=1-RPV-1042B
5.COMPONENT=RPV
6.SUBASSEMBLY=UPPER SHELL
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052746
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=7
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.28 JS
5. X-STOP POS.=38.29 64.00
6.WELD LENGTH=99
7.BEAM COMPONENT (DN=1,UP=0)=0
8.CAL.BLK.THICKNESS(IN.)=11
9.Y-START IF LIMITATIONS= 0
10.Y-STOP IF LIMITATIONS= 0

Comp 4 Nov 87 JS

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 70

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1352 SCAN PATH SK. DSK3052736
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1042B
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. 5305226?

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.85	SCAN	START	STOP
2/8	/ 7.6			
3/8	/ 11.5	1-22	2	17
NOTCH	/ 15.3			
5/8	/ 19.2			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 5.55	SCAN	START	STOP
2/8	/ 11			
3/8	/ 16.5	1-22	2	23
NOTCH	/ 22			
5/8	/ 27.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.75	SCAN	START	STOP
2/8	/ 5.5			
3/8	/ 8.2	1-22	~~+20~~	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-22	1 DIV.	~~8 DIV.~~ 7 (63)
4	/ 5 DIV.			
5	/ 6 DIV.			
6	/ 7 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 3701-31

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(2345) DATE 3 NOV 87

EXAM NO. 70 OPERATOR(S) L.R. MATHENA N/A) WELD NO. 1-RPV-11-128

PARAMETERS

WELD LOC. 7 VESSEL DIA. 171.3 WALL THICKNESS 1
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 99
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	205	2416	5698	
2	UP	254	5698	2416	
3	DN	303	2416	5698	70A { X CTS RAN FROM 30.28
4	UP	352	5698	2416	TO 64.00 SCANS 1 THUR 14 TH
5	DN	401	2416	5698	
6	UP	450	5698	2416	
7	DN	499	2416	5698	70B { 15 THUR 22 30.28 TO 60.00;
8	UP	546	5698	2416	
9	DN	597	2416	5698	
10	UP	646	5698	2416	
11	DN	695	2416	5698	
12	UP	744	5698	2416	
13	DN	793	2416	5698	
14	UP	842	5698	2416	
15	DN	891	2416	5698	
16	UP	940	5698	2416	
17	DN	989	2416	5698	
18	UP	1038	5698	2416	
19	DN	1087	2416	5698	
20	UP	1136	5698	2416	
21	DN	1185	2416	5698	
22	UP	1234	5698	2416	

REVIEWED BY(Neeta Hlay) (LEVEL(III) DATE(6 NOV 87)

EXAM.NO. 71

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=71
4. WELD NO.=1-RPV-1042B
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=7
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.28 JS
5. X-STOP POS.=~~38.29~~ 43.00
6. WELD LENGTH=99
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Comp 4 Nov. 87 JS

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 71

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052746
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1?A?B
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-22	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-22	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-22	~~4~~ 2 @	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-22	1 DIV.	~~8~~ 7 DIV. @

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.30 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. 0711.

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0036) DATE(4 NOV 87

EXAM NO. 71 OPERATOR(S) (P.C. TURNER) (N/A) WELD NO. 1-RPV-11428

PARAMETERS

WELD LOC. 7 VESSEL DIA. 171.3 WALL THICKNESS 1
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 99
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	205	846	4128	30.28 - 4350 @ throughout Exam @
2	UP	254	4128	846	
3	DN	303	846	4128	
4	UP	352	4128	846	
5	DN	401	846	4128	
6	UP	450	4128	846	
7	DN	499	846	4128	
8	UP	548	4128	846	
9	DN	597	846	4128	
10	UP	646	4128	846	
11	DN	695	846	4128	
12	UP	744	4128	846	
13	DN	793	846	4128	
14	UP	842	4128	846	
15	DN	891	846	4128	
16	UP	940	4128	846	
17	DN	989	846	4128	
18	UP	1038	4128	846	
19	DN	1087	846	4128	
20	UP	1136	4128	846	
21	DN	1185	846	4128	
22	UP	1234	4128	846	

REVIEWED BY(Heath Liz) (LEVEL(III) DATE(4 Nov 87)

EXAM.NO. 72

BWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1052

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=72
4. WELD NO.=1-RPV-1042C
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.16 (J9)
5. X-STOP POS.=~~38.28~~ 41.41 (J9)
6. WELD LENGTH=99
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 4 Nov 87 (J9)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 72

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3S52746
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-104-20
PROCEDURE/REV/DEV 709-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 11-CSCL-33-SAM DEVICE DWG.NO./CONFIG.NO. D3J932A7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-16	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-16	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-16	~~+~~ 2	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	~~5~~ 7 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.

MODULE CONFIGURATION NO.50D

SHEET NO. 0?[illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (0058) DATE 4 Nov 87

EXAM NO. 72 OPERATOR(S) P.C. TURNER) (N/A) WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 127 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 99
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN		DIR	X-POS	Y-START	Y-STOP	REMARKS
1		CW	2716	11136	13030	
2		CCW	2791	13030	11136	
3		CW	2866	11136	13030	
4		CCW	2941	13030	11136	
5	1	CW	3016	11136	13030	
6	2	CCW	3091	13030	11136	
7	3	CW	3166	11136	13030	
8	4	CCW	3241	13030	11136	
9	5	CW	3316	11136	13030	
10	6	CCW	3391	13030	11136	
11	7	CW	3466	11136	13030	
12	8	CCW	3541	13030	11136	
13	9	CW	3616	11136	13030	
14	10	CCW	3691	13030	11136	
15	11	CW	3766	11136	13030	
16	12	CCW	3841	13030	11136	
	13		3916			
	14		3991			
	15		4066			
	16		4141			

REVIEWED BY( ) (LEVEL( ) DATE(, ,)

Hector Diaz III 4 Nov 87

EXAM.NO. 73

SWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=73
4. WELD NO.=1-RPV-1042C
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.16 (JS)
5. X-STOP POS.=~~38.26~~ 41.41
6. WELD LENGTH=99
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Y-CONVERSION PARAMETERS

Comp 4 Nov. 87 (JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 73

EWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSKD0E2746
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1045E
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-16	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-16	2	22

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-16	+2 (JS)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	~~8 DIV.~~ (JS) 7

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 508

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0114) DATE 4 Nov 87

CYAN NO. 72 OPERATOR(S) (P.C. TURNER (N/A) WELD NO. 1-SP/-11-KII

PARAMETERS

WELD LOC. 127 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 99
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	2716	12370	14264	
2	CCW	2791	14264	12370	
3	CW	2866	12370	14264	
4	CCW	2941	14264	12370	
5	CW	3016	12370	14264	Scan 1 3016 - Thru Scan 16 @ 4191
6	CCW	3091	14264	12370	
7	CW	3166	12370	14264	
8	CCW	3241	14264	12370	
9	CW	3316	12370	14264	
10	CCW	3391	14264	12370	
11	CW	3466	12370	14264	
12	CCW	3541	14264	12370	
13	CW	3616	12370	14264	
14	CCW	3691	14264	12370	
15	CW	3766	12370	14264	
16	CCW	3841	14264	12370	
13		3916			
14		3991			
15		4066			
16		4191			

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(4 Nov 87

EXAM.NO. 74

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=74
4. WELD NO.=1-RPV-1042C
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.28 (JS)
5. X-STOP POS.=~~38.28~~ 64.00
6. WELD LENGTH=99
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Y-CONVERSION PARAMETERS

Comp 4 Nov 87 (JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 74

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. D8K3052746.
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1041C
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	3.85
2/8	/	7.6
3/8	/	11.5
NOTCH	/	15.3
5/8	/	19.2

GATE SETTINGS		
SCAN	START	STOP
1-22	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	5.55
2/8	/	11
3/8	/	16.5
NOTCH	/	22
5/8	/	27.5

GATE SETTINGS		
SCAN	START	STOP
1-22	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.75
2/8	/	5.5
3/8	/	8.2

GATE SETTINGS		
SCAN	START	STOP
1-22	+2 (12)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.
6	/	7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-22	1 DIV.	~~8~~ 7 DIV. (12)

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 500

SHEET NO. ST41

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1:37) DATE 4 NOV 87

EXAM NO. 74 OPERATOR(S) (P.C. TURNER) (N/A) WELD I.D. 1-[illegible]

PARAMETERS

WELD LOC. 127 VESSEL DIA. 171.3 WALL THICKNESS 1[illegible]
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 99
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	12205	2416	5698	30.28 - 64.00
2	UP	12254	5698	2416	64.00 - 30.28
3	DN	12303	2416	5698	
4	UP	12352	5698	2416	
5	DN	12401	2416	5698	
6	UP	12450	5698	2416	
7	DN	12499	2416	5698	
8	UP	12548	5698	2416	
9	DN	12597	2416	5698	
10	UP	12646	5698	2416	
11	DN	12695	2416	5698	
12	UP	12744	5698	2416	
13	DN	12793	2416	5698	
14	UP	12842	5698	2416	
15	DN	12891	2416	5698	
16	UP	12940	5698	2416	
17	DN	12989	2416	5698	
18	UP	13038	5698	2416	
19	DN	13087	2416	5698	
20	UP	13136	5698	2416	
21	DN	13185	2416	5698	
22	UP	13234	5698	2416	

REVIEWED BY(Weston Hicks) (LEVEL(III) DATE(4 NOV 87)

EXAM.NO. 75

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=75
4. WELD NO.=1-RPV-1042C
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=127
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.15~~ 30.28 (JS)
5. X-STOP POS.=~~38.28~~ 43.00
6. WELD LENGTH=99
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Comp 4 Nov. 87 (JS)

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 75

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1550. SCAN PATH SK. DSK0022743.
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-10427
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D305229/7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-22	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-22	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-22	+2 (SS)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-22	1 DIV.	~~8~~ 7 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.123 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO. [illegible]

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0158) DATE: 4 Nov 87

EXAM NO. 75 OPERATOR(S): P.C.TURNER (N/A) WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 127 VESSEL DIA. 171.3 WALL THICKNESS 1.
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 99
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	12205	846	4128	X 3028 - 4300
2	UP	12254	4128	846	X 4300 30.28 D
3	DN	12303	846	4128	
4	UP	12352	4128	846	
5	DN	12401	846	4128	
6	UP	12450	4128	846	
7	DN	12499	846	4128	
8	UP	12548	4128	846	
9	DN	12597	846	4128	
10	UP	12646	4128	846	
11	DN	12695	846	4128	
12	UP	12744	4128	846	
13	DN	12793	846	4128	
14	UP	12842	4128	846	
15	DN	12891	846	4128	
16	UP	12940	4128	846	
17	DN	12989	846	4128	
18	UP	13038	4128	846	
19	DN	13087	846	4128	
20	UP	13136	4128	846	
21	DN	13185	846	4128	
22	UP	13234	4128	846	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(04,Nov,87)

EXAM.NO. 76

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=76
4. WELD NO.=1-RPV-1042A
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=247
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.16
5. X-STOP POS.=~~39.29~~ 41.41 (JS)
6. WELD LENGTH=99
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Comp 4 Nov 87 (JS)

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

000800

EXAM NO. 76

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK2052Y-A
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-102CA
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE PARALLEL
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. EDDS223

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-16	2	17

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-16	2	23

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-16	±2 (JS)	10.5

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	÷ DIV. (JS) 7

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.
Y-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO.500

SHEET NO. 07-101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 0219) DATE 4 Nov 87

EXAM NO. 76 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RPV-[illegible]

PARAMETERS

WELD LOC. 247 . VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 99
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 27000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	2716	23136	25030	
2	CCW	2791	25030	23136	
3	CW	2866	23136	25030	X CTS. 30.16 TO 41.41 (AA)
4	CCW	2941	25030	23136	
5	CW	3016	23136	25030	
6	CCW	3091	25030	23136	
7	CW	3166	23136	25030	
8	CCW	3241	25030	23136	
9	CW	3316	23136	25030	
10	CCW	3391	25030	23136	
11	CW	3466	23136	25030	
12	CCW	3541	25030	23136	
13	CW	3616	23136	25030	
14	CCW	3691	25030	23136	
15	CW	3766	23136	25030	
16	CCW	3841	25030	23136	

(MMB)

REVIEWED BY Carlos M. Barrera (LEVEL II) DATE (04 Nov 87)

EXAM.NO. 77

EMAT SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=77
4. WELD NO.=1-RPV-1042A
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=247
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.16
5. X-STOP POS.=~~38.28~~ 41.41 SD
6. WELD LENGTH=99
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS=0
10. Y-STOP IF LIMITATIONS=0

Comp 4 NOV. 88 SD

JB

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

X-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

EXAM NO. 77

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SI. DSKSCIET+1
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1.AC2
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE [illegible]
CAL.BLK.NO. 11-SSCL-SU-SAM DEVICE DWG.NO./CONFIG.NO. SSCSSIET

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG. INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-16	2	17

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.3
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-16	2	23

****

INST.NO.3 / 0 DEG. INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-16	+2 (52)	10.5

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-16	1 DIV.	~~5~~ DIV. (52) 7

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.
Y-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.

MODULE CONFIGURATION NO. 508

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1550 TIME 0236 DATE 4 NOV 87

EXAM NO. 77 OPERATOR(S) L.R. MATTHEWS / N/A WELD NO. 1 87-1-10A

PARAMETERS

WELD LOC. 247 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 75 WELD LENGTH 99
Y-FUNCTION - BOOM ROTATE SWRI ROTATOR 9000 X-FUNCTION - HOIST

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	CW	2716	24370	26264	
2	CCW	2791	26264	24370	
3	CW	2866	24370	26264	X CTS 30.16 TO 41.41
4	CCW	2941	26264	24370	
5	CW	3016	24370	26264	
6	CCW	3091	26264	24370	
7	CW	3166	24370	26264	
8	CCW	3241	26264	24370	
9	CW	3316	24370	26264	
10	CCW	3391	26264	24370	
11	CW	3466	24370	26264	
12	CCW	3541	26264	24370	
13	CW	3616	24370	26264	
14	CCW	3691	26264	24370	
15	CW	3766	24370	26264	
16	CCW	3841	26264	24370	

REVIEWED BY(Carlos M Barrera LEVEL(II) DATE(04 Nov 87

EXAM.NO. 78

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=78
4. WELD NO.=1-RPV-1042A
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=247
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.18~~ 30.28 (JS)
5. X-STOP POS.=~~30.28~~ 63.00
6. WELD LENGTH=99
7. BEAM COMPONENT (DN=1,UP=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Comp 4 Nov 87 (JS)

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.47 DEGREES PER INCH= .66

EXAM NO. 78

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSKZ052746
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1042A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANS/MERID
CAL.BLK.NO. 11-CSCL-33-SAM DEVICE DWG.NO./CONFIG.NO. DZC522.7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.85	SCAN	START	STOP
2/8	/ 7.6	1-22	2	17
3/8	/ 11.5			
NOTCH	/ 15.3			
5/8	/ 19.2			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 5.55	SCAN	START	STOP
2/8	/ 11	1-22	2	23
3/8	/ 16.5			
NOTCH	/ 22			
5/8	/ 27.5			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.75	SCAN	START	STOP
2/8	/ 5.5	1-22	~~1~~ 2 (35)	10.5
3/8	/ 8.2			

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT UP SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-22	1 DIV.	~~3~~ 7 DIV. (35)
3	/ 4 DIV.			
4	/ 5 DIV.			
5	/ 6 DIV.			
6	/ 7 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	-1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 50C

SHEET NO. 078101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0257) DATE: 4 NOV 87

EXAM NO. 78 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RPV-13(3A

PARAMETERS

WELD LOC. 347 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 99
X-FUNCTION-HOIST SWRI ROTATOR 18000 Y-FUNCTION - 90CM RCTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	24205	2416	5698	
2	UP	24254	5698	2416	X CTS. 30.16 TO 63.74
3	DN	24303	2416	5698	
4	UP	24352	5698	2416	
5	DN	24401	2416	5698	
6	UP	24450	5698	2416	
7	DN	24499	2416	5698	
8	UP	24548	5698	2416	
9	DN	24597	2416	5698	
10	UP	24646	5698	2416	
11	DN	24695	2416	5698	
12	UP	24744	5698	2416	
13	DN	24793	2416	5698	
14	UP	24842	5698	2416	
15	DN	24891	2416	5698	
16	UP	24940	5698	2416	
17	DN	24989	2416	5698	
18	UP	25038	5698	2416	
19	DN	25087	2416	5698	
20	UP	25136	5698	2416	
21	DN	25185	2416	5698	
22	UP	25234	5698	2416	

REVIEWED BY Lee McBurnett (LEVEL (II) DATE (04 Nov 87)

EXAM.NO. 79

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=79
4. WELD NO.=1-RPV-1042A
5. COMPONENT=RPV
6. SUBASSEMBLY=UPPER SHELL
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052746
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=247
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=~~27.16~~ 30.28 (JS)
5. X-STOP POS.=~~38.28~~ 43.00
6. WELD LENGTH=99
7. BEAM COMPONENT (DN=1,UP=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. Y-START IF LIMITATIONS= 0
10. Y-STOP IF LIMITATIONS= 0

Comp
4 Nov 87
(JS)

Y-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 79

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. D8K3052744.
COMPONENT RPV SUBASSEMBLY UPPER SHELL WELD NO. 1-RPV-1042A
PROCEDURE/REV/DEV 700-11/7 WELD TYPE VERT. SCAN TYPE TRANSVERSE
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.35	SCAN	START	STOP
2/8	/ 7.6	1-22	2	17
3/8	/ 11.5			
NOTCH	/ 15.3			
5/8	/ 19.2			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 5.5	SCAN	START	STOP
2/8	/ 11	1-22	2	23
3/8	/ 16.5			
NOTCH	/ 22			
5/8	/ 27.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.75	SCAN	START	STOP
2/8	/ 5.5	1-22	~~1~~ 2 (SE)	10.5
3/8	/ 8.2			

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT DN SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-22	1 DIV.	~~6~~ 7 DIV. (SE)
3	/ 4 DIV.			
4	/ 5 DIV.			
5	/ 6 DIV.			
6	/ 7 DIV.			

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.50A

SHEET NO.079101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0317) DATE 4 NOV 87

EXAM NO. 79 OPERATOR(S) LR MATHENA (N/A) WELD NO. 1-RPW-1041A

PARAMETERS

WELD LOC. 247 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) 49 WELD LENGTH 99
X-FUNCTION-HOIST SWRI ROTATOR 0 Y-FUNCTION - BOOM ROTATE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	DN	24205	846	4128	
2	UP	24254	4128	846	
3	DN	24303	846	4128	
4	UP	24352	4128	846	
5	DN	24401	846	4128	
6	UP	24450	4128	846	
7	DN	24499	846	4128	
8	UP	24548	4128	846	
9	DN	24597	846	4128	
10	UP	24646	4128	846	
11	DN	24695	846	4128	
12	UP	24744	4128	846	
13	DN	24793	846	4128	
14	UP	24842	4128	846	
15	DN	24891	846	4128	
16	UP	24940	4128	846	
17	DN	24989	846	4128	
18	UP	25038	4128	846	
19	DN	25087	846	4128	
20	UP	25136	4128	846	
21	DN	25185	846	4128	
22	UP	25234	4128	846	

30.28 to 43 cts. in X. fw

REVIEWED BY(Carlos M Barrera) (LEVEL(II) DATE(04 Nov 87)

EXAM.NO. 80

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=80
4. WELD NO.=29-RPV-1140-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT SH TO NOZ
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 22

X-CONVERSION PARAMETERS

Comp 5 Nov. 87
(JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 80

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1140-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DSCS2267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

TCGON DAC

GATE SETTINGS		
SCAN	START	STOP
1-17	+ 3 @ 10	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	~~3~~ DIV. (55) 7

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.090101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME( ) DATE(4 NOV.87)

EXAM NO. 80 OPERATOR(S) (J ALEJANDRO)(N/A) WELD NO. 29-RPV-1140-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .5(CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	39.72	
2	CCW	85.62	40.05	
3	CW	85.62	40.38	
4	CCW	85.62	40.71	
5	CW	85.62	41.04	
6	CCW	85.62	41.37	
7	CW	85.62	41.7	
8	CCW	85.62	42.03	
9	CW	85.62	42.36	
10	CCW	85.62	42.69	
11	CW	85.62	43.02	
12	CCW	85.62	43.35	
13	CW	85.62	43.68	
14	CCW	85.62	44.01	
15	CW	85.62	44.34	
16	CCW	85.62	44.67	
17	CW	85.62	45	

Exam start @ scan 11
Y coordinates start 5235 ##

REVIEWED BY(Heath Day) (LEVEL(III) DATE(5 NOV 87)

EXAM.NO. 81

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=81
4. WELD NO.=29-RPV-1140-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT SH TO NOZ
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 22

X-CONVERSION PARAMETERS

Comp 5 NOV. 87

(15)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 81

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1140-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

TCG OFF DHK

GATE SETTINGS		
SCAN	START	STOP
1-17	3 DHK	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	7.8 DIV. DHK

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO.081101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME (0427) DATE (5 Nov 87)

EXAM NO. 81 OPERATOR(S) L.R. MATHEWS (N/A) WELD NO. 29-RPV-1140-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .5(CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	4.28	
2	CCW	85.62	3.95	
3	CW	85.62	3.62	
4	CCW	85.62	3.29	
5	CW	85.62	2.96	
6	CCW	85.62	2.63	
7	CW	85.62	2.3	
8	CCW	85.62	1.97	RAN SCANS 9-17.
9	CW	85.62	1.64	
10	CCW	85.62	1.31	
11	CW	85.62	.98	
12	CCW	85.62	.65	
13	CW	85.62	.32	
14	CCW	85.62	-.01	
15	CW	85.62	-.34	
16	CCW	85.62	-.67	
17	CW	85.62	-1	

REVIEWED BY(Heather Klein) (LEVEL(III) DATE(5 Nov 87)

EXAM.NO. 82

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=82
4. WELD NO.=27.5-RPV-1140-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ TO SH
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 67

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 4 Nov 87 RAK

EXAM NO. 82

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 17.E-RPV-1140-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DS052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	13 Blk	10.5

TCG ON Blk

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	7/8 DIV. Blk

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.082101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(1112) DATE(4 NOV 87

EXAM NO. 82 OPERATOR(S) (J. ALEJANDRO (P. GAINES N/A) WELD NO. 27.5-APV-1140-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 1.1
SCAN INC.(IN.) .75(CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	81	see exam sht (mg)
2	CCW	85.62	81.5	
3	CW	85.62	82	
4	CCW	85.62	82.5	
5	CW	85.62	83	
6	CCW	85.62	83.5	
7	CW	85.62	84	
8	CCW	85.62	84.5	
9	CW	85.62	85	
10	CCW	85.62	85.5	
11	CW	85.62	86	
12	CCW	85.62	86.5	
13	CW	85.62	87	
14	CCW	85.62	87.5	
15	CW	85.62	88	
16	CCW	85.62	88.5	
17	CW	85.62	89	
18	CCW	85.62	89.5	
19	CW	85.62	90	
20	CCW	85.62	90.5	
21	CW	85.62	91	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(04 Nov 87)

EXAM.NO. 83

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-5770
3.EXAM NO.=83
4.WELD NO.=27.5-RPV-1140-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ TO SH
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6.WELD LENGTH=166.5
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=11
9.NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 67

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 4 Nov 97 DHK

EXAM NO. 83

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSN3C52739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 27.S-RPV-1140-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DSC522.7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

TCG OFF OK

GATE SETTINGS		
SCAN	START	STOP
1-21	+3 OK	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	3 DIV. OK

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO.083101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(1447) DATE(4 Nov,87)

EXAM NO. 83 OPERATOR(S) (ALEJANDRO) (N/A) WELD NO. 27.5-RPV-1140-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR O X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	53	
2	CCW	85.62	52.5	see exam sht #3
3	CW	85.62	52	
4	CCW	85.62	51.5	
5	CW	85.62	51	
6	CCW	85.62	50.5	
7	CW	85.62	50	
8	CCW	85.62	49.5	
9	CW	85.62	49	
10	CCW	85.62	48.5	
11	CW	85.62	48	
12	CCW	85.62	47.5	
13	CW	85.62	47	
14	CCW	85.62	46.5	
15	CW	85.62	46	
16	CCW	85.62	45.5	
17	CW	85.62	45	
18	CCW	85.62	44.5	
19	CW	85.62	44	
20	CCW	85.62	43.5	
21	CW	85.62	43	

#

REVIEWED BY(Carlos M Barrera)(LEVEL(II) DATE(05 Nov,87)

EXAM.NO. 84

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=84
4. WELD NO.=27.5-RPV-1130-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ TO SH
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 113

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 4 Nov 87 DSK

EXAM NO. 84

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3552739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 27.3-RPV-1130-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	3.85
2/8	/	7.6
3/8	/	11.5
NOTCH	/	15.3
5/8	/	19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	5.55
2/8	/	11
3/8	/	16.5
NOTCH	/	22
5/8	/	27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	1	33

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.75
2/8	/	5.5
3/8	/	8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	x3 DWL	10.5

TCG ON SSK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.
6	/	7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	7 DIV. SSK

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.084101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME (1630) DATE (4 NOV, 87)

EXAM NO. 84 OPERATOR(S) (JALEJANDRO (~~C. GAMES~~) WELD NO. 27.5-RPV-1130-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	127	see exam sheet
2	CCW	85.62	127.5	
3	CW	85.62	128	
4	CCW	85.62	128.5	
5	CW	85.62	129	
6	CCW	85.62	129.5	
7	CW	85.62	130	
8	CCW	85.62	130.5	
9	CW	85.62	131	
10	CCW	85.62	131.5	
11	CW	85.62	132	
12	CCW	85.62	132.5	
13	CW	85.62	133	
14	CCW	85.62	133.5	
15	CW	85.62	134	
16	CCW	85.62	134.5	
17	CW	85.62	135	
18	CCW	85.62	135.5	
19	CW	85.62	136	
20	CCW	85.62	136.5	
21	CW	85.62	137	

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (05 Nov, 87)

EXAM.NO. 85

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=85
4. WELD NO.=27.5-RPV-1130-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ TO SH
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 113

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 4 NOV 87 ASK

EXAM NO. 85

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSKC052739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 27.S-RPV-1130-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	3.85
2/8	/	7.6
3/8	/	11.5
NOTCH	/	15.3
5/8	/	19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	5.55
2/8	/	11
3/8	/	16.5
NOTCH	/	22
5/8	/	27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

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INST.NO.3 / 0. DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.75
2/8	/	5.5
3/8	/	8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	r3 DLK	10.5

TCG OFF DLK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.
6	/	7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	7 DIV. DLK

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO. 085101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME (1804) DATE 4 NOV, 87)

EXAM NO. 85 OPERATOR(S) (JALEJANDRO (N/A) WELD NO. 27.5-RPV-1130-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC. (IN.) .75 (CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR O X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62 -	99	see exam sheet
2	CCW	85.62 -	98.5	
3	CW	85.62-	98	
4	CCW	85.62-	97.5	
5	CW	85.62-	97	
6	CCW	85.62-	96.5	
7	CW	85.62 -	96	
8	CCW	85.62 -	95.5	
9	CW	85.62-	95	
10	CCW	85.62-	94.5	
11	CW	85.62-	94	
12	CCW	85.62-	93.5	
13	CW	85.62-	93	
14	CCW	85.62-	92.5	
15	CW	85.62-	92	
16	CCW	85.62-	91.5	
17	CW	85.62-	91	
18	CCW	85.62	90.5	
19	CW	85.62-	90	
20	CCW	85.62 -	89.5	
21	CW	85.62-	89	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (05, Nov, 87)

EXAM.NO. 86

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=86
4. WELD NO.=29-RPV-1130-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT SH TO NOZ
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 158

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 4 Nov 87 DSK
J. Gross Mon 11/4/87

EXAM NO. 86

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1130-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	3.85
2/8	/	7.6
3/8	/	11.5
NOTCH	/	15.3
5/8	/	19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	5.35
2/8	/	11
3/8	/	16.5
NOTCH	/	22
5/8	/	27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	2.75
2/8	/	5.5
3/8	/	8.2

GATE SETTINGS		
SCAN	START	STOP
1-17	1.83	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.
6	/	7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	7.8 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO. 086101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME 0848 (X) DATE (4 Nov 87

EXAM NO. 86 OPERATOR(S) (J. ALEJANDRO (N/A) WELD NO. 29-RPV-1 ; 30-1

PARAMETERS

WELD LOC. 85.62 - VESSEL DIA. 171.3 WALL THICKNESS 1
SCAN INC. (IN.) .5 (CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR O X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	175.72	
2	CCW	85.62	176.05	
3	CW	85.62	176.38	
4	CCW	85.62	176.71	
5	CW	85.62	177.04	
6	CCW	85.62	177.37	
7	CW	85.62	177.7	
8	CCW	85.62	178.03	
9	CW	85.62	178.36	Exam start @ scan 9
10	CCW	85.62-	178.69	Y coordinates start 177.88 ff
11	CW	85.62-	179.02	Y coordinates stop 179.77 ff
12	CCW	85.62-	179.35	
13	CW	85.62-	179.68	
14	CCW	85.62	180.01	
15	CW	85.62	180.34	
16	CCW	85.62	180.67	
17	CW	85.62	181	see exam sht. (cmb)

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (04 Nov 87)

EXAM.NO. 87

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=87
4. WELD NO.=29-RPV-1130-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT SH TO NOZ
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 158

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

Completed 4 Nov 87 DBK

EXAM NO. 87

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSKC052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1130-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-17	13	10.5

TCG ON DAK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	3 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO.067101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(0946) DATE(9 NOV 87)

EXAM NO. 87 OPERATOR(S)(J.ALEJANDRO)(N/A) WELD NO. 29-RPV-1130-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .5(CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	140.28	
2	CCW	85.62	139.95	
3	CW	85.62	139.62	
4	CCW	85.62	139.29	
5	CW	85.62	138.96	
6	CCW	85.62	138.63	
7	CW	85.62	138.3	
8	CCW	85.62	137.97	
9	CW	85.62	137.64	exam start @ scan 9 ## Y coodinates start 138.11 ## Y coodinates stop 136.22 ##
10	CCW	85.62	137.31	
11	CW	85.62	136.98	
12	CCW	85.62	136.65	
13	CW	85.62	136.32	
14	CCW	85.62	135.99	
15	CW	85.62	135.66	
16	CCW	85.62	135.33	
17	CW	85.62	135	(MB) see exam sheet (MB)

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(04 Nov. 87)

EXAM.NO. 88

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=88
4. WELD NO.=29-RPV-1110-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT SH TO NOZ
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 202

X-CONVERSION PARAMETERS

Comp 4 NOV. 87

(JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. S8

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSKC032739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-111C-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DC052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.35
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-17	+3 DAK	10.5

TCG ON DAK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	+3 DAK DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.083101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(1925) DATE(4 NOV 87)

EXAM NO. 68 OPERATOR(S)(JALEJANDRO)(N/A) WELD NO. 29-RPV-1110-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .5(CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	219.72	
2	CCW	85.62	220.05	
3	CW	85.62	220.38	
4	CCW	85.62	220.71	
5	CW	85.62	221.04	
6	CCW	85.62	221.37	
7	CW	85.62	221.7	
8	CCW	85.62	222.03	see exam sht for pos.
9	CW	85.62	222.36	EXAM start @ scan 9
10	CCW	85.62	222.69	
11	CW	85.62	223.02	
12	CCW	85.62	223.35	
13	CW	85.62	223.68	
14	CCW	85.62	224.01	
15	CW	85.62	224.34	
16	CCW	85.62	224.67	
17	CW	85.62	225	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(05,Nov,87)

EXAM.NO. 89

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=89
4. WELD NO.=29-RPV-1110-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT SH TO NOZ
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 202

X-CONVERSION PARAMETERS

Comp 4 NOV 87

JS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 89

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1110-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 3.65	SCAN	START	STOP
2/8	/ 7.6	1-17	2	17
3/8	/ 11.5			
NOTCH	/ 15.3			
5/8	/ 19.2			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 5.55	SCAN	START	STOP
2/8	/ 11	1-17	2	22
3/8	/ 16.5			
NOTCH	/ 22			
5/8	/ 27.5			

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 2.75	SCAN	START	STOP
2/8	/ 5.5	1-17	3 OK	10.5
3/8	/ 8.2			

TCG OFF OK

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.	1-17	1 DIV.	1 1/8 DIV.
3	/ 4 DIV.			OK
4	/ 5 DIV.			
5	/ 6 DIV.			
6	/ 7 DIV.			

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO.089101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(~~0800~~ 2000 cmb) DATE(4 NOV 87)

EXAM NO. 69 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 27-RPV-1110-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .5(CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	184.28	cmb
2	CCW	85.62	183.95	
3	CW	85.62	183.62	
4	CCW	85.62	183.29	
5	CW	85.62	182.96	
6	CCW	85.62	182.63	
7	CW	85.62	182.3	
8	CCW	85.62	181.97	
9	CW	85.62	181.64	EXAM STARTS ON SCAN # 9 cmb
10	CCW	85.62	181.31	
11	CW	85.62	180.98	
12	CCW	85.62	180.65	
13	CW	85.62	180.32	
14	CCW	85.62	179.99	
15	CW	85.62	179.66	
16	CCW	85.62	179.33	
17	CW	85.62	179	

see exam shts cmb

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(05 Nov 87)

EXAM.NO. 90

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=90
4. WELD NO.=27.5-RPV-1110-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ TO SH
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC. (HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 247

X-CONVERSION PARAMETERS

Comp 4 Nov 87

JS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 90

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK-052739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 27.5-RPV-1110-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. 3305267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	+ 3 (SS)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	~~8~~ DIV. (SS) 7

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.090101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME 2052 DATE (4 NOV, 87)

EXAM NO. 90 OPERATOR(S) L R Mathena n/a WELD NO. 17.5-RPV-1110-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	261	See exam Sht. cmt 9
2	CCW	85.62	261.5	
3	CW	85.62	262	
4	CCW	85.62	262.5	
5	CW	85.62	263	
6	CCW	85.62	263.5	
7	CW	85.62	264	
8	CCW	85.62	264.5	
9	CW	85.62	265	
10	CCW	85.62	265.5	
11	CW	85.62	266	
12	CCW	85.62	266.5	
13	CW	85.62	267	
14	CCW	85.62	267.5	
15	CW	85.62	268	
16	CCW	85.62	268.5	
17	CW	85.62	269	
18	CCW	85.62	269.5	
19	CW	85.62	270	
20	CCW	85.62	270.5	
21	CW	85.62	271	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (05 Nov 87)

EXAM.NO. 91

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-5770
3.EXAM NO.=91
4.WELD NO.=27.5-RPV-1110-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ TO SH
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6.WELD LENGTH=166.5
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=11
9.NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 247

X-CONVERSION PARAMETERS

Comp 4 Nov 87
(9)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 91

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK:C52739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 27.S-RPV-1110-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	+3 (53)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	~~2~~ DIV. (53)7

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO.091101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME (~~1000~~ 2200 SMB) DATE (4 Nov 87

EXAM NO. 91 OPERATOR(S) (L.R MATHENA (N/A) WELD NO. 27.5-RPV-1110-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC. (IN.) .75 (CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	233	see exam sht. SMB
2	CCW	85.62	232.5	
3	CW	85.62	232	
4	CCW	85.62	231.5	
5	CW	85.62	231	
6	CCW	85.62	230.5	
7	CW	85.62	230	
8	CCW	85.62	229.5	
9	CW	85.62	229	
10	CCW	85.62	228.5	
11	CW	85.62	228	
12	CCW	85.62	227.5	
13	CW	85.62	227	
14	CCW	85.62	226.5	
15	CW	85.62	226	
16	CCW	85.62	225.5	
17	CW	85.62	225	
18	CCW	85.62	224.5	
19	CW	85.62	224	
20	CCW	85.62	223.5	
21	CW	85.62	223	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (05 Nov 87)

EXAM.NO. 92

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=92
4. WELD NO.=27.5-RPV-1120-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ TO SH
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 293

X-CONVERSION PARAMETERS

Comp 5 NOV. 87
JS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 92

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DS:2052739
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 1/8-RPV-1120-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DS0522e7

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	+3 (2S)	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	~~6 DIV.~~ 7 (2S)

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	-1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.092101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(2306) DATE(4 Nov 87)

EXAM NO. 92 OPERATOR(S) L.R. MATHENA (P.C. TURNER WELD NO. 27.5-RPV-1120-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	307 See exam sht. comp	
2	CCW	85.62	307.5	
3	CW	85.62	308	
4	CCW	85.62	308.5	
5	CW	85.62	309	
6	CCW	85.62	309.5	
7	CW	85.62	310	
8	CCW	85.62	310.5	
9	CW	85.62	311	
10	CCW	85.62	311.5	
11	CW	85.62	312	
12	CCW	85.62	312.5	
13	CW	85.62	313	
14	CCW	85.62	313.5	
15	CW	85.62	314	
16	CCW	85.62	314.5	
17	CW	85.62	315	
18	CCW	85.62	315.5	
19	CW	85.62	316	
20	CCW	85.62	316.5	
21	CW	85.62	317	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(05 Nov. 87)

EXAM.NO. 93

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-5770
3. EXAM NO.=93
4. WELD NO.=27.5-RPV-1120-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ TO SH
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL. BLK. NO.=11-CSCL-53-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 14
5. LAST SCAN RADIUS = 24
6. WELD LENGTH=166.5
7. BEAM COMPONENT (CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=11
9. NOZZLE TYPE (INLET=1,OUTLET=0)=1
10. NOZZLE BOOM CENTERLINE = 293

X-CONVERSION PARAMETERS

Comp 5N00.87

(JH)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 93

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. D8KJ052759
COMPONENT RPV SUBASSEMBLY IN NOZ TO SH WELD NO. 27.5-RPV-1120-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. D3052287

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-21	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-21	2	23

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-21	~~+~~ 3.59	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-21	1 DIV.	~~6~~ 5.97 DIV.

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 11B

SHEET NO. 093101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(0027) DATE(5 Nov 87)

EXAM NO. 93 OPERATOR(S) (P.C. TURNER) (N/A) WELD NO. Z7.5-RSV-1120-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) .5 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR O X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	279	See exam sht (mp)
2	CCW	85.62	278.5	(mp)
3	CW	85.62	278	
4	CCW	85.62	277.5	
5	CW	85.62	277	
6	CCW	85.62	276.5	
7	CW	85.62	276	
8	CCW	85.62	275.5	
9	CW	85.62	275	
10	CCW	85.62	274.5	
11	CW	85.62	274	
12	CCW	85.62	273.5	
13	CW	85.62	273	
14	CCW	85.62	272.5	
15	CW	85.62	272	
16	CCW	85.62	271.5	
17	CW	85.62	271	
18	CCW	85.62	270.5	
19	CW	85.62	270	
20	CCW	85.62	269.5	
21	CW	85.62	269	

REVIEWED BY (Carlos M Barrera) (LEVEL(II) DATE(05 Nov 87)

EXAM.NO. 94

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-5770
3.EXAM NO.=94
4.WELD NO.=29-RPV-1120-1
5.COMPONENT=RPV
6.SUBASSEMBLY=OUT SH TO NOZ
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6.WELD LENGTH=166.5
7.BEAM COMPONENT (CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=11
9.NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 338

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 94

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSKC052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1120-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DC052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-17	~~4~~ 3 (09)	10.5

INST.NO.4 / 30/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	~~8~~ 7 DIV. (02)

****

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	-1.50 IN.	-1.50 IN.	-1.50 IN.	+1.50 IN.
Y-OFFSET	-1.125 IN.	+1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.10B

SHEET NO.094101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-5770 TIME (0220) DATE (5.20.87

EXAM NO. 94 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 29-RPV-1120-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC. (IN.) .5 (CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR O X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	355.72	
2	CCW	85.62	356.05	
3	CW	85.62	356.38	
4	CCW	85.62	356.71	
5	CW	85.62	357.04	
6	CCW	85.62	357.37	
7	CW	85.62	357.7	
8	CCW	85.62	358.03	
9	CW ✓	85.62	358.36	
10	CCW ✓	85.62	358.69	Raw Scans 9 - 17
11	CW ✓	85.62	359.02	
12	CCW ✓	85.62	359.35	
13	CW ✓	85.62	359.68	
14	CCW ✓	85.62	360.01	
15	CW ✓	85.62	360.34	
16	CCW ✓	85.62	360.67	
17	CW ✓	85.62	361	

REVIEWED BY (Hector Diaz) (LEVEL (III) DATE (5/20/87

EXAM.NO. 95

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-5770

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-5770
3.EXAM NO.=95
4.WELD NO.=29-RPV-1120-1
5.COMPONENT=RPV
6.SUBASSEMBLY=OUT SH TO NOZ
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=11-CSCL-53-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052267

CALIBRATION AND DEVICE PARAMETERS

1. START LOC.(HOIST)=85.62
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. FIRST SCAN RADIUS = 17.72
5. LAST SCAN RADIUS = 22.74
6.WELD LENGTH=166.5
7.BEAM COMPONENT (CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=11
9.NOZZLE TYPE (INLET=1,OUTLET=0)=0
10. NOZZLE BOOM CENTERLINE = 338

X-CONVERSION PARAMETERS

Comp 5 Nov 87
(JS)

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

EXAM NO. 95

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-5770 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY OUT SH TO NOZ WELD NO. 29-RPV-1120-1
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. EXAM TYPE - TRANS.
CAL.BLK.NO. 11-CSCL-53-SAM DEVICE DWG.NO./CONFIG.NO. DI052267

CALIBRATION PARAMETERS

INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 3.85
2/8	/ 7.6
3/8	/ 11.5
NOTCH	/ 15.3
5/8	/ 19.2

GATE SETTINGS		
SCAN	START	STOP
1-17	2	17

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	
1/8	/ 5.55
2/8	/ 11
3/8	/ 16.5
NOTCH	/ 22
5/8	/ 27.5

GATE SETTINGS		
SCAN	START	STOP
1-17	2	23

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INST.NO.3 / 0 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.	
1/8	/ 2.75
2/8	/ 5.5
3/8	/ 8.2

GATE SETTINGS		
SCAN	START	STOP
1-17	~~1~~ 3	10.5

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1 IN FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	
1	/ 2 DIV.
2	/ 3 DIV.
3	/ 4 DIV.
4	/ 5 DIV.
5	/ 6 DIV.
6	/ 7 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-17	1 DIV.	8 DIV.

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MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	+1.50 IN.	+1.50 IN.	+1.50 IN.	-1.50 IN.
Y-OFFSET	+1.125 IN.	-1.125 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO. 113

SHEET NO.095101

SWRI PAR SCAN SHEET

ITE NAME SALEM 1 PROJECT NO. 17-5770 TIME(0303) DATE(5 NOV.87)

EXAM NO. 95 OPERATOR(S) LR Mathena (N/A) WELD NO. 29-RPV-1120-1

PARAMETERS

WELD LOC. 85.62 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .5(CTS.) .33 WELD LENGTH 166.5
Y= BOOM ROTATE Z= SWRI ROTATOR 0 X= HOIST

SCAN	DIR	HOIST	BOOM ROTATOR	REMARKS
1	CW	85.62	320.28	
2	CCW	85.62	319.95	
3	CW	85.62	319.62	
4	CCW	85.62	319.29	
5	CW	85.62	318.96	
6	CCW	85.62	318.63	
7	CW	85.62	318.3	
8	CCW	85.62	317.97	
9	CW ✓	85.62	317.64	
10	CCW ✓	85.62	317.31	
11	CW ✓	85.62	316.98	Ran Scan 9-17 TW
12	CCW ✓	85.62	316.65	
13	CW ✓	85.62	316.32	
14	CCW ✓	85.62	315.99	
15	CW ✓	85.62	315.66	
16	CCW ✓	85.62	315.33	
17	CW ✓	85.62	315	

REVIEWED BY(Victor Diaz) (LEVEL(III) DATE(5 NOV 87)

EXAM.NO. 96

BWRI SCAN PLAN PARAMETER PRINTOUT

SITE NAME SALEM 1 PRINT OUT 12:1

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=96
4.WELD NO.=27.5-RPV-1140-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ 367 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=67
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=14.85
5. Y-STOP POS.=41.55
6.WELD DIAMETER=57
7.NOZZLE BORE DIAMETER AT LIP=31.5
8.Y-OFFSET (PIV.TO RPV C.L.)=73
9.HOIST POSITION=85.62
10.FIRST CAL. REFLECTOR=6.5
11.SECOND CAL.REFLECTOR=11
12.THIRD CAL.REFLECTOR=16
13.EXAM.ANGLE #2=6

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 201.17
COUNTS PER DEGREE= 100

Completed 5 Nov 87 DAK

002800

EXAM NO. 96

SURE SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1002 SCAN PLAN NO. SS/NOZZLE
ITEM NO. NA SUBASSEMBLY ID NOZ 267 DEG NOZZLE NO. SI-1 TO SHELL
PROCEDURE REV. NO. ZAX-11/7 WELD TYPE N-SHELL EXAMINER INITIALS
CAL.BLK.NO. N/S-CSCL-110-SA/ DEVICE DWG.NO./CONFIG. NO. ST/SHELL

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	7.6	SCAN	START	STOP
2/8	/	15.3			
3/8	/	22.3	1-276	4	24

INST.NO.2 /6 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 6
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	5.5	SCAN	START	STOP
2/8	/	11			
3/8	/	16	1-276	4	20

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-276	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

MODULE PARAMETERS

	45 DEG.	6 DEG.	50/70 DEG.
X-OFFSET	-.785 IN.	+.785 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-7.2 IN.

MODULE CONFIGURATION NO. 12

GIRTH PLATE SCAN SHEET

JOB NO. 0757 DATE 5 NOV 87

OPERATOR(S): R. MATHENA J. ALEJANDRO

PARAMETERS

VESSEL NO. 67 VESSEL DIA. 85.69 WALL THICKNESS .

NOM INC.(IN.) .34 CTS.131 WELD DIAMETER 87 HOIST POS. SC 3.1

X-FUNCTION SWRC ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	14.95	41.55	
2	RET	131	41.55	14.85	
3	EXT	262	14.85	41.55	
4	RET	393	41.55	14.35	
5	EXT	524	14.85	41.55	
6	RET	655	41.55	14.85	
7	EXT	786	14.85	41.55	
8	RET	917	41.55	14.85	
9	EXT	1049	14.85	41.55	
10	RET	1179	41.55	14.85	
11	EXT	1310	14.85	41.55	
12	RET	1441	41.55	14.85	
13	EXT	1572	14.85	41.55	
14	RET	1703	41.55	14.85	
15	EXT	1834	14.85	41.55	
16	RET	1965	41.55	14.85	
17	EXT	2096	14.85	41.55	
18	RET	2227	41.55	14.85	
19	EXT	2358	14.85	41.55	
20	RET	2489	41.55	14.85	
21	EXT	2620	14.85	41.55	
22	RET	2751	41.55	14.85	
23	EXT	2882	14.85	41.55	
24	RET	3013	41.55	14.85	
25	EXT	3144	14.85	41.55	
26	RET	3275	41.55	14.85	
27	EXT	3406	14.85	41.55	
28	RET	3537	41.55	14.85	
29	EXT	3668	14.85	41.55	
30	RET	3799	41.55	14.85	
31	EXT	3930	14.85	41.55	
32	RET	4061	41.55	14.85	
33	EXT	4192	14.85	41.55	
34	RET	4323	41.55	14.85	
35	EXT	4454	14.85	41.55	
36	RET	4585	41.55	14.85	
37	EXT	4716	14.85	41.55	
38	RET	4847	41.55	14.85	
39	EXT	4978	14.85	41.35	

OPERATOR/S JALEJANDRO N/A

EC	DIR	X-POS	Y-START	Y-STOP	TEXT
40	RET	3107	41.55	14.85	
41	EXT	3241	14.85	41.55	
42	RET	3371	41.55	14.85	
43	EXT	3502	14.85	41.55	
44	RET	3632	41.55	14.85	
45	EXT	3764	14.85	41.55	
46	RET	3895	41.55	14.85	
47	EXT	4026	14.85	41.55	
48	RET	4157	41.55	14.85	
49	EXT	4288	14.85	41.55	
50	RET	4419	41.55	14.85	
51	EXT	4550	14.85	41.55	
52	RET	4681	41.55	14.85	
53	EXT	4812	14.85	41.55	
54	RET	4943	41.55	14.85	
55	EXT	5074	14.85	41.55	
56	RET	5205	41.55	14.85	
57	EXT	5336	14.85	41.55	
58	RET	5467	41.55	14.85	
59	EXT	5598	14.85	41.55	
60	RET	5729	41.55	14.85	
61	EXT	5860	14.85	41.55	
62	RET	5991	41.55	14.85	
63	EXT	6122	14.85	41.55	
64	RET	6253	41.55	14.85	
65	EXT	6384	14.85	41.55	
66	RET	6515	41.55	14.85	
67	EXT	6646	14.85	41.55	
68	RET	6777	41.55	14.85	
69	EXT	6908	14.85	41.55	
70	RET	7039	41.55	14.85	
71	EXT	7170	14.85	41.55	
72	RET	7301	41.55	14.85	
73	EXT	7432	14.85	41.55	
74	RET	7563	41.55	14.85	
75	EXT	7694	14.85	41.55	
76	RET	7825	41.55	14.85	
77	EXT	7956	14.85	41.55	
78	RET	10087	41.55	14.85	
79	EXT	10218	14.85	41.55	
80	RET	10349	41.55	14.85	
81	EXT	10480	14.85	41.55	
82	RET	10611	41.55	14.85	
83	EXT	10742	14.85	41.55	
84	RET	10873	41.55	14.85	
85	EXT	11004	14.85	41.55	
86	RET	11135	41.55	14.85	
87	EXT	11266	14.85	41.55	
88	RET	11397	41.55	14.85	
89	EXT	11528	14.85	41.55	

B

OPERATOR(S): JALEJANDRO NIA

SECT	DIR	X-FEET	Y-START	Y-STOP	REMARKS
90	RET	11659.	41.55	14.85	
91	EXT	11790.	14.85	41.55	
92	RET	11921.	41.55	14.85	
93	EXT	12052.	14.85	41.55	
94	RET	12183.	41.55	14.85	
95	EXT	12314.	14.85	41.55	
96	RET	12445.	41.55	14.85	
97	EXT	12576.	14.85	41.55	
98	RET	12707.	41.55	14.85	
99	EXT	12838.	14.85	41.55	
100	RET	12969.	41.55	14.85	
101	EXT	13100.	14.85	41.55	
102	RET	13231.	41.55	14.85	
103	EXT	13362.	14.85	41.55	
104	RET	13493.	41.55	14.85	
105	EXT	13624.	14.85	41.55	
106	RET	13755.	41.55	14.85	
107	EXT	13886.	14.85	41.55	
108	RET	14017.	41.55	14.85	
109	EXT	14148.	14.85	41.55	
110	RET	14279.	41.55	14.85	
111	EXT	14410.	14.85	41.55	
112	RET	14541.	41.55	14.85	
113	EXT	14672.	14.85	41.55	
114	RET	14803.	41.55	14.85	
115	EXT	14934.	14.85	41.55	
116	RET	15065.	41.55	14.85	
117	EXT	15196.	14.85	41.55	
118	RET	15327.	41.55	14.85	
119	EXT	15458.	14.85	41.55	
120	RET	15589.	41.55	14.85	
121	EXT	15720.	14.85	41.55	
122	RET	15851.	41.55	14.85	
123	EXT	15982.	14.85	41.55	
124	RET	16113.	41.55	14.85	
125	EXT	16244.	14.85	41.55	
126	RET	16375.	41.55	14.85	
127	EXT	16506.	14.85	41.55	
128	RET	16637.	41.55	14.85	
129	EXT	16768.	14.85	41.55	
130	RET	16899.	41.55	14.85	
131	EXT	17030.	14.85	41.55	
132	RET	17161.	41.55	14.85	
133	EXT	17292.	14.85	41.55	
134	RET	17423.	41.55	14.85	
135	EXT	17554.	14.85	41.55	
136	RET	17685.	41.55	14.85	
137	EXT	17816.	14.85	41.55	
138	RET	17947.	41.55	14.85	
139	EXT	18078.	14.85	41.55	

JALEJANDRO / N/A

ED N	EXT	X-POS	Y-START	Y-STOP	RE ARKS
140	RET	19209.	41.55	14.85	
141	EXT	19340.	14.85	41.55	
142	RET	19471.	41.55	14.85	
143	EXT	19602.	14.85	41.55	
144	RET	19733.	41.55	14.85	
145	EXT	19864.	14.85	41.55	
146	RET	19995.	41.55	14.85	
147	EXT	20126.	14.85	41.55	
148	RET	20257.	41.55	14.85	
149	EXT	20388.	14.85	41.55	
150	RET	20519.	41.55	14.85	
151	EXT	20650.	14.85	41.55	
152	RET	20781.	41.55	14.85	
153	EXT	20912.	14.85	41.55	
154	RET	21043.	41.55	14.85	
155	EXT	21174.	14.85	41.55	
156	RET	21305.	41.55	14.85	
157	EXT	21436.	14.85	41.55	
158	RET	21567.	41.55	14.85	
159	EXT	21698.	14.85	41.55	
160	RET	21829.	41.55	14.85	
161	EXT	21960.	14.85	41.55	
162	RET	22091.	41.55	14.85	
163	EXT	22222.	14.85	41.55	
164	RET	22353.	41.55	14.85	
165	EXT	22484.	14.85	41.55	
166	RET	22615.	41.55	14.85	
167	EXT	22746.	14.85	41.55	
168	RET	22877.	41.55	14.85	
169	EXT	23008.	14.85	41.55	
170	RET	23139.	41.55	14.85	
171	EXT	23270.	14.85	41.55	
172	RET	23401.	41.55	14.85	
173	EXT	23532.	14.85	41.55	
174	RET	23663.	41.55	14.85	
175	EXT	23794.	14.85	41.55	
176	RET	23925.	41.55	14.85	
177	EXT	24056.	14.85	41.55	
178	RET	24187.	41.55	14.85	
179	EXT	24318.	14.85	41.55	
180	RET	24449.	41.55	14.85	
181	EXT	24580.	14.85	41.55	
182	RET	24711.	41.55	14.85	
183	EXT	24842.	14.85	41.55	
184	RET	24973.	41.55	14.85	
185	EXT	25104.	14.85	41.55	
186	RET	25235.	41.55	14.85	
187	EXT	25366.	14.85	41.55	
188	RET	25497.	41.55	14.85	
189	EXT	25628.	14.85	41.55	

OPERATOR: JALEJANDRO N/A

SCAN	DIR	X-POS	Y-START	Y-STOP	RESULT
196	RET	24787	41.55	14.85	
197	EXT	24918	14.85	41.55	
198	RET	25049	41.55	14.85	
199	EXT	25180	14.85	41.55	
200	RET	25311	41.55	14.85	
201	EXT	25442	14.85	41.55	
202	RET	25573	41.55	14.85	
203	EXT	25704	14.85	41.55	
204	RET	25835	41.55	14.85	
205	EXT	25966	14.85	41.55	
206	RET	26097	41.55	14.85	
207	EXT	26228	14.85	41.55	
208	RET	26359	41.55	14.85	
209	EXT	26490	14.85	41.55	
210	RET	26621	41.55	14.85	
211	EXT	26752	14.85	41.55	
212	RET	26883	41.55	14.85	
213	EXT	27014	14.85	41.55	
214	RET	27145	41.55	14.85	
215	EXT	27276	14.85	41.55	
216	RET	27407	41.55	14.85	
217	EXT	27538	14.85	41.55	
218	RET	27669	41.55	14.85	
219	EXT	27800	14.85	41.55	
220	RET	27931	41.55	14.85	
221	EXT	28062	14.85	41.55	
222	RET	28193	41.55	14.85	
223	EXT	28324	14.85	41.55	
224	RET	28455	41.55	14.85	
225	EXT	28586	14.85	41.55	
226	RET	28717	41.55	14.85	
227	EXT	28848	14.85	41.55	
228	RET	28979	41.55	14.85	
229	EXT	29110	14.85	41.55	
230	RET	29241	41.55	14.85	
231	EXT	29372	14.85	41.55	
232	RET	29503	41.55	14.85	
233	EXT	29634	14.85	41.55	
234	RET	29765	41.55	14.85	
235	EXT	29896	14.85	41.55	
236	RET	30027	41.55	14.85	
237	EXT	30158	14.85	41.55	
238	RET	30289	41.55	14.85	
239	EXT	30420	14.85	41.55	

NB

OPERATOR(S): JAIEJANDRO (N/A

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
240	RET	31309-	41.55	14.85	
241	EXT	31440-	14.85	41.55	
242	RET	31571-	41.55	14.85	
243	EXT	31702-	14.85	41.55	
244	RET	31833-	41.55	14.85	
245	EXT	31964-	14.85	41.55	
246	RET	32095-	41.55	14.85	
247	EXT	32226-	14.85	41.55	
248	RET	32357-	41.55	14.85	
249	EXT	32488-	14.85	41.55	
250	RET	32619-	41.55	14.85	
251	EXT	32750-	14.85	41.55	
252	RET	32881-	41.55	14.85	
253	EXT	33012-	14.85	41.55	
254	RET	33143-	41.55	14.85	
255	EXT	33274-	14.85	41.55	
256	RET	33405-	41.55	14.85	
257	EXT	33536-	14.85	41.55	
258	RET	33667-	41.55	14.85	
259	EXT	33798-	14.85	41.55	
260	RET	33929-	41.55	14.85	
261	EXT	34060-	14.85	41.55	
262	RET	34191-	41.55	14.85	
263	EXT	34322-	14.85	41.55	
264	RET	34453-	41.55	14.85	
265	EXT	34584-	14.85	41.55	
266	RET	34715-	41.55	14.85	
267	EXT	34846-	14.85	41.55	
268	RET	34977-	41.55	14.85	
269	EXT	35108-	14.85	41.55	
270	RET	35239-	41.55	14.85	
271	EXT	35370-	14.85	41.55	
272	RET	35501-	41.55	14.85	
273	EXT	35632-	14.85	41.55	
274	RET	35763-	41.55	14.85	
275	EXT	35894-	14.85	41.55	
276	RET	36025-	41.55	14.85	

Scans 1-257 REVIEWED BY: Hector Diaz) (LEVEL(III) DATE: 5 Nov 87

258-276 Reviewed by Carlos M Barrera Level II 05 Nov 87

EXAM.NO. 97

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=97
4.WELD NO.=27.5-RPV-1140-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ @67 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2.OUTSIDE VESSEL DIA.=193.3
3.INSIDE VES DIA.(I.E.IF CUTLET)=171.3
4. X-START POS.=~~0~~ 100 DK
5. X-STOP POS.=~~36000~~ 36100 DK
6.NOZZLE BORE DIAMETER=27.5
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=14.85
10.Y-STOP POSITION=31.85

Comp 6 Nov. 87

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 416.9
COUNTS PER DEGREE= 100

9002800

EXAM NO. 97

BWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO 17-1552 SCAN PLAN 3A, 3B CONSIST
COMPONENT RPV SUBASSEMBLY IN-NOZ @67 TSS WELD NO. 2-[illegible]
PR.CODE/PE/REV 700-11/7 WELD TYPE IRS EXAM.TYPE STAND'D
CAL.BLK.NO. W/S-CBIL-110-BAM DEVICE DWG.NO./CONFIG.NO. STD500.0

CALIBRATION PARAMETERS
INST.NO. 3 / 50/70 DEG.

DAK

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT ~~SCW~~ CW DAK SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-25	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

INST.NO. 4 / 50/70 DEG.

DAK

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW DAK SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1-25	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

****

MODULE PARAMETERS

X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 12A

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME: Miller 1 PROJECT NO. 17-1555 TIME 2235 DATE 6 Nov 87

DIA NO. 97 OPERATOR(S): L.R. Mathena N/A WELD NO. CT 3-2 27.5-RPV-1140-1

67

PARAMETERS

NOZZLE LOC. 113 VESSEL DIA. 171.3 OUTSIDE VES.DIA. 171.3
SCAN INC.(IN.) .7 CTS..7 NOZ.BORE DIA. 27.5 HOIST POS. 25.02
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTENS

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	14.85	0	36000	
2	CCW	15.55	36000	0	THIS IS USED FOR EXAM
3	CW	16.25	0	36000	
4	CCW	16.95	36000	0	~~Exam~~ 97 & 99 ✓
5	CW	17.65	0	36000	
6	CCW	18.35	36000	0	
7	CW	19.05	0	36000	
8	CCW	19.75	36000	0	
9	CW	20.45	0	36000	
10	CCW	21.15	36000	0	
11	CW	21.85	0	36000	
12	CCW	22.55	36000	0	
13	CW	23.25	0	36000	
14	CCW	23.95	36000	0	
15	CW	24.65	0	36000	
16	CCW	25.35	36000	0	
17	CW	26.05	0	36000	
18	CCW	26.75	36000	0	
19	CW	27.45	0	36000	
20	CCW	28.15	36000	0	
21	CW	28.85	0	36000	
22	CCW	29.55	36000	0	
23	CW	30.25	0	36000	
24	CCW	30.95	36000	0	
25	CW	31.65	0	36000	

REVIEWED BY: Carlos M Barrera (LEVEL: II) DATE: 07 Nov 87

EXAM.NO. 98

EVRI SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=98
4.WELD NO.=27.5-RPV-1130-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ @113 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=113
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=14.85
5. Y-STOP POS.=41.55
6.WELD DIAMETER=57
7.NOZZLE BORE DIAMETER AT LIP=31.5
8.Y-OFFSET (PIV.TO RPV C.L.)=73
9.HOIST POSITION=83.62
10.FIRST CAL. REFLECTOR=5.5
11.SECOND CAL.REFLECTOR=11
12.THIRD CAL.REFLECTOR=16
13.EXAM.ANGLE #2=6

X-CONVERSION PARAMETERS

INCHES PER COUNT= C COUNTS PER INCH= 201.17
COUNTS PER DEGREE= 100

Completed 5 NOV 87 DSK

0002600

EXAM NO. 93

[illegible] SCAN PLAN EXAMINATION [illegible]

SITE NAME:SALEM 1 PROJECT NO. 17-1881 SCAN PATH NO. [illegible]
COMPONENT REV. DWG/SKETCH/REV 760-11/7 WELD TYPE A-SHELL EXAM. [illegible]
CAL.BLK.NO. N.S-CSCL-110-SAM DEVICE DWG.NO. CONFIG NO. [illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 7
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) [illegible]

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	7.4	SCAN	START	STOP
2/8	/	15.3			
3/8	/	22.3	1-276	4	24

INST.NO.2 /6 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 6
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	5.5	SCAN	START	STOP
2/8	/	11			
3/8	/	16	1-276	4	20

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.3

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-276	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

MODULE PARAMETERS

	45 DEG.	6 DEG.	50/70 DEG.
X-OFFSET	-.785 IN.	+.785 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 12

SHEET 1 OF 1

SWRI FOR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1551 TIME 1152 DATE 5 NOV 87

EXAM NO. 15 OPERATOR(S) J.ALEJANDRO / N/A WELD NO. ET-S-F1-1100-

PARAMETERS

NOZZLE LOC. 113 VESSEL DIA. 88.65 WALL THICK 8.31

SCAN INC.(IN.) .36 CTS.131 WELD DIAMETER ET HOIST POS. 12 &2

X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	14.85	41.55	
2	RET	131	41.55	14.85	
3	EXT	262	14.85	41.55	
4	RET	393	41.55	14.85	
5	EXT	524	14.85	41.55	
6	RET	655	41.55	14.85	
7	EXT	786	14.85	41.55	
8	RET	917	41.55	14.85	
9	EXT	1048	14.85	41.55	
10	RET	1179	41.55	14.85	
11	EXT	1310	14.85	41.55	
12	RET	1441	41.55	14.85	
13	EXT	1572	14.85	41.55	
14	RET	1703	41.55	14.85	
15	EXT	1834	14.85	41.55	
16	RET	1965	41.55	14.85	
17	EXT	2096	14.85	41.55	
18	RET	2227	41.55	14.85	
19	EXT	2358	14.85	41.55	
20	RET	2489	41.55	14.85	
21	EXT	2620	14.85	41.55	
22	RET	2751	41.55	14.85	
23	EXT	2882	14.85	41.55	
24	RET	3013	41.55	14.85	
25	EXT	3144	14.85	41.55	
26	RET	3275	41.55	14.85	
27	EXT	3406	14.85	41.55	
28	RET	3537	41.55	14.85	
29	EXT	3668	14.85	41.55	
30	RET	3799	41.55	14.85	
31	EXT	3930	14.85	41.55	
32	RET	4061	41.55	14.85	
33	EXT	4192	14.85	41.55	
34	RET	4323	41.55	14.85	
35	EXT	4454	14.85	41.55	
36	RET	4585	41.55	14.85	
37	EXT	4716	14.85	41.55	
38	RET	4847	41.55	14.85	
39	EXT	4979	14.85	41.55	

EXAM NO. 92 OPERATOR(S): P. Gaines J. Alejandro SHEET [illegible]

WELL I.D. 07-S-RP1-11IC-1

SCAN	DIR	X-STOP	Y-START	Y-STOP	REMARKS
41	RET	5100	41.55	14.85	
42	EXT	5241	14.85	41.55	
43	RET	5371	41.55	14.85	
44	EXT	5502	14.85	41.55	
45	RET	5633	41.55	14.85	
46	EXT	5764	14.85	41.55	
47	RET	5895	41.55	14.85	
48	EXT	6026	14.85	41.55	
49	RET	6157	41.55	14.85	
50	EXT	6288	14.85	41.55	
51	RET	6419	41.55	14.85	
52	EXT	6550	14.85	41.55	
53	RET	6681	41.55	14.85	
54	EXT	6812	14.85	41.55	
55	RET	6943	41.55	14.85	
56	EXT	7074	14.85	41.55	
57	RET	7205	41.55	14.85	
58	EXT	7336	14.85	41.55	
59	RET	7467	41.55	14.85	
60	EXT	7598	14.85	41.55	
61	RET	7729	41.55	14.85	
62	EXT	7860	14.85	41.55	
63	RET	7991	41.55	14.85	
64	EXT	8122	14.85	41.55	
65	RET	8253	41.55	14.85	
66	EXT	8384	14.85	41.55	
67	RET	8515	41.55	14.85	
68	EXT	8646	14.85	41.55	
69	RET	8777	41.55	14.85	
70	EXT	8908	14.85	41.55	
71	RET	9039	41.55	14.85	
72	EXT	9170	14.85	41.55	
73	RET	9301	41.55	14.85	
74	EXT	9432	14.85	41.55	
75	RET	9563	41.55	14.85	
76	EXT	9694	14.85	41.55	
77	RET	9825	41.55	14.85	
78	EXT	9956	14.85	41.55	
79	RET	10087	41.55	14.85	
80	EXT	10218	14.85	41.55	
81	RET	10349	41.55	14.85	
82	EXT	10480	14.85	41.55	
83	RET	10611	41.55	14.85	
84	EXT	10742	14.85	41.55	
85	RET	10873	41.55	14.85	
86	EXT	11004	14.85	41.55	
87	RET	11135	41.55	14.85	
88	EXT	11266	14.85	41.55	
89	RET	11397	41.55	14.85	
90	EXT	11528	14.85	41.55	

EXAM NO. 98 OPERATOR(S): P. GOINE / N/A SHEET NO. 3 OF 11
WELD NO. 27.5-RPV-1130-1

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
70	RET	11657	41.55	14.85	
71	EXT	11790	14.85	41.55	
72	RET	11921	41.55	14.85	
73	EXT	12052	14.85	41.55	
74	RET	12183	41.55	14.85	
75	EXT	12314	14.85	41.55	
76	RET	12445	41.55	14.85	
77	EXT	12576	14.85	41.55	
78	RET	12707	41.55	14.85	
79	EXT	12838	14.85	41.55	
100	RET	12969	41.55	14.85	
101	EXT	13100	14.85	41.55	
102	RET	13231	41.55	14.85	
103	EXT	13362	14.85	41.55	
104	RET	13493	41.55	14.85	
105	EXT	13624	14.85	41.55	
106	RET	13755	41.55	14.85	
107	EXT	13886	14.85	41.55	
108	RET	14017	41.55	14.85	
109	EXT	14148	14.85	41.55	
110	RET	14279	41.55	14.85	
111	EXT	14410	14.85	41.55	
112	RET	14541	41.55	14.85	
113	EXT	14672	14.85	41.55	
114	RET	14803	41.55	14.85	
115	EXT	14934	14.85	41.55	
116	RET	15065	41.55	14.85	
117	EXT	15196	14.85	41.55	
118	RET	15327	41.55	14.85	
119	EXT	15458	14.85	41.55	
120	RET	15589	41.55	14.85	
121	EXT	15720	14.85	41.55	
122	RET	15851	41.55	14.85	
123	EXT	15982	14.85	41.55	
124	RET	16113	41.55	14.85	
125	EXT	16244	14.85	41.55	
126	RET	16375	41.55	14.85	
127	EXT	16506	14.85	41.55	
128	RET	16637	41.55	14.85	
129	EXT	16768	14.85	41.55	
130	RET	16899	41.55	14.85	
131	EXT	17030	14.85	41.55	
132	RET	17161	41.55	14.85	
133	EXT	17292	14.85	41.55	
134	RET	17423	41.55	14.85	
135	EXT	17554	14.85	41.55	
136	RET	17685	41.55	14.85	
137	EXT	17816	14.85	41.55	
138	RET	17947	41.55	14.85	
139	EXT	18078	14.85	41.55	

EXAM NO. 75 OPERATOR ID: J. ALEJANDRO n/a
FIELD NO. ET.5-24V-1100-1

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
140	RET	18209	41.55	14.85	
141	EXT	18340	14.85	41.55	
142	RET	18471	41.55	14.85	
143	EXT	18602	14.85	41.55	
144	RET	18733	41.55	14.85	
145	EXT	18864	14.85	41.55	
146	RET	18995	41.55	14.85	
147	EXT	19126	14.85	41.55	
148	RET	19257	41.55	14.85	
149	EXT	19388	14.85	41.55	
150	RET	19519	41.55	14.85	
151	EXT	19650	14.85	41.55	
152	RET	19781	41.55	14.85	
153	EXT	19912	14.85	41.55	
154	RET	20043	41.55	14.85	
155	EXT	20174	14.85	41.55	
156	RET	20305	41.55	14.85	
157	EXT	20436	14.85	41.55	
158	RET	20567	41.55	14.85	
159	EXT	20698	14.85	41.55	
160	RET	20829	41.55	14.85	
161	EXT	20960	14.85	41.55	
162	RET	21091	41.55	14.85	
163	EXT	21222	14.85	41.55	
164	RET	21353	41.55	14.85	
165	EXT	21484	14.85	41.55	
166	RET	21615	41.55	14.85	
167	EXT	21746	14.85	41.55	
168	RET	21877	41.55	14.85	
169	EXT	22008	14.85	41.55	
170	RET	22139	41.55	14.85	
171	EXT	22270	14.85	41.55	
172	RET	22401	41.55	14.85	
173	EXT	22532	14.85	41.55	
174	RET	22663	41.55	14.85	
175	EXT	22794	14.85	41.55	
176	RET	22925	41.55	14.85	
177	EXT	23056	14.85	41.55	
178	RET	23187	41.55	14.85	
179	EXT	23318	14.85	41.55	
180	RET	23449	41.55	14.85	
181	EXT	23580	14.85	41.55	
182	RET	23711	41.55	14.85	
183	EXT	23842	14.85	41.55	
184	RET	23973	41.55	14.85	
185	EXT	24104	14.85	41.55	
186	RET	24235	41.55	14.85	
187	EXT	24366	14.85	41.55	
188	RET	24497	41.55	14.85	
189	EXT	24628	14.85	41.55	

SHOT NO. 28 OPERATOR(S): JALEJANDRO : N/A
FIELD LOC. ST.E RAN-4170-1

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
190	RET	24757	41.55	14.85	
191	EXT	24890	14.85	41.55	
192	RET	25021	41.55	14.85	
193	EXT	25152	14.85	41.55	
194	RET	25283	41.55	14.85	
195	EXT	25414	14.85	41.55	
196	RET	25545	41.55	14.85	
197	EXT	25676	14.85	41.55	
198	RET	25807	41.55	14.85	
199	EXT	25938	14.85	41.55	
200	RET	26069	41.55	14.85	
201	EXT	26200	14.85	41.55	
202	RET	26331	41.55	14.85	
203	EXT	26462	14.85	41.55	
204	RET	26593	41.55	14.85	
205	EXT	26724	14.85	41.55	
206	RET	26855	41.55	14.85	
207	EXT	26986	14.85	41.55	
208	RET	27117	41.55	14.85	
209	EXT	27248	14.85	41.55	
210	RET	27379	41.55	14.85	
211	EXT	27510	14.85	41.55	
212	RET	27641	41.55	14.85	
213	EXT	27772	14.85	41.55	
214	RET	27903	41.55	14.85	
215	EXT	28034	14.85	41.55	
216	RET	28165	41.55	14.85	
217	EXT	28296	14.85	41.55	
218	RET	28427	41.55	14.85	
219	EXT	28558	14.85	41.55	
220	RET	28689	41.55	14.85	
221	EXT	28820	14.85	41.55	
222	RET	28951	41.55	14.85	
223	EXT	29082	14.85	41.55	
224	RET	29213	41.55	14.85	
225	EXT	29344	14.85	41.55	
226	RET	29475	41.55	14.85	
227	EXT	29606	14.85	41.55	
228	RET	29737	41.55	14.85	
229	EXT	29868	14.85	41.55	
230	RET	29999	41.55	14.85	
231	EXT	30130	14.85	41.55	
232	RET	30261	41.55	14.85	
233	EXT	30392	14.85	41.55	
234	RET	30523	41.55	14.85	
235	EXT	30654	14.85	41.55	
236	RET	30785	41.55	14.85	
237	EXT	30916	14.85	41.55	
238	RET	31047	41.55	14.85	
239	EXT	31178	14.85	41.55	

D

BANK NO. 58 OPERATOR(S): JALEJANDRO : N/A

WELL ID: 27.8-5W-.17-1

SIGN.	DIP	X-POS	Y-START	Y-STOP	REMARKS
240	RET	31709-	41.55	14.85	
241	EXT	3.440-	14.85	41.55	
242	RET	31571-	41.55	14.85	
243	EXT	31702-	14.85	41.55	
244	RET	31833-	41.55	14.85	
245	EXT	31964-	14.85	41.55	
246	RET	32095-	41.55	14.85	
247	EXT	32226-	14.85	41.55	
248	RET	32357-	41.55	14.85	
249	EXT	32488-	14.85	41.55	
250	RET	32619-	41.55	14.85	
251	EXT	32750-	14.85	41.55	
252	RET	32881-	41.55	14.85	
253	EXT	33012-	14.85	41.55	
254	RET	33143-	41.55	14.85	
255	EXT	33274-	14.85	41.55	
256	RET	33405-	41.55	14.85	
257	EXT	33536-	14.85	41.55	
258	RET	33667-	41.55	14.85	
259	EXT	33798-	14.85	41.55	
260	RET	33929-	41.55	14.85	
261	EXT	34060-	14.85	41.55	
262	RET	34191-	41.55	14.85	
263	EXT	34322-	14.85	41.55	
264	RET	34453-	41.55	14.85	
265	EXT	34584-	14.85	41.55	
266	RET	34715-	41.55	14.85	
267	EXT	34846-	14.85	41.55	
268	RET	34977-	41.55	14.85	
269	EXT	35108-	14.85	41.55	
270	RET	35239-	41.55	14.85	
271	EXT	35370-	14.85	41.55	
272	RET	35501-	41.55	14.85	
273	EXT	35632-	14.85	41.55	
274	RET	35763-	41.55	14.85	
275	EXT	35894-	14.85	41.55	
276	RET	36025-	41.55	14.85	

REVIEWED BY: Carlos M Barrera (LEVEL II) DATE: 06 Nov 87

EXAM.NO. 99

EWRI SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=99
4.WELD NO.=27.5-RPV-1130-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ @113 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=D9K3052738
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052262

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2.OUTSIDE VESSEL DIA.=193.3
3.INSIDE VES DIA.(I.E.IF OUTLET)=171.3
4. X-START POS.=~~0~~ 100
5. X-STOP POS.=3~~60036~~ 100
6.NOZZLE BORE DIAMETER=27.5
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=14.85
10.Y-STOP POSITION=31.85

Comp 7 Nov. 87

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 416.7
COUNTS PER DEGREE= 100

002600

EXAM NO. 99

SWRI SCAN PLAN EXAMINATION [illegible]

SITE NAME SALEM 1 PROJECT NO. 17-1551 [illegible]
COMPONENT ID/ SUBASSEMBLY IN NOZ 6 IT LEG WELD NO. [illegible]
PROCED./REV/REV/DEV PDI-UT-7 WELD TYPE IRS EXAM.TYPE [illegible]
CAL.BLK.NO. N/S-DECL-110-SPM DEVICE ENG.NO./CONFIG NO. [illegible]

CALIBRATION PARAMETERS
INST.NO. 3 / 50/70 DEG. OK

TRANSDUCER SIZE .5X1 IN. FREQ. OK 2.25 MHZ.
BEAM COMPONENT ~~CCW~~ CW OK SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-25	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

****

INST.NO. 4 / 50/70 DEG. OK

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW OK SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-25	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

****

MODULE PARAMETERS

X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 12A

SHEET NO. 1 OF 1

SWRI PAT SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2235 DATE 6 Nov 87

EXAM NO. 97 OPERATOR(S): L.R. Mathena N/A WELD NO. 27.5-RPV-1140-1

67

PARAMETERS

NOZZLE LOC. 113 VESSEL DIA. 171.3 OUTSIDE VES.D.A. 171.3
SCAN INC.(IN.) .7 CTS..7 NOZ.BORE DIA. 27.3 HOIST POS. 23 02
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTENS

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	14.65	0	36000	
2	CCW	15.55	36000	0	
3	CW	16.25	0	36000	
4	CCW	16.95	36000	0	
5	CW	17.65	0	36000	
6	CCW	18.35	36000	0	
7	CW	19.03	0	36000	
8	CCW	19.75	36000	0	
9	CW	20.45	0	36000	
10	CCW	21.15	36000	0	
11	CW	21.85	0	36000	
12	CCW	22.55	36000	0	
13	CW	23.25	0	36000	
14	CCW	23.95	36000	0	
15	CW	24.65	0	36000	
16	CCW	25.35	36000	0	
17	CW	26.05	0	36000	
18	CCW	26.75	36000	0	
19	CW	27.45	0	36000	
20	CCW	28.15	36000	0	
21	CW	28.85	0	36000	
22	CCW	29.55	36000	0	
23	CW	30.25	0	36000	
24	CCW	30.95	36000	0	
25	CW	31.65	0	36000	

THIS IS USED FOR EXAM ~~Exam~~ 97 & 99.1

REVIEWED BY: Carlos M Barrera (LEVEL: II) DATE: 07 Nov 87

EXAM.NO. 100

SWRI SCAN PLAN PARAMETER RECEIPT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=100
4. WELD NO.=27.S-RPV-1110-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ @247 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=N/S-CSCL-110-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=247
2. VESSEL DIA.=95.65
3. WALL THICKNESS=11
4. Y-START POS.=14.65
5. Y-STOP POS.=41.55
6. WELD DIAMETER=57
7. NOZZLE BORE DIAMETER AT LIP=31.5
8. Y-OFFSET (PIV.TO RPV C.L.)=73
9. HOIST POSITION=85.62
10. FIRST CAL. REFLECTOR=5.5
11. SECOND CAL.REFLECTOR=11
12. THIRD CAL.REFLECTOR=16
13. EXAM.ANGLE #2=6

Comp 5 NOV. 87
(JS)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 201.13

COUNTS PER DEGREE= 100

002200

EXAM NO. 100

EWR-2 SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1052 SCAN PATH SK. 10.5X5.5"DS
COMPONENT REV SUBASSEMBLY IN NOZ @047 DEG WELD NO. 17-[illegible]
PROCED.REQ/REV/DEV 700-11/7 WELD TYPE V-GROOVE EXAM.TYPE PARALLEL
CALIBLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. 8705E2158

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		
1/8	/	7.6
2/8	/	15.3
3/8	/	22.3

GATE SETTINGS		
SCAN	START	STOP
1-276	4	24

INST.NO.2 /6 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 6
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		
1/8	/	5.5
2/8	/	11
3/8	/	16

GATE SETTINGS		
SCAN	START	STOP
1-276	4	20

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.		
1	/	2 DIV.
2	/	3 DIV.
3	/	4 DIV.
4	/	5 DIV.
5	/	6 DIV.

GATE SETTINGS		
SCAN	START	STOP
1-276	1 DIV.	7 DIV.

MODULE PARAMETERS

	45 DEG.	6 DEG.	50/70 DEG.
X-OFFSET	-.755 IN.	+.705 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 1C

SWRI EXAMINATION SHEET
SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 DATE (5 NOV, 87)
EXAM NO. 100 OPERATOR(S) (J ALEJANDRO, K R MATHEWS)
WELD NO. 27.5-RPV-1110-1 @ 247°
INLET NOZZLE TO SHELL WELD

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START
Y FUNCTION = BOOM EXTEND, X FUNCTION = SWRI ROTATOR

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ m ~~NO YES GEO OTHER~~ X X	SCAN RUN	REMARKS
1	CW	1485	0 | 360000	I I	EXAM START TIME 1854
2	CCW	1520	36000 0	I I	
3	CW	1555	0 | 36000	I I	
4	CCW	1590	36000 0	I I	
5	CW	1625	0 | 360000	I I	
6	CCW	1660	36000 0	I I	
7	CW	1695	0 | 36000	I I	
8	CCW	1730	36000 0	I I	
9	CW	1765	0 | 36000	I I	
10	CCW	1800	36000 0	I I	
11	CW	1835	0 | 36000	I I	
12	CCW	1870	36000 0	I I	
13	CW	1905	0 | 36000	I I	
14	CCW	1940	36000 0	I I	
15	CW	1975	0 | 36000	I I	
16	CCW	2010	36000 0	I I	
17	CW	2045	0 | 36000	I I	
18	CCW	2080	36000 0	I I	
19	CW	2115	0 | 36000	I I	
20	CCW	2150	36000 0	I I	
21	CW	2185	0 | 36000	I I	
22	CCW	2220	36000 0	I I	
23	CW	2255	0 | 36000	I I	
24	CCW	2290	36000 0	I I	
25	CW	2325	0 | 36000	I I	
26	CCW	2360	36000 0	I I	
27	CW	2395	0 | 36000	I I	
28	CCW	2430	36000 0	I I	
29	CW	2465	0 | 36000	I I	
30	CCW	2500		I I	X 000 TO 360
31	CW	2535		I I	
32	CCW	2570		I I	START 2000
33	CW	2605		I I	FRAME
34	CCW	2640		I I	
35	CW	2675		I I	
36	CCW	2710		I I	
37	CW	2745		I I	
38	CCW	2780		I I	
39	CW	2815		I I	

SHEET NO. 100002

EXAM NO. 100 OPERATOR(S) L.R. Mathena (n/a)
WELD NO. 27.5-RPV-1110-1

SCAN	DIR	INC-POS Y	INDICATIONS NO X	INDICATIONS YES X	GEO	OTHER	SCAN RUN	REMARKS
40	CCW	2850	360	360			I I	
41	CW	2885	0 360				I I	
42	CCW	2920					I I	X cts 000 to 360
43	CW	2955					I I	
44	CCW	2990					I I	
45	CW	3025					I I	
46	CCW	3060					I I	
47	CW	3095					I I	
48	CCW	3130					I I	
49	CW	3165					I I	
50	CCW	3200					I I	
51	CW	3235					I I	
52	CCW	3270					I I	
53	CW	3305					I I	
54	CCW	3340					I I	
55	CW	3375					I I	
56	CCW	3410					I I	
57	CW	3445					I I	
58	CCW	3480					I I	
59	CW	3515					I I	
60	CCW	3550					I I	
61	CW	3585					I I	
62	CCW	3620					I I	
63	CW	3655					I I	
64	CCW	3690					I I	
65	CW	3725					I I	
66	CCW	3760					I I	
67	CW	3795					I I	
68	CCW	3830					I I	
69	CW	3865					I I	Restart @ #69
70	CCW	3900					I I	
71	CW	3935					I I	
72	CCW	3970					I I	
73	CW	4005					I I	
74	CCW	4040					I I	
75	CW	4075					I I	
76	CCW	4110					I I	
77	CW	4145					I I	

EXAM. TEMP. AFTER NA , TIME EXAM END 2055 .

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (06 Nov 87)

EXAM.NO. 101

BWR SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=101
4. WELD NO.=27.5-RPV-1110-1
5. COMPONENT=RPV
6. SUBASSEMBLY=IN NOZ @247 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK30E2736
9. CAL.BLK.NO.=N/S-CSCL-110-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. OUTSIDE VESSEL DIA.=193.3
3. INSIDE VES DIA.(I.E.IF OUTLET)=171.3
4. X-START POS.=~~0~~ 100 (J2)
5. X-STOP POS.=~~360~~ 360 100
6. NOZZLE BORE DIAMETER=27.5
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. Y-START POSITION=14.85
10. Y-STOP POSITION=31.85

Comp 7 Nov. 87
(JS)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 416.9

COUNTS PER DEGREE= 100

002200

EXAM NO. 101

[illegible] SCAN PLAN [illegible]

[illegible] SALEM 1 PROJECT NO. 17-1552 SCAN PATH BK. [illegible]
[illegible] SUBASSEMBLY [illegible] WELD NO. [illegible]
[illegible] DEG. 70%-11.7 WELD TYPE IRS [illegible]
[illegible] N/O-CEL-110-SAN DEVICE D.G.NO.. CONFIG.NO. [illegible]

CALIBRATION PARAMETERS

INST.NO. 1 / 50/70 DEG.

6NOV87

TRANSDUCER SIZE .5X. IN.FREQ. 2.25 MHZ.
BEAM COMPONENT SCW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-25	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

INST.NO. 2 / 50/70 DEG.

TRANSDUCER SIZE .3X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT C CW SWEEP DISTANCE(IN.) 2.5

6NOV87

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-25	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

MODULE PARAMETERS

	INSTR. #3	INSTR. #4
X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-1.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 12A

SHEET NO. 1 OF 1

SWRI FLAT SCAN SHEET

SITE: N/S SALEM 1 PROJECT NO. 87-1552 FILE: 0307 DATE: 7 NOV 87

SCAN NO. 01 OPERATOR: L.R. Mathews N/A WELD NO. STEAM

PARAMETERS

NOZZLE LOC. 247 VESSEL DIA. 171.3 OUTSIDE VES.DIA. 177.3
SCAN INC.(IN.) .7 CTS..7 NOZ.BORE DIA. 27.5 HOIST POS. 35.11
Y-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	14.85	0	36000	
2	CCW	15.55	36000	0	
3	CW	16.25	0	36000	
4	CCW	16.95	36000	0	
5	CW	17.65	0	36000	
6	CCW	18.35	36000	0	
7	CW	19.05	0	36000	
8	CCW	19.75	36000	0	
9	CW	20.45	0	36000	
10	CCW	21.15	36000	0	
11	CW	21.85	0	36000	
12	CCW	22.55	36000	0	
13	CW	23.25	0	36000	
14	CCW	23.95	36000	0	
15	CW	24.65	0	36000	
16	CCW	25.35	36000	0	
17	CW	26.05	0	36000	
18	CCW	26.75	36000	0	
19	CW	27.45	0	36000	
20	CCW	28.15	36000	0	
21	CW	28.85	0	36000	
22	CCW	29.55	36000	0	
23	CW	30.25	0	36000	
24	CCW	30.95	36000	0	
25	CW	31.65	0	36000	

REVIEWED BY: Carlos M Barrera (LEVEL: II) DATE: 07 Nov 87

EXAM.NO. 102

SWRI SCAN PLAN PARAMETER MODEL

SITE NAME SALEM 1 PROJECT NO. 17-1562

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1562
3.EXAM NO.=102
4.WELD NO.=27.5-RPV-1120-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ @293 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSKD052738
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=293
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=14.85
5. Y-STOP POS.=41.55
6.WELD DIAMETER=57
7.NOZZLE BORE DIAMETER AT LIP=31.5
8.Y-OFFSET (PIV.TO RPV C.L.)=73
9.HOIST POSITION=65.62
10.FIRST CAL. REFLECTOR=5
11.SECOND CAL.REFLECTOR=6
12.THIRD CAL.REFLECTOR=11
13.EXAM.ANGLE #2=6

Comp 6 Nov. 87
(JS)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 201.13
COUNTS PER DEGREE= 100

002400

EXAM NO. 112

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/2	/ 7	SCAN	START	STOP
2/5	/ 11.1			
3/9	/ 15.3	1 ~~276~~ 77	4	~~17~~ 24

INST.NO.2 /6 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 6
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/2	/ 5	SCAN	START	STOP
2/6	/ 8			
3/9	/ 11	1 ~~276~~ 77	4	~~13~~ 20

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 3 DIV.			
3	/ 4 DIV.	1 ~~276~~ 77	1 DIV.	7 DIV.
4	/ 5 DIV.			
5	/ 6 DIV.			

MODULE PARAMETERS

	45 DEG.	6 DEG.	50/70 DEG.
X-OFFSET	-.783 IN.	+.725 IN.	130 DEG.
Y-OFFSET	-2.2 IN.	-2.2 IN.	-2.2 IN.

MODULE CONFIGURATION NO. 12

SHEET NO. ~~100001~~ 10200 1

SWRI ~~EXAMINATION~~ (CMB) SHEET
SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 DATE (5 AUG 87)
EXAM NO. ~~100~~ 102 OPERATOR(S) (L.R. MATHENA) (N/A)
WELD NO. 27.5-RPV-1110-1 @ 293° TO SHELL WELD
INLET NOZZLE

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 2255
Y FUNCTION = BOOM EXTEND, X FUNCTION = SWRI ROTATOR

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO	YES	GEO	OTHER	SCAN RUN X	X	REMARKS
1	CW	1485	0	36000					X CTS RUN FROM 0°-360°
2	CCW	1520	36000	0					
3	CW	1555							
4	CCW	1590							
5	CW	1625							
6	CCW	1660							
7	CW	1695							
8	CCW	1730							
9	CW	1765							
10	CCW	1800							
11	CW	1835							
12	CCW	1870							
13	CW	1905							
14	CCW	1940							
15	CW	1975							
16	CCW	2010							
17	CW	2045							
18	CCW	2080							
19	CW	2115							
20	CCW	2150							
21	CW	2185							
22	CCW	2220							
23	CW	2255							
24	CCW	2290							
25	CW	2325							
26	CCW	2360							
27	CW	2395							
28	CCW	2430							
29	CW	2465							
30	CCW	2500							
31	CW	2535							
32	CCW	2570							
33	CW	2605							
34	CCW	2640							
35	CW	2675							
36	CCW	2710							
37	CW	2745							
38	CCW	2780							
39	CW	2815							

SHEET NO. 10 2001

EXAM NO. ~~100~~ m102 OPERATOR(S) (LR MATHENA (N/A)
WELD NO. 27.5-RPV-1110-1

SCAN	DIR	INC-POS Y	INDICATIONS NO	YES	REQ	OTHER	SCAN RUN	REMARKS
			X	X				
40	CCW	2850	34000	0			I I	
41	CW	2885					I I	
42	CCW	2920					I I	
43	CW	2955					I I	
44	CCW	2990					I I	
45	CW	3025					I I	
46	CCW	3060					I I	
47	CW	3095					I I	
48	CCW	3130					I I	
49	CW	3165					I I	
50	CCW	3200					I I	
51	CW	3235					I I	
52	CCW	3270					I I	
53	CW	3305					I I	
54	CCW	3340					I I	
55	CW	3375					I I	
56	CCW	3410					I I	
57	CW	3445					I I	
58	CCW	3480					I I	
59	CW	3515					I I	
60	CCW	3550					I I	
61	CW	3585					I I	
62	CCW	3620					I I	
63	CW	3655					I I	
64	CCW	3690					I I	
65	CW	3725					I I	
66	CCW	3760					I I	
67	CW	3795					I I	
68	CCW	3830					I I	
69	CW	3865					I I	
70	CCW	3900					I I	
71	CW	3935					I I	
72	CCW	3970					I I	
73	CW	4005					I I	
74	CCW	4040					I I	
75	CW	4075					I I	
76	CCW	4110					I I	
77	CW	4145					I I	

EXAM. TEMP. AFTER NA , TIME EXAM END 0040 .

REVIEWED BY (Carlos M Barrera (LEVEL (II) DATE (05 Nov, 87)

EXAM.NO. 103

SWRI SCAN PLAN PARAMETER RECALL

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=103
4.WELD NO.=27.3-RPV-1120-1
5.COMPONENT=RPV
6.SUBASSEMBLY=IN NOZ @293 DEG
7.PROCEDURE/REV/DEV=700-11/7
8.SCAN PATH SKETCH NO.=DSK3052736
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2.OUTSIDE VESSEL DIA.=193.3
3.INSIDE VES DIA.(I.E.IF OUTLET)=171.3
4. X-START POS.=~~0~~ 100 (19)
5. X-STOP POS.=~~36000~~ 3600
6.NOZZLE BORE DIAMETER=27.5
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=14.65
10.Y-STOP POSITION=31.85

Comp TN00.87

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 416.7

COUNTS PER DEGREE= 100

EXAM NO. 103

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1051 SCAN PAT. SA, TI TIT: 11
COMPONENT RPV SUBASSEMBLY IN NOZ @293 DEG WELD NO. 27 [illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE IR SXA.1 TYPE [illegible]
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS
INST.NO. 1 / 3 AWK / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT ~~CCW~~ CW AWK SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-25	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

****

INST.NO. 2 / 4 AWK / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW AWK SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	3 DIV.			
3	/	4 DIV.	1-25	1 DIV.	7 DIV.
4	/	5 DIV.			
5	/	6 DIV.			

****

MODULE PARAMETERS

K-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-0.2 IN.	-0.2 IN.

MODULE CONFIGURATION NO. 12A

SWRI PAR SCAN SHEET

FILE NAME [illegible] PROJECT NO. [illegible] TIME 0346 DATE 7 Nov 87

SCAN NO. 103 OPERATOR(S) LR Mathena N/A JOB NO. [illegible]

PARAMETERS

NOZZLE LOC. 293 VESSEL DIA. 171.7 OUTSIDE VES. [illegible] 3.7
SCAN INC.(IN.) .7 CTS..7 NOZ.BORE DIA. 27.5 HOIST POS. 95.61
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	14.85	0	36000	
2	CCW	15.55	36000	0	
3	CW	16.25	0	36000	
4	CCW	16.95	36000	0	
5	CW	17.65	0	36000	
6	CCW	18.35	36000	0	
7	CW	17.05	0	36000	
8	CCW	19.75	36000	0	
9	CW	20.45	0	36000	
10	CCW	21.15	36000	0	
11	CW	21.85	0	36000	
12	CCW	22.55	36000	0	
13	CW	23.25	0	36000	
14	CCW	23.95	36000	0	
15	CW	24.65	0	36000	
16	CCW	25.35	36000	0	
17	CW	26.05	0	36000	
18	CCW	26.75	36000	0	
19	CW	27.45	0	36000	
20	CCW	28.15	36000	0	
21	CW	28.85	0	36000	
22	CCW	29.55	36000	0	
23	CW	30.25	0	36000	
24	CCW	30.95	36000	0	
25	CW	31.65	0	36000	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE 07 Nov. 87

EXAM.NO. 104

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=104
4.WELD NO.=29-RPV-1110-1
5.COMPONENT=RPV
6.SUBASSEMBLY=OUT NOZ @202 DEG
7.PROCEDURE/REV/DEV=700-11/8
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=202
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=12.4
5. Y-STOP POS.=45.45
6.WELD DIAMETER=53
7.NOZZLE BORE DIAMETER AT LIP=37.2
8.Y-OFFSET (PIV.TO RPV C.L.)=73
9.HOIST POSITION=85.62
10.FIRST CAL. REFLECTOR=5.5
11.SECOND CAL.REFLECTOR=11
12.THIRD CAL.REFLECTOR=16
13.EXAM.ANGLE #2=10

Comp 6 Nov 87
(J3)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32
COUNTS PER DEGREE= 100

002100

EXAM NO. 104

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3057737
COMPONENT RPV SUBASSEMBLY OLT NOZ 0202 DEG WELD NO 2S-RPV-11
PROCEDURE/REV/DEV 700-11/8 WELD TYPE N-SHELL EXAM.TYPE PARALLEL
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. D3052285

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 7.6	SCAN	START	STOP
2/8	/ 15.3			
3/8	/ 22.3	1-469	4	24

****

INST.NO.2 /10 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 10
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 5.7	SCAN	START	STOP
2/8	/ 11.5			
3/8	/ 16.7	1-469	4	20

****

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-469	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	45 DEG.	10 DEG.	50/70
X-OFFSET	-.785 IN.	-.785 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13

SWRI EXAMINATION SHEET
SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 DATE 6 Nov 87
EXAM NO. 104 OPERATOR(S) L.R. MATHENA (2/04)
WELD NO. 2"-RPV-1110-1
OUTLET @ 202°

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 0220.
Y FUNCTION = Boom EXTEND X FUNCTION = SWRI ROTATOR

SCAN	DIR	INC-POS Y	INDICATIONS ~~NO YES DEG OTHER~~ X	X	SCAN RUN		REMARKS
1	CW	1240	0	36000			
2	CCW	1260	36000	0			
3	CW	1280					
4	CCW	1300					
5	CW	1320					
6	CCW	1340					
7	CW	1360					
8	CCW	1380					
9	CW	1400					
10	CCW	1420					
11	CW	1440					
12	CCW	1460					
13	CW	1480					
14	CCW	1500					
15	CW	1520					
16	CCW	1540					
17	CW	1560					
18	CCW	1580					
19	CW	1600					
20	CCW	1620					
21	CW	1640					
22	CCW	1660					
23	CW	1680					
24	CCW	1700					
25	CW	1720					
26	CCW	1740					
27	CW	1760					
28	CCW	1780					
29	CW	1800					
30	CCW	1820					
31	CW	1840					
32	CCW	1860					
33	CW	1880					
34	CCW	1900					
35	CW	1920					
36	CCW	1940					
37	CW	1960					
38	CCW	1980					
39	CW	2000					

SHEET NO .04C[illegible]

EXAM NO. 104 OPERATOR(S): LR Mathena (n/A)
WELD NO. 29-RFV-1110-1

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ m ~~NO~~ X	~~REC~~ X	~~GEO~~	~~OTHER~~ m	SCAN RUN	REMARKS
40	CCW	2020✓	36000	0				
41	CW	2040✓	0	36000				
42	CCW	2060✓						
43	CW	2080✓						
44	CCW	2100✓						
45	CW	2120✓						
46	CCW	2140✓						
47	CW	2160✓						
48	CCW	2180✓						
49	CW	2200✓						
50	CCW	2220✓						
51	CW	2240✓						
52	CCW	2260✓						
53	CW	2280✓						
54	CCW	2300✓						
55	CW	2320✓						
56	CCW	2340✓						
57	CW	2360✓						
58	CCW	2380✓						
59	CW	2400✓						
60	CCW	2420✓						
61	CW	2440✓						
62	CCW	2460✓						
63	CW	2480✓						
64	CCW	2500✓						
65	CW	2520✓						
66	CCW	2540✓						
67	CW	2560✓						
68	CCW	2580✓						
69	CW	2600✓						
70	CCW	2620✓						
71	CW	2640✓						
72	CCW	2660✓						
73	CW	2680✓						
74	CCW	2700✓						
75	CW	2720✓						
76	CCW	2740✓						
77	CW	2760✓						
78	CCW	2780✓						
79	CW	2800✓						
80	CCW	2820✓						
81	CW	2840✓						
82	CCW	2860✓						
83	CW	2880✓						
84	CCW	2900✓						
85	CW	2920✓						
86	CCW	2940✓						
87	CW	2960✓						
88	CCW	2980✓						
89	CW	3000✓						

m

SHEET NO. 040003

EXAM NO. 104 OPERATOR(S) L.R. Mathena (n/a)
WELD NO. 2V-RPV-1110-1

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO	YES	SIZE	STYLE	SCAN RUN	REMARKS
			X	X				
90	CCW	3020	36000	0		I	I	
91	CW	3040	0	36000		I	I	
92	CCW	3060				I	I	
93	CW	3080				I	I	
94	CCW	3100				I	I	
95	CW	3120				I	I	
96	CCW	3140				I	I	
97	CW	3160				I	I	
98	CCW	3180				I	I	
99	CW	3200				I	I	
100	CCW	3220				I	I	
101	CW	3240				I	I	
102	CCW	3260				I	I	
103	CW	3280				I	I	
104	CCW	3300				I	I	
105	CW	3320				I	I	
106	CCW	3340				I	I	
107	CW	3360				I	I	
108	CCW	3380				I	I	
109	CW	3400				I	I	
110	CCW	3420				I	I	
111	CW	3440				I	I	
112	CCW	3460				I	I	
113	CW	3480				I	I	
114	CCW	3500				I	I	
115	CW	3520				I	I	
116	CCW	3540				I	I	
117	CW	3560				I	I	
118	CCW	3580				I	I	
119	CW	3600				I	I	
120	CCW	3620				I	I	
121	CW	3640				I	I	
122	CCW	3660				I	I	
123	CW	3680				I	I	
124	CCW	3700				I	I	
125	CW	3720				I	I	
126	CCW	3740				I	I	
127	CW	3760				I	I	
128	CCW	3780				I	I	
129	CW	3800				I	I	
130	CCW	3820				I	I	
131	CW	3840				I	I	
132	CCW	3860				I	I	
133	CW	3880				I	I	
134	CCW	3900				I	I	
135	CW	3920				I	I	
136	CCW	3940				I	I	
137	CW	3960				I	I	
138	CCW	3980				I	I	
139	CW	4000				I	I	

EXAM NO. 104 OPERATOR(S) L.R. Mathews) (N/A)
MAP ID NO. 27-RPV-1(1)-1

SCAN	DIR	ENC-POS Y	INITIATION X	INITIATION Z	SCAN RUN	REMARKS
140	CCW	4020	36000	0		
141	CW	4040	0	36000		
142	CCW	4060				
143	CW	4080				
144	CCW	4100				
145	CW	4120				
146	CCW	4140				
147	CW	4160				
148	CCW	4180				
149	CW	4200				
150	CCW	4220				
151	CW	4240				
152	CCW	4260				
153	CW	4280				
154	CCW	4300				
155	CW	4320				
156	CCW	4340				
157	CW	4360				
158	CCW	4380				
159	CW	4400				
160	CCW	4420				
161	CW	4440				
162	CCW	4460				
163	CW	4480				
164	CCW	4500				
165	CW	4520				

EXAM. TEMP. AFTER N/A, TIME EXAM END N/A.

REVIEWED BY Carlos M Barrera) (LEVEL(II) DATE(06 Nov, 87)

EXAM.NO. 105

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=105
4. WELD NO.=29-RPV-1110-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT NOZ @202 DEG
7. PROCEDURE/REV/DEV=700-11/8
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=N/S-CSCL-110-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=202
2. OUTSIDE VESSEL DIA.=85.65
3. INSIDE VES DIA.(I.E.IF OUTLET)=166.5
4. X-START POS.=~~0~~ 100
5. X-STOP POS.=~~36000~~ 36100
6. NOZZLE BORE DIAMETER=53
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. Y-START POSITION=12.4
10. Y-STOP POSITION=35.05

Comp 7 Nov - 87
(JS)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32

COUNTS PER DEGREE= 100

002100

EXAM NO. 105

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSKB0S2735
COMPONENT RPV SUBASSEMBLY OUT NOZ @202 DEG WELD NO. 2P-RPV-110-1
PROCEDURE/REV/DEV 700-11/8 WELD TYPE IRS EXAM.TYPE TRANSVERSE
CAL.BLK.NO. N/S-C9CL-110-SAM DEVICE DWG.NO./CONFIG.NO. D7052269

CALIBRATION PARAMETERS
INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

MODULE PARAMETERS

X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13A

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0219) DATE(7 JUL 87)

EXAM NO. 105 OPERATOR(S) (LR MATHENA) (N/A) WELD NO. 29-RPV-1110-1

PARAMETERS

NOZZLE LOC. 202 VESSEL DIA. 166.5 OUTSIDE VES.DIA.85.65
SCAN INC.(IN.) .5 CTS..5 NOZ.BORE DIA. 53 HOIST POS. 25.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	12.4	0	36000	
2	CCW	12.9	36000	0	
3	CW	13.4	0	36000	
4	CCW	13.9	36000	0	
5	CW	14.4	0	36000	
6	CCW	14.9	36000	0	
7	CW	15.4	0	36000	
8	CCW	15.9	36000	0	
9	CW	16.4	0	36000	
10	CCW	16.9	36000	0	
11	CW	17.4	0	36000	
12	CCW	17.9	36000	0	
13	CW	18.4	0	36000	
14	CCW	18.9	36000	0	
15	CW	19.4	0	36000	
16	CCW	19.9	36000	0	
17	CW	20.4	0	36000	
18	CCW	20.9	36000	0	
19	CW	21.4	0	36000	
20	CCW	21.9	36000	0	
21	CW	22.4	0	36000	
22	CCW	22.9	36000	0	
23	CW	23.4	0	36000	
24	CCW	23.9	36000	0	
25	CW	24.4	0	36000	
26	CCW	24.9	36000	0	
27	CW	25.4	0	36000	
28	CCW	25.9	36000	0	
29	CW	26.4	0	36000	
30	CCW	26.9	36000	0	
31	CW	27.4	0	36000	
32	CCW	27.9	36000	0	
33	CW	28.4	0	36000	
34	CCW	28.9	36000	0	
35	CW	29.4	0	36000	
36	CCW	29.9	36000	0	
37	CW	30.4	0	36000	
38	CCW	30.9	36000	0	
39	CW	31.4	0	36000	

EXAM NO. 105 OPERATOR(S) LK / MATHENA (N/A) SHEET NO. 105102 WELD NO. 29-RPV-1110-

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CCW	31.9 ✓	36000	0	
41	CW	32.4 ✓	0	36000	
42	CCW	32.9 ✓	36000	0	
43	CW	33.4 ✓	0	36000	
44	CCW	33.9 ✓	36000	0	
45	CW	34.4 ✓	0	36000	
46	CCW	34.9 ✓	36000	0	

REVIEWED BY(Carlos M Barrios LEVEL(II) DATE(07 Nov 87

EXAM.NO. 106

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=106
4.WELD NO.=29-RPV-1120-1
5.COMPONENT=RPV
6.SUBASSEMBLY=OUT NOZ @338 DEG
7.PROCEDURE/REV/DEV=700-11/8
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=338
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=12.4
5. Y-STOP POS.=45.45
6.WELD DIAMETER=53
7.NOZZLE BORE DIAMETER AT LIP=37.2
8.Y-OFFSET (PIV.TO RPV C.L.)=73
9.HOIST POSITION=85.62
10.FIRST CAL. REFLECTOR=5.5
11.SECOND CAL.REFLECTOR=11
12.THIRD CAL.REFLECTOR=16
13.EXAM.ANGLE #2=10

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32
COUNTS PER DEGREE= 100

Completed 6 NOV 87 RMK

002300

EXAM NO. 106

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1302 SCAN PATH SK. DSK3332737
COMPONENT RPV SUBASSEMBLY OUT NOZ @230 DEG WELD NO. 29-RPV-111-A
PROCEDURE/REV./DEV 700-11/8 WELD TYPE N-SHELL EXAM. TYPE PARALLEL
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. 0305E2L7

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	7.6	SCAN	START	STOP
2/8	/	15.3			
3/8	/	22.3	1-469	4	24

****

INST.NO.2 /10 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 10
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	5.7	SCAN	START	STOP
2/8	/	11.5			
3/8	/	16.7	1-469	4	20

****

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-469	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	45 DEG.	10 DEG.	50/70
X-OFFSET	-.785 IN.	-.785 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13

SWRT EXAMINATION SHEET
SCAN SHEET

SITE NAME SHLEN 1 PROJECT NO. 17-1552 DATE 6 NOV 87
EXAM NO. 106 OPERATOR(S) J.ALEJANDRO N/A
WELD NO. 29-RPV-1120-1
OUTLET @ 338°

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 1415.
Y FUNCTION = BOOM EKTEND X FUNCTION = SWRI ROTATOR

SCAN	DIR	INC-POS Y	INDICATIONS ~~NO YES REC OTHER~~ X X	SCAN RUN	REMARKS
1	CW	1240	0 36000	I I	CTS START @ 100 CTS TDC A
2	CCW	1260	36000 0	I I	CTS STOP @ 36100 TDC A
3	CW	1280		I I	
4	CCW	1300		I I	
5	CW	1320		I I	
6	CCW	1340		I I	
7	CW	1360		I I	
8	CCW	1380		I I	
9	CW	1400		I I	
10	CCW	1420		I I	
11	CW	1440		I I	
12	CCW	1460		I I	
13	CW	1480		I I	
14	CCW	1500		I I	
15	CW	1520		I I	
16	CCW	1540		I I	
17	CW	1560		I I	
18	CCW	1580		I I	
19	CW	1600		I I	
20	CCW	1620		I I	
21	CW	1640		I I	
22	CCW	1660		I I	
23	CW	1680		I I	
24	CCW	1700		I I	
25	CW	1720		I I	
26	CCW	1740		I I	
27	CW	1760		I I	
28	CCW	1780		I I	
29	CW	1800		I I	
30	CCW	1820		I I	
31	CW	1840		I I	
32	CCW	1860		I I	
33	CW	1880		I I	
34	CCW	1900		I I	
35	CW	1920		I I	
36	CCW	1940		I I	
37	CW	1960		I I	
38	CCW	1980		I I	
39	CW	2000		I I	

EXAM NO. 106 OPERATOR(S) (JALEANDRO) (N/A)
LEL) NO. 29-RPV-1120-1

SCAN	DIR	INL-POS Y	INDICATIONS NE VES BEI OTHER	SCAN RUN	REMARKS
			X X		
40	CCW	2020-	36000 0	I I	
41	CW	2040-	0 36000	I I	
42	CCW	2060-		I I	
43	CW	2080-		I I	
44	CCW	2100-		I I	
45	CW	2120-		I I	
46	CCW	2140-		I I	
47	CW	2160-		I I	
48	CCW	2180-		I I	
49	CW	2200-		I I	
50	CCW	2220-		I I	
51	CW	2240-		I I	
52	CCW	2260-		I I	
53	CW	2280-		I I	
54	CCW	2300-		I I	
55	CW	2320-		I I	
56	CCW	2340-		I I	
57	CW	2360-		I I	
58	CCW	2380-		I I	
59	CW	2400-		I I	
60	CCW	2420-		I I	
61	CW	2440-		I I	
62	CCW	2460-		I I	
63	CW	2480-		I I	
64	CCW	2500-		I I	
65	CW	2520-		I I	
66	CCW	2540-		I I	
67	CW	2560-		I I	
68	CCW	2580-		I I	
69	CW	2600-		I I	
70	CCW	2620-		I I	
71	CW	2640-		I I	
72	CCW	2660-		I I	
73	CW	2680-		I I	
74	CCW	2700-		I I	
75	CW	2720-		I I	
76	CCW	2740-		I I	
77	CW	2760-		I I	
78	CCW	2780-		I I	
79	CW	2800-		I I	
80	CCW	2820-		I I	
81	CW	2840-		I I	
82	CCW	2860-		I I	
83	CW	2880-		I I	
84	CCW	2900-		I I	
85	CW	2920-		I I	
86	CCW	2940-		I I	
87	CW	2960-		I I	
88	CCW	2980-		I I	
89	CW	3000-		I I	

SHEET NO. 10600J

EXAM NO 101 OPERATOR(S) JAIGJANDRO) (~~ALK~~ N/A)
WELD NO. 29-RPV-1120-I

SCAN	DIR	INC-POS	INDICATIONS NO Y	YES Y	SCAN RUN	REMARKS
90	CCW	3020-	36000	0	I I	
91	CW	3040-	0	36000	I I	
92	CCW	3060-			I I	
93	CW	3080-			I I	
94	CCW	3100-			I I	
95	CW	3120-			I I	
96	CCW	3140-			I I	
97	CW	3160-			I I	
98	CCW	3180-			I I	
99	CW	3200-			I I	
100	CCW	3220-			I I	
101	CW	3240-			I I	
102	CCW	3260-			I I	
103	CW	3280-			I I	
104	CCW	3300-			I I	
105	CW	3320-			I I	
106	CCW	3340-			I I	
107	CW	3360-			I I	
108	CCW	3380-			I I	
109	CW	3400-			I I	
110	CCW	3420-			I I	
111	CW	3440-			I I	
112	CCW	3460-			I I	
113	CW	3480-			I I	
114	CCW	3500-			I I	
115	CW	3520-			I I	
116	CCW	3540-			I I	
117	CW	3560-			I I	
118	CCW	3580-			I I	
119	CW	3600-			I I	
120	CCW	3620-			I I	
121	CW	3640-			I I	
122	CCW	3660-			I I	
123	CW	3680-			I I	
124	CCW	3700-			I I	
125	CW	3720-			I I	
126	CCW	3740-			I I	
127	CW	3760-			I I	
128	CCW	3780-			I I	
129	CW	3800-			I I	
130	CCW	3820-			I I	
131	CW	3840-			I I	
132	CCW	3860-			I I	
133	CW	3880-			I I	
134	CCW	3900-			I I	
135	CW	3920-			I I	
136	CCW	3940-			I I	
137	CW	3960-			I I	
138	CCW	3980-			I I	
139	CW	4000-			I I	

SHEET NO. 16601-1

EXAM [illegible] (OPERATOR) JALEJANDRO (N/A)
WPT P/N [illegible] 47-85v-1120-1

WPT	DIR	END-POS	~~LEAD-IN~~ Y	~~LEAD-OUT~~ X	~~LEAD-OUT~~ X	SCAN RUN	REMARKS
140	CCW	4020-	36000	0			
141	CW	4040-	0	36000			
142	CCW	4060-					
143	CW	4080-					
144	CCW	4100-					
145	CW	4120-					
146	CCW	4140-					
147	CW	4160-					
148	CCW	4180-					
149	CW	4200-					
150	CCW	4220-					
151	CW	4240-					
152	CCW	4260-					
153	CW	4280-					
154	CCW	4300-					
155	CW	4320-					
156	CCW	4340-					
157	CW	4360-					
158	CCW	4380-					
159	CW	4400-					
160	CCW	4420-					
161	CW	4440-					
162	CCW	4460-					
163	CW	4480-					
164	CCW	4500-					
165	CW	4520-					

EXAM. TEMP. AFTER N/A, TIME EXAM END N/A.

REVIEWED BY (Carlos M Barrera) (LEVEL (II) DATE (06/07 Nov 27)

EXAM.NO. 107

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=107
4.WELD NO.=29-RPV-1120-1
5.COMPONENT=RPV
6.SUBASSEMBLY=OUT NOZ @338 DEG
7.PROCEDURE/REV/DEV=700-11/8
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=338
2.OUTSIDE VESSEL DIA.=85.65
3.INSIDE VES DIA.(I.E.IF OUTLET)=166.5
4. X-START POS.=~~0~~ 100
5. X-STOP POS.=~~36000~~ 36100
6.NOZZLE BORE DIAMETER=53
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=12.4
10.Y-STOP POSITION=35.05

Comp 7 NOV 87

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32
COUNTS PER DEGREE= 100

EXAM NO. 107

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSKJCSI739
COMPONENT RPV SUBASSEMBLY CUT NOZ @338 DEG WELD NO. 29-RPV-1120-1
PROCEDURE/REV/DEV 700-11/8 WELD TYPE IRS EXAM.TYPE TRANSVERSE
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. 03032269

CALIBRATION PARAMETERS

INST.NO. 3 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

INST.NO. 4 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

MODULE PARAMETERS

X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13A

SHEET NO. 107101

SWRI PAR SCAN SHEET

ITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0657 ?) DATE(7 Nov 83

EXAM NO. 107 OPERATOR(S) L R MATHEWS (N/A) WELD NO. 29-RPV-1130-1

PARAMETERS

NOZZLE LOC. 338 VESSEL DIA. 166.5 OUTSIDE VES.DIA. 85.63
SCAN INC.(IN.) .5 CTS..5 NOZ.BORE DIA. 33 HOIST POS. 85.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	12.4	0	36000	
2	CCW	12.9	36000	0	
3	CW	13.4	0	36000	
4	CCW	13.9	36000	0	
5	CW	14.4	0	36000	
6	CCW	14.9	36000	0	
7	CW	15.4	0	36000	
8	CCW	15.9	36000	0	
9	CW	16.4	0	36000	
10	CCW	16.9	36000	0	
11	CW	17.4	0	36000	
12	CCW	17.9	36000	0	
13	CW	18.4	0	36000	
14	CCW	18.9	36000	0	
15	CW	19.4	0	36000	
16	CCW	19.9	36000	0	
17	CW	20.4	0	36000	
18	CCW	20.9	36000	0	
19	CW	21.4	0	36000	
20	CCW	21.9	36000	0	
21	CW	22.4	0	36000	
22	CCW	22.9	36000	0	
23	CW	23.4	0	36000	
24	CCW	23.9	36000	0	
25	CW	24.4	0	36000	
26	CCW	24.9	36000	0	
27	CW	25.4	0	36000	
28	CCW	25.9	36000	0	
29	CW	26.4	0	36000	
30	CCW	26.9	36000	0	
31	CW	27.4	0	36000	
32	CCW	27.9	36000	0	
33	CW	28.4	0	36000	
34	CCW	28.9	36000	0	
35	CW	29.4	0	36000	
36	CCW	29.9	36000	0	
37	CW	30.4	0	36000	
38	CCW	30.9	36000	0	
39	CW	31.4	0	36000	

EXAM NO. 107 OPERATOR(S) L.C. Mathews (N/A) SHEET NO. 107112 WELD NO. 29-RPV-1120-

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CCW	31.9	36000	0	
41	CW	32.4	0	36000	
42	CCW	32.9	36000	0	
43	CW	33.4	0	36000	
44	CCW	33.9	36000	0	
45	CW	34.4	0	36000	
46	CCW	34.9	36000	0	

REVIEWED BY(Heather Ney) (LEVEL(III) DATE(7/20/89)

EXAM.NO. 108 RR

SITE SCAN PLAN PARAMETER PRINTOUT

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=108 RR
4. WELD NO.=27.5-RPV-1140-IRS
5. COMPONENT=RPV
6. SUBASSEMBLY=IN IRS @67 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=08K3052738
9. CAL.BLK.NO.=IR-C8CL-73-SAM
10. DEVICE DWG.NO./CONFIG.NO.=03052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2. Y-START POSITION =1440
3. Y-STOP POSITION =2090
4. X-START POS.=~~0~~ 100
5. X-STOP POS.=~~36000~~ 36100
6. NOZZLE BORE DIAMETER=27.5
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. VESSEL DIA=171.3
10. OUTSIDE VESSEL DIA=193.3

Y-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 8 NOV 87 DSK

003600

EXAM NO. 108 RR

SHEAR SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO 17-1552 SCAN PATH JK LEFT SIDE/PS
COMPONENT P.N. SUBASSEMBLY IN IRD 337 DEG WELD NO. 2Y,E-RSV 1"SCH. 10
PROBE MFR/DIV KBA-1172 WELD TYPE BW EXAM.TYPE MAN.UT
CAL.BLK.NO. IR-CSCL-TS-SAN DEVICE DWG.NO./CONF.D.NO. 830F225

CALIBRATION PARAMETERS
INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-66	1 DIV.	7 DIV.

****

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-66	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST#1	INST#2
X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-6 IN	-6 IN.

MODULE CONFIGURATION NO. 12A

SHEET NO. 1 OF 2

SWRI CAR SCAN SHEET

UNIT NAME SALEM 1 PROJECT NO. 17-1552 TIME 0630 DATE 8 Nov 87

EXAM NO. 1-9 PR OPERATOR(S): L.R. Mathews N/A WELD NO. 27.5-RPV-11 1-1

PARAMETERS

NOZZLE I.D. 27 VESSEL DIA. 171.3 OUTSIDE VES. DIA. 191.5
SCAN INC.(IN.) .10 CTS. 10 NOZ.BORE DIA. 27.5 HOIST POS. 25.67
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1440 ✓	0	36000	CTS. START @ 100 T.D.C. P
2	CCW	1450 ✓	36000	0	
3	CW	1460 ✓	0	36000	CTS STOP @ 36100 T.D.C. P
4	CCW	1470 ✓	36000	0	
5	CW	1480 ✓	0	36000	
6	CCW	1490 ✓	36000	0	
7	CW	1500 ✓	0	36000	
8	CCW	1510 ✓	36000	0	
9	CW	1520 ✓	0	36000	
10	CCW	1530 ✓	36000	0	
11	CW	1540 ✓	0	36000	
12	CCW	1550 ✓	36000	0	
13	CW	1560 ✓	0	36000	
14	CCW	1570 ✓	36000	0	
15	CW	1580 ✓	0	36000	
16	CCW	1590 ✓	36000	0	
17	CW	1600 ✓	0	36000	
18	CCW	1610 ✓	36000	0	
19	CW	1620 ✓	0	36000	
20	CCW	1630 ✓	36000	0	
21	CW	1640 ✓	0	36000	
22	CCW	1650 ✓	36000	0	
23	CW	1660 ✓	0	36000	
24	CCW	1670 ✓	36000	0	
25	CW	1680 ✓	0	36000	
26	CCW	1690 ✓	36000	0	
27	CW	1700 ✓	0	36000	
28	CCW	1710 ✓	36000	0	
29	CW	1720 ✓	0	36000	
30	CCW	1730 ✓	36000	0	
31	CW	1740 ✓	0	36000	
32	CCW	1750 ✓	36000	0	
33	CW	1760 ✓	0	36000	
34	CCW	1770 ✓	36000	0	
35	CW	1780 ✓	0	36000	
36	CCW	1790 ✓	36000	0	
37	CW	1800 ✓	0	36000	
38	CCW	1810 ✓	36000	0	
39	CW	1820 ✓	0	36000	

EXAM NO. LM 30 OPERATOR(S) L.R. Mathews/Stiles/Alvidrez UNIT NO. 27, 9-69 SHEET NO. 1 OF 1 SHEETS

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CCW	1830	36000	0	
41	CW	1840	0	36000	
42	CCW	1850	36000	0	
43	CW	1860	0	36000	
44	CCW	1870	36000	0	
45	CW	1880	0	36000	
46	CCW	1890	36000	0	
47	CW	1900	0	36000	
48	CCW	1910	36000	0	
49	CW	1920	0	36000	
50	CCW	1930	36000	0	
51	CW	1940	0	36000	
52	CCW	1950	36000	0	
53	CW	1960	0	36000	
54	CCW	1970	36000	0	
55	CW	1980	0	36000	
56	CCW	1990	36000	0	
57	CW	2000	0	36000	
58	CCW	2010	36000	0	
59	CW	2020	0	36000	
60	CCW	2030	36000	0	
61	CW	2040	0	36000	
62	CCW	2050	36000	0	
63	CW	2060	0	36000	
64	CCW	2070	36000	0	
65	CW	2080	0	36000	
66	CCW	2090	36000	0	

REVIEWED BY Carla M Barnett (LEVEL (II) DATE 08 Nov 87)

EXAM.NO. 109 RR

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 MODEL NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=109 RR
4. WELD NO.=27.5-RPV-1130--IRS
5. COMPONENT=RPV
6. SUBASSEMBLY=IN IRS @113 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL. BLK. NO.=IR-CSCL-73-SAM
10. DEVICE DWG. NO./CONFIG. NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2. Y-START POSITION =1440
3. Y-STOP POSITION =2090
4. X-START POS.=~~0~~ 100 DNK
5. X-STOP POS.=~~36000~~ 36100 DNK
6. NOZZLE BORE DIAMETER=27.5
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. VESSEL DIA=171.3
10. OUTSIDE VESSEL DIA=193.3

Y-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 8 NOV 87 DNK

[illegible] SCAN PLAN EXAMINATION TABLE

[illegible]
[illegible] SUBASSEMBLY IN 109 @11% DCG WELD NO. [illegible]
[illegible] WELD TYPE 109 EXAM TYPE [illegible]
CAL.BLK.NO. IR-CCCL-73-SAM DEVICE DWG.NO./CONFIG.NO. D305E3263

CALIBRATION PARAMETERS
INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-66	1 DIV.	7 DIV.

****

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 2.3

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-66	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST#1	INST#2
X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	.5 IN.	-.5 IN.

MODULE CONFIGURATION NO. 150

SHEET 0 OF 0

SWRI PAR SCAN SHEET

CITY NAME SALEM 1 PROJECT NO. 17-1992 TIME 0804 DATE 8 NOV. 87

EXAM ID 107 BR OPERATOR(S) (N/A) JALEJANDRO WELD NO. 21-SG-4P

PARAMETERS

NOZZLE LOC. 115 VESSEL DIA. 171.3 OUTSIDE VES.DIA.172

SD-N INC.(IN.) .10 CTS. 10 NOZ.BORE DIA.27.5 HOIST POS. 85.62

X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1440	0	36000	CTS. START @ 100 T.D.C.
2	CCW	1450	36000	0	CTS STOP @ 36100 T.D.C.
3	CW	1460	0	36000	
4	CCW	1470	36000	0	
5	CW	1480	0	36000	
6	CCW	1490	36000	0	
7	CW	1500	0	36000	
8	CCW	1510	36000	0	
9	CW	1520	0	36000	
10	CCW	1530	36000	0	
11	CW	1540	0	36000	
12	CCW	1550	36000	0	
13	CW	1560	0	36000	
14	CCW	1570	36000	0	
15	CW	1580	0	36000	
16	CCW	1590	36000	0	
17	CW	1600	0	36000	
18	CCW	1610	36000	0	
19	CW	1620	0	36000	
20	CCW	1630	36000	0	
21	CW	1640	0	36000	
22	CCW	1650	36000	0	
23	CW	1660	0	36000	
24	CCW	1670	36000	0	
25	CW	1680	0	36000	
26	CCW	1690	36000	0	
27	CW	1700	0	36000	
28	CCW	1710	36000	0	
29	CW	1720	0	36000	
30	CCW	1730	36000	0	
31	CW	1740	0	36000	
32	CCW	1750	36000	0	
33	CW	1760	0	36000	
34	CCW	1770	36000	0	
35	CW	1780	0	36000	
36	CCW	1790	36000	0	
37	CW	1800	0	36000	
38	CCW	1810	36000	0	
39	CW	1820	0	36000	

EXAM NO. 109 PR OPERATOR(S) ALEJANDRO N/A

SCAN	DIR	X-PTS	Y-START	Y-STOP	REMARKS
40	CCW	1830-	36000	0	
41	CW	1840-	0	36000	
42	CCW	1850-	36000	0	
43	CW	1860-	0	36000	
44	CCW	1870-	36000	0	
45	CW	1880-	0	36000	
46	CCW	1890-	36000	0	
47	CW	1900-	0	36000	
48	CCW	1910-	36000	0	
49	CW	1920-	0	36000	
50	CCW	1930-	36000	0	
51	CW	1940-	0	36000	
52	CCW	1950-	36000	0	
53	CW	1960-	0	36000	
54	CCW	1970-	36000	0	
55	CW	1980-	0	36000	
56	CCW	1990-	36000	0	
57	CW	2000-	0	36000	
58	CCW	2010-	36000	0	
59	CW	2020-	0	36000	
60	CCW	2030-	36000	0	
61	CW	2040-	0	36000	
62	CCW	2050-	36000	0	
63	CW	2060-	0	36000	
64	CCW	2070-	36000	0	
65	CW	2080-	0	36000	
66	CCW	2090-	36000	0	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (08 Nov 89))

EXAM.NO. 110 RR 001

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=110 RR
4. WELD NO.=27.5-RPV-1110-IRS
5. COMPONENT=RPV
6. SUBASSEMBLY=IN IRS @247 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=IR-CSCL-73-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. Y-START POSITION =1440
3. Y-STOP POSITION =2090
4. X-START POS.=~~2100~~ 100 OK
5. X-STOP POS.=~~36000~~ 36100 OK
6. NOZZLE BORE DIAMETER=27.5
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. VESSEL DIA=171.3
10. OUTSIDE VESSEL DIA=193.3

Y-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 8 Nov 87 DK

EXAM NO. 110 RR001

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME CALPM 1 PROJECT NO. 17-1552 SCAN PATH NO. DSP3L52V2P
COMPONENT REV SUBASSEMBLY IN I-S 9247 D'S WELD NO. 27.5-RRV-111-108
PROC-DUPS/REV/DEV 70H-11/7 WELD TYPE BNS EXAM.TYPE PA REV 27
CAL.BLK.NO. IP-CSCL-73-SAM DEVICE DWG.NO./CONFIG.NO. D3059236S

CALIBRATION PARAMETERS
INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-66	1 DIV.	7 DIV.

****

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-66	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST#1	INST#2
X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-6 IN.	-6 IN.

MODULE CONFIGURATION NO. 1CA

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 0909 DATE 8 NOV 37

EXAM NO. 10 RR OPERATOR(S) JALEJANDRO (N/A) WELD NO. 27.5-RPV-1

PARAMETERS

NOZZLE LOC. 247 VESSEL DIA. 171.3 OUTSIDE VES DIA. 193.3
SCAN INC. (IN.) .10 CTS. 10 NOZ. BORE DIA. 27.5 HOIST POS. 85.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION 900M EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1440	0	36000	CTS. START @ 100 TDC. B
2	CCW	1450	36000	0	CTS. STOP @ 36100 TDC. B
3	CW	1460	0	36000	
4	CCW	1470	36000	0	
5	CW	1480	0	36000	
6	CCW	1490	36000	0	
7	CW	1500	0	36000	
8	CCW	1510	36000	0	
9	CW	1520	0	36000	
10	CCW	1530	36000	0	
11	CW	1540	0	36000	
12	CCW	1550	36000	0	
13	CW	1560	0	36000	
14	CCW	1570	36000	0	
15	CW	1580	0	36000	
16	CCW	1590	36000	0	
17	CW	1600	0	36000	
18	CCW	1610	36000	0	
19	CW	1620	0	36000	
20	CCW	1630	36000	0	
21	CW	1640	0	36000	
22	CCW	1650	36000	0	
23	CW	1660	0	36000	
24	CCW	1670	36000	0	
25	CW	1680	0	36000	
26	CCW	1690	36000	0	
27	CW	1700	0	36000	
28	CCW	1710	36000	0	
29	CW	1720	0	36000	
30	CCW	1730	36000	0	
31	CW	1740	0	36000	
32	CCW	1750	36000	0	
33	CW	1760	0	36000	
34	CCW	1770	36000	0	
35	CW	1780	0	36000	
36	CCW	1790	36000	0	
37	CW	1800	0	36000	
38	CCW	1810	36000	0	
39	CW	1820	0	36000	

B

SHEET NO. 1 OF 1

BEAM NO. 110 MR OPERATOR(S) JALEJANDRO N/A WELD NO. 17,5,6,8 [illegible]

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CCW	1830-	36000	0	
41	CW	1840-	0	36000	
42	CCW	1850-	36000	0	
43	CW	1860-	0	36000	
44	CCW	1870-	36000	0	
45	CW	1880-	0	36000	
46	CCW	1890-	36000	0	
47	CW	1900-	0	36000	
48	CCW	1910-	36000	0	
49	CW	1920-	0	36000	
50	CCW	1930-	36000	0	
51	CW	1940-	0	36000	
52	CCW	1950-	36000	0	
53	CW	1960-	0	36000	
54	CCW	1770-	36000	0	
55	CW	1980-	0	36000	
56	CCW	1990-	36000	0	
57	CW	2000-	0	36000	
58	CCW	2010-	36000	0	
59	CW	2020-	0	36000	
60	CCW	2030-	36000	0	
61	CW	2040-	0	36000	
62	CCW	2050-	36000	0	
63	CW	2060-	0	36000	
64	CCW	2070-	36000	0	
65	CW	2080-	0	36000	
66	CCW	2090-	36000	0	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(08Nov18)

EXAM.NO. 111 RR001

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=111 RR
4. WELD NO.=27.5-RPV-1120-IRS
5. COMPONENT=RPV
6. SUBASSEMBLY=IN IRS @293 DEG
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=SSK3052738
9. CAL.BLK.NO.=IR-CSCL-73-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2. Y-START POSITION =1440
3. Y-STOP POSITION =2090
4. X-START POS.=~~0~~ 100 DHK
5. X-STOP POS.=~~36000~~ 36100 DHK
6. NOZZLE BORE DIAMETER=27.5
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. VESSEL DIA=171.3
10. OUTSIDE VESSEL DIA=193.3

Y-CONVERSION PARAMETERS

INCHES PER COUNT= .01 COUNTS PER INCH= 100

Completed 8 Nov 87 DHK

EXAM NO. 111 RR002

SWRI SCAN PLAN EXAMINATION

EI F [illegible] SALEM 1 PROJECT NO. 17-1552 SCAN PATH NO. [illegible]
COMPONENT RPV SUBASSEMBLY ID IRA @270 DEG WELD NO. 27,5-RPV-113 [illegible]
PROCEDURE/REV/DEV 700-11/7 WELD TYPE IRS EXAM. TYPE [illegible]
CAL. BLK. NO. IF-CBCL-75-SAM DEVICE DWG. NO./CONFIG. NO. [illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 2.5

CAL. NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-66	1 DIV.	7 DIV.

****

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 2.5

CAL. NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-66	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	INST#1	INST#2
X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-6 IN.	-6 IN.

MODULE CONFIGURATION NO. 12A

SWRI MAP SCAN [illegible]

FILE NAME SALEM 1 PROBE # [illegible] USER TIME 1013 DATE 8 NOV 87

EXAM NO. [illegible] OPERATOR(S) JALEJANDRO, NIA WELD NO. [illegible]

PARAMETERS

NOZZLE LOC. 293 VESSEL DIA. 171.3 OUTSIDE VES.DIA. 197.5
SCAN INC.(IN.) .10 CTS. 10 NOZ.BORE DIA. 27.5 HOIST POS. 65.42
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	1440	0	36000	CTS START @ 100 T.D.C.
2	CCW	1450	36000	0	CTS. STOP @ 36100 T.D.C.
3	CW	1460	0	36000	
4	CCW	1470	36000	0	
5	CW	1480	0	36000	
6	CCW	1490	36000	0	
7	CW	1500	0	36000	
8	CCW	1510	36000	0	
9	CW	1520	0	36000	
10	CCW	1530	36000	0	
11	CW	1540	0	36000	
12	CCW	1550	36000	0	
13	CW	1560	0	36000	
14	CCW	1570	36000	0	
15	CW	1580	0	36000	
16	CCW	1590	36000	0	
17	CW	1600	0	36000	
18	CCW	1610	36000	0	
19	CW	1620	0	36000	
20	CCW	1630	36000	0	
21	CW	1640	0	36000	
22	CCW	1650	36000	0	
23	CW	1660	0	36000	
24	CCW	1670	36000	0	
25	CW	1680	0	36000	
26	CCW	1690	36000	0	
27	CW	1700	0	36000	
28	CCW	1710	36000	0	
29	CW	1720	0	36000	
30	CCW	1730	36000	0	
31	CW	1740	0	36000	
32	CCW	1750	36000	0	
33	CW	1760	0	36000	
34	CCW	1770	36000	0	
35	CW	1780	0	36000	
36	CCW	1790	36000	0	
37	CW	1800	0	36000	
38	CCW	1810	36000	0	
39	CW	1820	0	36000	

EXAM NO. 111 PR OPERATOR'S: JALEJANDRO N/A) WELD NO. 37.5 SPL 11 ...

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CW	1830-	36000	0	
41	CW	1840-	0	36000	
42	CCW	1850-	36000	0	
43	CW	1860-	0	36000	
44	CCW	1870-	36000	0	
45	CW	1880-	0	36000	
46	CCW	1890-	36000	0	
47	CW	1900-	0	36000	
48	CCW	1910-	36000	0	
49	CW	1920-	0	36000	
50	CCW	1930-	36000	0	
51	CW	1940-	0	36000	
52	CCW	1950-	36000	0	
53	CW	1960-	0	36000	
54	CCW	1970-	36000	0	
55	CW	1980-	0	36000	
56	CCW	1990-	36000	0	
57	CW	2000-	0	36000	
58	CCW	2010-	36000	0	
59	CW	2020-	0	36000	
60	CCW	2030-	36000	0	
61	CW	2040-	0	36000	
62	CCW	2050-	36000	0	
63	CW	2060-	0	36000	
64	CCW	2070-	36000	0	
65	CW	2080-	0	36000	
66	CCW	2090-	36000	0	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(08 Nov 87)

EXAM.NO. .112

EXTRA BEAM PLAN PARAMETER PRINT

SITE NAME SALEM 1 PROJECT 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3 EXAM NO.=112
4.WELD NO.=27.5-RC-1140-5
5.COMPONENT=RC
6.SUBASSEMBLY=SE-N02
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052733
9.CAL.BLK.NO.=PL-CSCL-3.0-76-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=47.8
5. Y-STOP POS.=54.12 JS
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8.CAL.BLK.THICKNESS(IN.)=3
9.X-START POS.=0
10.X-STOP POS. =36000
11.HOIST POS.=85.62

Comp 8 NOV. 87

JS

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

055700

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG. 45
BEAM COMPONENT AWAY FM.VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.05	SCAN	START	STOP
3/8	/	3.1	1 ~~215~~ 170	1	8
5/8	/	5.2			
7/8	/	7.3			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 60
BEAM COMPONENT AWAY FM.VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.55	SCAN	START	STOP
3/8	/	3			
5/8	/	4.5	1 ~~210~~ 170	1	8
7/8	/	7.3			

INST.NO. ~~3~~ 4 / 0 DEG.

TRANSDUCER SIZE .5 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~.5~~ 1

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1 ~~215~~ 170	.75	2

MODULE PARAMETERS

0 DEG.	45 DEG.	60 DEG.
X-OFFSET 0 IN.	-.62 IN.	-.62 IN.
Y-OFFSET -.562 IN.	-.562 IN.	-.562 IN.

MODULE CONFIGURATION NO.13

[illegible] 2255 8 Nov 87

[illegible] LR. MATHENA N/A

PARAMETERS

NOZZLE AZIMUTH 67 NOZZLE DIA. 27.3 WALL THICKNESS [illegible]
SCAN INC.(IN.) .4 (CTS.) ~~140~~ 40 CTS WELD LENGTH 26.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION SCAN EXT.

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	47.8	54.3	
2	RET	166	54.3	47.8	
3	EXT	332	47.8	54.3	
4	RET	498	54.3	47.8	
5	EXT	664	47.8	54.3	1- 4780 ✓
6	RET	830	54.3	47.8	
7	EXT	996	47.8	54.3	2- 4820 ✓
8	RET	1162	54.3	47.8	
9	EXT	1328	47.8	54.3	3- 4860 ✓
10	RET	1494	54.3	47.8	
11	EXT	1660	47.8	54.3	4- 4900 ✓
12	RET	1826	54.3	47.8	
13	EXT	1992	47.8	54.3	5- 4940 ✓
14	RET	2158	54.3	47.8	
15	EXT	2324	47.8	54.3	6- 4980 ✓
16	RET	2490	54.3	47.8	
17	EXT	2656	47.8	54.3	7- 5020 ✓
18	RET	2822	54.3	47.8	
19	EXT	2988	47.8	54.3	8- 5060 ✓
20	RET	3154	54.3	47.8	
21	EXT	3320	47.8	54.3	9- 5100 ✓
22	RET	3486	54.3	47.8	
23	EXT	3652	47.8	54.3	10- 5140 ✓
24	RET	3818	54.3	47.8	
25	EXT	3984	47.8	54.3	11- 5180 ✓
26	RET	4150	54.3	47.8	
27	EXT	4316	47.8	54.3	12- 5220 ✓
28	RET	4482	54.3	47.8	
29	EXT	4648	47.8	54.3	13- 5260 ✓
30	RET	4814	54.3	47.8	
31	EXT	4980	47.8	54.3	14- 5300 ✓
32	RET	5146	54.3	47.8	
33	EXT	5312	47.8	54.3	15- 5340 ✓
34	RET	5478	54.3	47.8	
35	EXT	5644	47.8	54.3	16- 5380 ✓
36	RET	5810	54.3	47.8	
37	EXT	5976	47.8	54.3	17- 5420 ✓
38	RET	6142	54.3	47.8	
39	EXT	6308	47.8	54.3	

Y

X

0° - 360°

Reviewed by Carlos M Barrera Lev. II 09Nov87

EXAMINATION PARAMETERS

1.SITE NAME-SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=113
4.WELD NO.=27.5-RC-1130-5
5.COMPONENT=RC
6.SUBASSEMBLY=SE-NOZ
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=D8K3052739
9.CAL.BLK.NO.=PL-CSCL-3.0-76-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=47.8
5. Y-STOP POS.=54.1 2R
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8.CAL.BLK.THICKNESS(IN.)=3
9.X-START POS.=0
10.X-STOP POS. =36000
11.HOIST POS.=85.62

Comp 8 NOV 87

(3)

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

057300

EXAM NO. 113

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANG.(DEG.) 45
BEAM COMPONENT AWAY FM.VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.05	SCAN	START	STOP
3/8	/	3.1	1-~~210~~ 170	1	3
5/8	/	5.2			
7/8	/	7.3			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 60
BEAM COMPONENT AWAY FM.VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.55	SCAN	START	STOP
2/8	/	3			
3/8	/	4.5	1-~~210~~ 170	1	~~1~~ 8
5/8	/	7.5			

INST.NO.~~3~~ 4 / 0 DEG.

TRANSDUCER SIZE .5 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-~~210~~ 170	.75	2

MODULE PARAMETERS

	0 DEG.	45 DEG.	60 DEG.
X-OFFSET	0 IN.	+.83 IN.	+.83 IN.
Y-OFFSET	-.342 IN.	-.342 IN.	-.342 IN.

MODULE CONFIGURATION NO.15

SHEET 1 OF 1 SHEET

PROJECT NO. WHEEL 2322 8 Nov 87

OPERATOR L.R. Mathena N/A

PARAMETERS

NOZZLE AZIMUTH 113 NOZZLE DIA. 27.5 WALL THICKNESS 1.2
SCAN INC. (IN.) .4 (CTS.) ~~1.6~~ 40 WELD LENGTH 86.34
X-FUNCTION BORI ROTATOR TW HOIST POS. 85.62 Y-FUNCTION SCAN EXT

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	47.8	54.3	
2	RET	166	54.3	47.8	
3	EXT	332	47.8	54.3	
4	RET	498	54.3	47.8	
5	EXT	664	47.8	54.3	
6	RET	830	54.3	47.8	
7	EXT	996	47.8	54.3	
8	RET	1162	54.3	47.8	
9	EXT	1328	47.8	54.3	
10	RET	1494	54.3	47.8	
11	EXT	1660	47.8	54.3	
12	RET	1826	54.3	47.8	
13	EXT	1992	47.8	54.3	
14	RET	2158	54.3	47.8	
15	EXT	2324	47.8	54.3	
16	RET	2490	54.3	47.8	
17	EXT	2656	47.8	54.3	
18	RET	2822	54.3	47.8	
19	EXT	2988	47.8	54.3	
20	RET	3154	54.3	47.8	
21	EXT	3320	47.8	54.3	
22	RET	3486	54.3	47.8	
23	EXT	3652	47.8	54.3	
24	RET	3818	54.3	47.8	
25	EXT	3984	47.8	54.3	
26	RET	4150	54.3	47.8	
27	EXT	4316	47.8	54.3	
28	RET	4482	54.3	47.8	
29	EXT	4648	47.8	54.3	
30	RET	4814	54.3	47.8	
31	EXT	4980	47.8	54.3	
32	RET	5146	54.3	47.8	
33	EXT	5312	47.8	54.3	
34	RET	5478	54.3	47.8	
35	EXT	5644	47.8	54.3	
36	RET	5810	54.3	47.8	
37	EXT	5976	47.8	54.3	
38	RET	6142	54.3	47.8	
39	EXT	6308	47.8	54.3	

X

1- 4780 ✓
2- 4820 ✓
3- 4860 ✓
4- 4900 ✓
5- 4940 ✓
6- 4980 ✓
7- 5020 ✓
8- 5060 ✓
9- 5100 ✓
10- 5140 ✓
11- 5180 ✓
12- 5220 ✓
13- 5260 ✓
14- 5300 ✓
15- 5340 ✓
16- 5380 ✓
17- 5420 ✓

X

0°—360°

TW

Reviewed by Carlos M Barrera Level II 09 Nov 87 TW

EXAM.NO. 114

DATA SCAN PLAN PARAMETER TEXT

SITE NAME SALEM 1 PROJECT NO. 17-1352

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1352
3.EXAM NO.=114
4.WELD NO.=27.5-RC-1110-5
5.COMPONENT=RC
6.SUBASSEMBLY=SE-NOZ
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=PL-CSCL-3.0-76-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=47.8
5. Y-STOP POS.=54.12 (29)
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8.CAL.BLK.THICKNESS(IN.)=3
9.X-START POS.=0
10.X-STOP POS. =36000
11.HOIST POS.=85.62

Comp 9 Nov. 87
(13)

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

06000

EXAM NO. 114

SHEAR WAVE SCAN PLAN EXAMINATION TABLE

SITE LOCATION: PROJECT NO. 17-1553 SCAN PLAN DESIGNED
ENGINEER: SUBASSEMBLY DESCRIPTION: ALLOY NO. OF SPECIMEN
SPECIFICATION/REV/DEV TUBING
WELD TYPE BUTT SEAM TYPE
DRAWING: PLATECOL-3.0-76-SEAM DEVICE DWG.NO./CONFIG.NO. ST/CELL

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT AWAY FM.WELD SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.05	SCAN	START	STOP
3/8	/ 3.1	1-~~210~~ 17 (59)	1	8
5/8	/ 5.2			
7/8	/ 7.3			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 60
BEAM COMPONENT AWAY FM.WELD SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.55	SCAN	START	STOP
2/8	/ 3			
3/8	/ 4.5	1-~~210~~ 17 (59)	1	~~8~~ 8 (59)
5/8	/ 7.5			

INST.NO.3 / 0 DEG.

(40) (35)

TRANSDUCER SIZE .5 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-~~210~~ 17 (59)	.75	2

MODULE PARAMETERS

0 DEG.	45 DEG.	60 DEG.
X-OFFSET 0 IN.	+.63 IN.	-.87 IN.
Y-OFFSET -.562 IN.	-.362 IN.	-.362 IN.

MODULE CONFIGURATION NO.15

[illegible] FAIR SCAN SHEET

[illegible] PROJECT NO. [illegible] 2345 8 NOV 87

[illegible] INSPECTOR(S) LR Mathena N/A [illegible]

PARAMETERS

NOZZLE AZIMUTH 247 NOZZLE DIA. 27.5 WALL THICKNESS [illegible]
SCAN INC.(IN.) .4 (CTS.) ~~125~~ 40 CTS WELD LENGTH 36.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION SCAN EXT.

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	47.8	54.3	
2	RET	166	54.3	47.8	
3	EXT	332	47.8	54.3	
4	RET	498	54.3	47.8	
5	EXT	664	47.8	54.3	
6	RET	830	54.3	47.8	
7	EXT	996	47.8	54.3	
8	RET	1162	54.3	47.8	
9	EXT	1328	47.8	54.3	
10	RET	1494	54.3	47.8	
11	EXT	1660	47.8	54.3	
12	RET	1826	54.3	47.8	
13	EXT	1992	47.8	54.3	
14	RET	2158	54.3	47.8	
15	EXT	2324	47.8	54.3	
16	RET	2490	54.3	47.8	
17	EXT	2656	47.8	54.3	
18	RET	2822	54.3	47.8	
19	EXT	2988	47.8	54.3	
20	RET	3154	54.3	47.8	
21	EXT	3320	47.8	54.3	
22	RET	3486	54.3	47.8	
23	EXT	3652	47.8	54.3	
24	RET	3818	54.3	47.8	
25	EXT	3984	47.8	54.3	
26	RET	4150	54.3	47.8	
27	EXT	4316	47.8	54.3	
28	RET	4482	54.3	47.8	
29	EXT	4648	47.8	54.3	
30	RET	4814	54.3	47.8	
31	EXT	4980	47.8	54.3	
32	RET	5146	54.3	47.8	
33	EXT	5312	47.8	54.3	
34	RET	5478	54.3	47.8	
35	EXT	5644	47.8	54.3	
36	RET	5810	54.3	47.8	
37	EXT	5976	47.8	54.3	
38	RET	6142	54.3	47.8	
39	EXT	6308	47.8	54.3	

Y

1- 4780 ✓
2- 4820 ✓ ✓
3- 4860 ✓ ✓
4- 4900 ✓
5- 4940 ✓
6- 4980 ✓
7- 5020 ✓
8- 5060 ✓
9- 5100 ✓
10- 5140 ✓
11- 5180 ✓
12- 5220 ✓
13- 5260 ✓
14- 5300 ✓
15- 5340 ✓
16- 5380 ✓
17- 5420 ✓

X

0° – 360°

Reviewed by Carlos M Barrera Level II 09 Nov 87

EXAM.NO. 115

[illegible] SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT [illegible]

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=115
4.WELD NO.=27.5-RC-1120-5
5.COMPONENT=RC
6.SUBASSEMBLY=SE-NOZ
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052733
9.CAL.BLK.NO.=PL-CSCL-3.0-76-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=47.8
5. Y-STOP POS.=54.1 2
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8.CAL.BLK.THICKNESS(IN.)=3
9.X-START POS.=0
10.X-STOP POS. =36000
11.HOIST POS.=85.62

Comp 9 NOV. 87

(JS)

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

058600

EXAM NO. 11E

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE DEG. [illegible]
BEAM COMPONENT AWAY FM.VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.05	SCAN	START	STOP
3/8	/ 3.1	1 ~~[illegible]~~ 17 59	1	5
5/8	/ 5.2			
7/8	/ 7.3			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE .75 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 60
BEAM COMPONENT AWAY FM.VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.55	SCAN	START	STOP
2/8	/ 3			
3/8	/ 4.5	1 ~~[illegible]~~ 17 59	1	~~[illegible]~~ 8
5/8	/ 7.5			8

INST.NO.3 / 0 DEG.

4 59

TRANSDUCER SIZE .5 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1 ~~[illegible]~~ 17 59	.75	2

MODULE PARAMETERS

0 DEG.	45 DEG.	60 DEG.
X-OFFSET 0 IN.	+.83 IN.	-.83 IN.
Y-OFFSET -.362 IN.	-.362 IN.	-.362 IN.

MODULE CONFIGURATION NO.1E

SHEET 1 OF 1

SWRI PAR SCAN SHEET

SITE: VIP SALEM 1 PROJECT NO. 17-832 FILE: 0015 DATE: 9 Nov 87

EXAM NO. 118 OPERATOR(S): L.R Mathena M/A WELD NO. IP-2 TO 1

PARAMETERS

NOZZLE AZIMUTH 293 NOZZLE DIA. 27.5 WALL T-ICKNESS 2.1

SCAN INC.(IN.) .4 (CTS.) ~~165~~ 4000 WELD LENGTH 86.34

X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	47.8	54.3	
2	RET	166	54.3	47.8	
3	EXT	332	47.8	54.3	
4	RET	498	54.3	47.8	
5	EXT	664	47.8	54.3	
6	RET	830	54.3	47.8	
7	EXT	996	47.8	54.3	
8	RET	1162	54.3	47.8	
9	EXT	1328	47.8	54.3	
10	RET	1494	54.3	47.8	
11	EXT	1660	47.8	54.3	
12	RET	1826	54.3	47.8	
13	EXT	1992	47.8	54.3	
14	RET	2158	54.3	47.8	
15	EXT	2324	47.8	54.3	
16	RET	2490	54.3	47.8	
17	EXT	2656	47.8	54.3	
18	RET	2822	54.3	47.8	
19	EXT	2988	47.8	54.3	
20	RET	3154	54.3	47.8	
21	EXT	3320	47.8	54.3	
22	RET	3486	54.3	47.8	
23	EXT	3652	47.8	54.3	
24	RET	3818	54.3	47.8	
25	EXT	3984	47.8	54.3	
26	RET	4150	54.3	47.8	
27	EXT	4316	47.8	54.3	
28	RET	4482	54.3	47.8	
29	EXT	4648	47.8	54.3	
30	RET	4814	54.3	47.8	
31	EXT	4980	47.8	54.3	
32	RET	5146	54.3	47.8	
33	EXT	5312	47.8	54.3	
34	RET	5478	54.3	47.8	
35	EXT	5644	47.8	54.3	
36	RET	5810	54.3	47.8	
37	EXT	5976	47.8	54.3	
38	RET	6142	54.3	47.8	
39	EXT	6308	47.8	54.3	

Y

1- 4780 ✓
2- 4820 ✓
3- 4860 ✓
4- 4900 ✓
5- 4940 ✓
6- 4980 ✓
7- 5020 ✓
8- 5060 ✓
9- 5100 ✓
10- 5140 ✓
11- 5180 ✓
12- 5220 ✓
13- 5260 ✓
14- 5300 ✓
15- 5340 ✓
16- 5380 ✓
17- 5420 ✓

X

0°—360°

Reviewed by Carlos M Barrera Level II 09 Nov 87

EXAM.NO. 116

SITE NAME SALEM 1

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1532
3. EXAM NO.=116
4. WELD NO.=27.5-RC-1140-S
5. COMPONENT=RC
6. SUBASSEMBLY=SE-NOZ
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052728
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=53.14
5. Y-STOP POS.=58.71
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(TOWARD VES.=1,AWAY=0)=1
8. CAL.BLK.THICKNESS(IN.)=2.312
9. X-START POS.=~~0~~ 100 DNK
10. X-STOP POS. =~~34000~~ 36100 DNK
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 NOV 87 DNK

055700

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.): 45
BEAM COMPONENT TOWARD VEE. SWEEP DISTANCE(IN.): 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.95	SCAN	START	STOP
3/8	/	2.4	1-218	1	6
5/8	/	4			
7/8	/	5.6			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.): 60
BEAM COMPONENT TOWARD VEE. SWEEP DISTANCE(IN.): 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.15	SCAN	START	STOP
2/8	/	2.3	1-218	1	5
3/8	/	3.4			
5/8	/	3.7			

INST.NO.4 / 0 DEG. OK

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.): 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.): 10 OK

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.35	2

MODULE PARAMETERS

	0 DEG.	45 DEG.	60 DEG.
X-OFFSET	0 IN.	-.82 IN.	+.82 IN.
Y-OFFSET	+.562 IN.	+.562 IN.	+.562 IN.

MODULE CONFIGURATION NO.14

SHEET NO. 1 OF 1

SWRI EXAMINATION SHEET
SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 DATE: 8 NOV 87
SCAN NO. 116 OPERATOR(S) (JALEJANDRO) (N/A
WELD NO. 27.5-RC-1J40-5

PARAMETERS

VTOEC REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA , N/A , N/A , N/A
EXAM. TEMP. BEFORE NA , TIME EXAM. START 1240 .
Y=Boom EXT X=SWRI ROT

SCAN	DIR	INC-POS Y	INDICATIONS ~~NO YES GEO OTHER~~ X START	X STOP	SCAN RUN	REMARKS
1	CW	5314 -	0	360000	I I	CTS START @ 100 TDC A
2	CCW	5354 -	360000	0	I I	CTS. STOP @ 36100 TDC A
3	CW	5394 -			I I	
4	CCW	5434 -			I I	
5	CW	5474 -			I I	
6	CCW	5514 -			I I	
7	CW	5554 -			I I	
8	CCW	5594 -			I I	
9	CW	5634 -			I I	
10	CCW	5674 -			I I	
11	CW	5714 -			I I	
12	CCW	5754 -			I I	
13	CW	5794 -			I I	
14	CCW	5834 - A			I I	

EXAM. TEMP. AFTER NA , TIME EXAM END _____ .

REVIEWED BY( ) (LEVEL( ) DATE(, ,)

EXAM.NO. 117

[illegible] BEAM PLOT PARAMETER RECORD

SITE : SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=117
4.WELD NO.=27.5-RC-1130-S
5.COMPONENT=RC
6.SUBASSEMBLY=SE-NOZ
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3032268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=53.14
5. Y-STOP POS.=58.71
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(TOWARD VES.=1,AWAY=0)=1
8.CAL.BLK.THICKNESS(IN.)=2.312
9.X-START POS.=~~0~~ 100 ALK
10.X-STOP POS. =~~56000~~ 36100 ALK
11.HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.14

051300

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD WES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.83	SCAN	START	STOP
3/8	/	2.4	1-218	1	6
5/6	/	4			
7/8	/	5.6			

****

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.3 MHZ. NOM.BEAM ANGLE(DEG.)60
BEAM COMPONENT TOWARD WES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.15	SCAN	START	STOP
2/8	/	2.3	1-218	1	6
3/8	/	3.4			
5/8	/	5.7			

****

INST.NO.~~3~~ 4 / 0 DEG.
OK

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.)0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~10~~ 5
OK

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.55	2

****

MODULE PARAMETERS

	0 DEG.	45 DEG.	60 DEG.
X OFFSET	0 IN.	-.83 IN.	+.25 IN.
Y-OFFSET	+.562 IN.	+.562 IN.	+.562 IN.

MODULE CONFIGURATION NO.14

SHEET NO. 1 OF 1

SWRI EXAMINATION SHEET
SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1557 DATE 8 NOV. 87
EXAM NO. 117 OPERATOR(S) P. GAINES) (N/A)
WELD NO. 27.5-RC-1130-E

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA, NA, NA, NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 1348.

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO YES REJ OTHER XSTART	XSTOP		SCAN RUN	REMARKS
1	CW	5314	0	36000		PA	
2	CCW	5354	36000	0		PA	
3	CW	5394	0	36000		PA	
4	CCW	5434	36000	0		PA	
5	CW	5474	0	36000		PA	
6	CCW	5514	36000	0		PA	
7	CW	5554	0	36000		PA	
8	CCW	5594	36000	0		PA	
9	CW	5634	0	36000		PA	
10	CCW	5674	36000	0		PA	
11	CW	5714	~~36000~~	36000		(PA)	
12	CCW	5754	36000	0		PA	
13	CW	5794	0	36000		PA	
14	CCW	5834	36000	0		PA	

EXAM. TEMP. AFTER NA, TIME EXAM END _____.

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(08 Nov 87)

EXAM.NO. 118

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=118
4.WELD NO.=27.5-RC-1110-5
5.COMPONENT=RC
6.SUBASSEMBLY=SE-NOZ
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052730
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052260

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=53.14
5. Y-STOP POS.=58.71
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(TOWARD VES.=1,AWAY=0)=1
8.CAL.BLK.THICKNESS(IN.)=2.312
9.X-START POS.=~~2100~~ 2114
10.X-STOP POS. =~~16000~~ 3600 SAK
11.HOIST POS.=65.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 NOV 87

060000

EXAM NO. 113

[illegible]

[illegible] PROCEDURE NO. 17.302 SCAN PATH [illegible]
[illegible] BLANDERMAN 88-M02 WELD NO. [illegible]
[illegible] WELD TYPE BUTT SCAN [illegible]
CAL.BLK.NO. 2.713-88-T7-S&M DEVICE DWG.NO./CONFIG.NO. [illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)45
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ .85	SCAN	START	STOP
3/8	/ 2.4	1-218	1	2
5/8	/ 4			
7/8	/ 5.6			

****

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)60
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.15	SCAN	START	STOP
2/8	/ 2.3	1-218	1	6
3/8	/ 3.4			
5/8	/ 5.7			

****

INST.NO.~~3~~ 4 / 0 DEG.

DAF

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.)0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~2~~ 5 DAF

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.55	2

****

MODULE PARAMETERS

	0 DEG.	45 DEG.	60 DEG.
X-OFFSET	0 IN.	-.82 IN.	+.82 IN.
Y-OFFSET	+.562 IN.	+.562 IN.	+.562 IN.

MODULE CONFIGURATION NO.14

SWRI EXAMINATION SHEET
SCAN SHEET

LIFT NAME CAMEM 1 PROJECT NO. 17-1332 DATE 8 NOV 87
EXAM NO. 119 OPERATOR(S) (P.GAINES) (—)
WELD NO. 27.5 RD-1110 5

PARAMETERS

VIDEO RCEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA , TIME EXAM. START 1412 .
Y = Boom EXT X = SWRI ROT

SCAN	DIR	ENC-POS Y	INDICATIONS ~~NO YES GEO OTHER~~ X START	X STOP		SCAN RUN	MEM-SKP
1	CW	5314	0	36000		PA	
2	CCW	5354	36000	0		PA	
3	CW	5394	0	36000		PA	
4	CCW	5434	36000	0		PA	
5	CW	5474	0	36000		PA	
6	CCW	5514	36000	0		PA	
7	CW	5554	0	36000		PA	
8	CCW	5594	36000	0		PA	
9	CW	5634	0	36000		PA	
10	CCW	5674	36000	0		PA	
11	CW	5714	0	36000		PA	
12	CCW	5754	36000	0		PA	
13	CW	5794	0	36000		PA	
14	CCW	5834	36000	0		PA	

EXAM. TEMP. AFTER NA , TIME EXAM END NA .

REVIEWED BY Carlos M Gaines LEVEL (II) DATE 08 Nov 87

EXAM.NO. 119

SURE SCAN PLAN PARAMETER RECEIPT

SITE: SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=119
4. WELD NO.=27.5-RC-1120-E
5. COMPONENT=RC
6. SUBASSEMBLY=SE-NOZ
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=53.14
5. Y-STOP POS.=58.71
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(TOWARD VES.=1,AWAY=0)=1
8. CAL.BLK.THICKNESS(IN.)=2.312
9. X-START POS.=~~0~~ 100 DLK
10. X-STOP POS. =~~3460~~ 3600 DLK
11. HOIST POS.=65.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8NOV87 DLK

058600

EXAM NO. 119

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)45
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.85	SCAN	START	STOP
3/8	/	2.4	1-218	1	6
5/8	/	4			
7/8	/	5.6			

****

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)60
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.15	SCAN	START	STOP
2/8	/	2.3	1-218	1	6
3/8	/	3.4			
5/8	/	5.7			

****

INST.NO.3 / 0 DEG.

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.)0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~10~~ 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.55	2

****

MODULE PARAMETERS

0 DEG.	45 DEG.	60 DEG.
X-OFFSET 0 IN.	-.93 IN.	+.32 IN.
Y-OFFSET +.362 IN.	+.362 IN.	+.362 IN.

MODULE CONFIGURATION NO.14

SHEET NO. 1 (REV 1)

EDDY CURRENT EXAMINATION SHEET

SCAN SHEET

SITE NAME: SWRI PROJECT NO. 17-1152 DATE: 8 Nov 87
SCAN ID: 11 OPERATOR(S): P. Gaines : N/A
WELD NO. 17-3-RC-1121-2

PARAMETERS

STORE REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 1505.

Y = Boom EXT X = SWRI ROT

SCAN	DIR	INC-POS Y	INDICATIONS X START	X STOP	NO. VEG SCIP SHEET	SCAN RUN	REMARKS
1	CW	5314	0	36000		PD	
2	CCW	5354	36000	0		PC	
3	CW	5394	0	36000		PB	
4	CCW	5434	36000	0		PA	
5	CW	5474	0	36000		PZ	
6	CCW	5514	36000	0		PY	
7	CW	5554	0	36000		PX	
8	CCW	5594	36000	0		PW	
9	CW	5634	0	36000		PV	
10	CCW	5674	36000	0		PU	
11	CW	5714	0	36000		PT	
12	CCW	5754	36000	0		PS	
13	CW	5794 -				PR	
14	CCW	5834 -				PQ	

EXAM. TEMP. AFTER NA, TIME EXAM END N/A.

REVIEWED BY Carlos M Barrera (LEVEL II) DATE (08 Nov 87)

EXAM.NO. 120

EDDY SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=120
4. WELD NO.=27.5-RC-1140-4
5. COMPONENT=RC
6. SUBASSEMBLY=ELBOW-SE
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-83-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=52.77
5. Y-STOP POS.=59.27
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. X-START POS.=~~2~~100 DMK
10. X-STOP POS. =~~36000~~ 36100 DMK
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 Nov 87 DMK

055600

EXAM NO. 130

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT AWAY FM.WEB. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ .85	SCAN	START	STOP
3/8	/ 2.4	1-218	1	3
5/8	/ 4			
7/8	/ 5.6			

****

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.) 60
BEAM COMPONENT AWAY FM.WEB. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.15	SCAN	START	STOP
2/8	/ 2.3	1-218	1	6
3/6	/ 3.4			
5/8	/ 5.7			

****

INST.NO.~~3~~ 4 / 0 DEG.

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.) 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~10~~ 5 OK

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.35	2

****

MODULE PARAMETERS

0 DEG.	45 DEG.	60 DEG.
X-OFFSET 0 IN.	-.83 IN.	-.87 IN.
Y-OFFSET -.562 IN.	-.362 IN.	-.262 IN.

MODULE CONFIGURATION NO.13

SHEET NO. 1 OF 1

EDDY CURRENT EXAMINATION SHEET

SCAN SHEET

SITE: [illegible] SALEM 1 PROJECT NO. 17-1992 DATE: 8 NOV 87

EXAM BY: (SO) OPERATOR'S: JALEJANDRO ( ) N/A

WORK NO.: 27 5-1PV-1141-4 INLET CLOSE BW # 17 JOB

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA

CALIBRATION SHEET (S) NA, NA, NA, NA

EXAM. TEMP. BEFORE NA, TIME EXAM. START 1740

Y = Boom Ext X = SWRI ROT

SCAN	DIR	INC-POS Y	INDICATIONS ~~NO YES SEG OTHER~~ X START	X STOP	SCAN RUN	REMARKS
1	CW	5277	0	36000		CTS. START @ 100 TDC. #
2	CCW	5317	36000	0		CTS STOP @ 36100 TDC. #
3	CW	5357				
4	CCW	3397				
5	CW	5437				
6	CCW	5477				
7	CW	5517				
8	CCW	5557				
9	CW	5597				
10	CCW	5637				
11	CW	5677				
12	CCW	5717				-
13	CW	5757				
14	CCW	5797				
15	CW	5837				
16	CCW	5877				
17	CW	3917				#

EXAM. TEMP. AFTER NA, TIME EXAM END NA.

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(08 Nov 87)

EXAM.NO. 121

SCAN PLAN PARAMETER SHEET

SITE : SALEM 1 PROJECT #: 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=121
4. WELD NO.=27.S-RC-1130-4
5. COMPONENT=RC
6. SUBASSEMBLY=ELBOW-SE
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=52.77
5. Y-STOP POS.=59.27
4. Y-OFFSET (PIV.TO VES.C.L.)=73
7. SEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. X-START POS.=~~2~~ 100 OK
10. X-STOP POS. =~~36000~~ 36100 OK
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 Nov 87 OK

057200

EXAM NO. 121

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG. 1
BEAM COMPONENT AWAY FM.WES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ .85	SCAN	START	STOP
3/8	/ 2.4	1-218	1	8
3/8	/ 4			
7/8	/ 5.6			

****

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)60
BEAM COMPONENT AWAY FM.WES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.15	SCAN	START	STOP
2/8	/ 2.3	1-218	1	6
3/8	/ 3.4			
5/8	/ 5.7			

****

INST.NO.~~3~~ 4 OSK / 0 DEG.

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.)0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~10~~ 5 OSK

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.55	2

****

MODULE PARAMETERS

	0 DEG.	45 DEG.	60 DEG.
X-OFFSET	0 IN.	+.83 IN.	-.87 IN.
Y-OFFSET	-.362 IN.	-.562 IN.	-.513 IN.

MODULE CONFIGURATION NO.15

SHEET NO. (211.1

SHIRE EXAMINATION SHEET
SCAN SHEET

SITE NAME SNEC 1 PROJECT NO. 17 1552 DATE 8 NOV 87
EXAM NO. 131 OPERATOR(S) JALEJANDRO (N/A)
WELD NO. 27 S-RPV-1130-4 INLET EL-SE BW @ 113 DEG

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA, NA, NA, NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 1840.

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO YES SEG OTHER % START	% STOP	SCAN RUN	REMARKS
1	CW	5277-	0	36000		CTS START @ 100 TDC B
2	CCW	5317-	36000	0		CTS STOP @ 36100 TDC, B
3	CW	5357-				
4	CCW	5397-				
5	CW	5437-				
6	CCW	5477-				
7	CW	5517-				
8	CCW	5557-				
9	CW	5597-				
10	CCW	5637-				
11	CW	5677-				
12	CCW	5717-				
13	CW	5757-				
14	CCW	5797-				
15	CW	5837-				
16	CCW	5877-				
17	CW	5917-				

EXAM. TEMP. AFTER NA, TIME EXAM END NA.

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(08 Nov 87)

EXAM.NO. 122

[illegible] SCAN PLAN PARAMETER REPORT

SITE NAME SALEM 1 [illegible]

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=122
4. WELD NO.=27.5-RC-1110-4
5. COMPONENT=RC
6. SUBASSEMBLY=ELBOW-SE
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052730
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052266

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=52.77
5. Y-STOP POS.=59.27
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. X-START POS.=~~0~~ 100 DMK
10. X-STOP POS. =~~36000~~ 36100 DMK
11. HOIST POS.=25.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 Nov 87 DMF

059900

EXAM NO. 122

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)45
BEAM COMPONENT AWAY FM.WLD. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ .85	SCAN	START	STOP
3/8	/ 2.4	1-218	1	8
5/8	/ 4			
7/8	/ 5.6			

****

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.)60
BEAM COMPONENT AWAY FM.WLD. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1/8	/ 1.15	SCAN	START	STOP
2/8	/ 2.3	1-218	1	6
3/8	/ 3.4			
5/8	/ 5.7			

****

INST.NO.~~3~~ 4 0 DEG.

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.)0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) ~~4~~ 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-219	.55	2

****

MODULE PARAMETERS

	0 DEG.	45 DEG.	60 DEG.
X-OFFSET	0 IN.	+.80 IN.	-.35 IN.
Y-OFFSET	-.562 IN.	-.562 IN.	.562 IN.

MODULE CONFIGURATION NO.13

SHEET NO. 0001

SWRI EXAMINATION SHEET

SCAN SHEET

PLANT NAME SALEM 1 PROJECT NO. 17-1552 DATE: 8 NOV 87

EXAM NO. 122 OPERATOR(S): (#) WALGANDRO

WELD NO. 87.5-RC-111) 4 INLET EL-SE BW @ 247 DEG

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA

CALIBRATION SHEET (S) NA, NA, NA, NA

EXAM. TEMP. BEFORE NA, TIME EXAM. START 1907

Y = Boom EXT X = SWRI ROT

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO YES SEE OTHER START	STOP	SCAN RUN	REMARKS
1	CW	5277-	0	36000	I I	CTS. START @ 100 T.O.C. #
2	CCW	5317-	36000	0	I I	CTS STOP @ 36100 T.O.C. #
3	CW	5357-			I I	
4	CCW	5397-			I I	
5	CW	5437-			I I	
6	CCW	5477-			I I	
7	CW	5517-			I I	
8	CCW	5557-			I I	
9	CW	5597-			I I	
10	CCW	5637-			I I	
11	CW	5677-			I I	
12	CCW	5717-			I I	
13	CW	5757-			I I	
14	CCW	5797-			I I	
15	CW	5837-			I I	
16	CCW	5877-			I I	
17	CW	5917- #			I I	

EXAM. TEMP. AFTER NA, TIME EXAM END NA

REVIEWED BY Carlos M Barrera (LEVEL II) DATE 08 Nov 87

EXAM.NO. 123

[illegible] SCAN PLAN PARAMETER [illegible]

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=123
4. WELD NO.=27.5-RC-1120-4
5. COMPONENT=RC
6. SUBASSEMBLY=ELBOW-SE
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3352738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. Y-START POS.=52.77
5. Y-STOP POS.=59.27
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(TOWARD VES.=1,AWAY=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. X-START POS.=~~0~~ 100 OK
10. X-STOP POS. =~~36000~~ 36100 OK
11. HOIST POS.=85.62

Comp 8 Nov 87
JS

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

058500

EXAM NO. 123

[illegible]

[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT AWAY FM.WES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.83	SCAN	START	STOP
3/8	/	2.4	1-218	1	6
5/8	/	4			
7/8	/	5.6			

INST.NO.2 / 60 DEG.

TRANSDUCER SIZE.75 FREQ .1.5 MHZ. NOM.BEAM ANGLE(DEG.) 60
BEAM COMPONENT AWAY FM.WES. SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	1.15	SCAN	START	STOP
3/8	/	3.3	1-218	1	4
5/8	/	3.4			
7/8	/	5.7			

INST.NO.4 / 0 DEG.

TRANSDUCER SIZE.5 FREQ .2.25 MHZ. NOM.BEAM ANGLE(DEG.) 0
BEAM COMPONENT ST.BEAM SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
LAMINATION ONLY	SCAN	START	STOP
	1-218	.33	2

MODULE PARAMETERS

0 DEG.	45 DEG.	60 DEG.
X-OFFSET 0 IN.	+.33 IN.	-.33 IN.
Y-OFFSET -.562 IN.	-.562 IN.	-.562 IN.

MODULE CONFIGURATION NO.15

SHEET 2 OF 3

SWRI EXAMINATION SHEET

SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 DATE (8 Nov 87
S AM NO. 123 OPERATOR(S) (L.R. MATHENA) (N/A
WELD NO. 27-SI-HC-1120-4 INLET EL-SE SW @ 295 DEG

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA , NA , NA , NA
EXAM. TEMP. BEFORE NA , TIME EXAM. START 2007 .

Y = Boom EXT X = SWRI ROTATOR

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO YES DEG OTHER X START	X STOP		SCAN RUN		REMARKS
1	CW	5277	0	360		I	I	
2	CCW	5317	360	0		I	I	
3	CW	5357				I	I	
4	CCW	5397				I	I	
5	CW	5437				I	I	
6	CCW	5477				I	I	
7	CW	5517				I	I	
8	CCW	5557				I	I	
9	CW	5597				I	I	
10	CCW	5637				I	I	
11	CW	5677				I	I	
12	CCW	5717				I	I	
13	CW	5757				I	I	
14	CCW	5797				I	I	
15	CW	5837				I	I	
16	CCW	5877				I	I	
17	CW	5917				I	I	

EXAM. TEMP. AFTER NA , TIME EXAM END NA .

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (09 Nov, 87)

EXAM.NO. 124

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=124
4. WELD NO.=27.5-RC-1140-4 & 5
5. COMPONENT=ELBOW-SE-NOZ
6. SUBASSEMBLY=RC
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=~~0~~ 100 OK
5. X-STOP POS.=~~36000~~ 36100 OK
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. Y-START POS.(FM.CL)=125.51
10. COVERAGE IN INCHES=6
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 Nov 87 OK

EXAM NO. 124

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK1052T2E
COMPONENT ELBOW-SE-N02 SUBASSEMBLY RC WELD NO. 27.5-RC-1140-4 & E
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.3:2-SS-37-SAM DEVICE DWG.NO./CONFIG.NO. DSK32268

CALIBRATION PARAMETERS
INST.NO. 1 / 45 DEG.
3 OK

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
			SCAN	START	STOP
1/8	/	.85			
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	-.532 IN.
Y-OFFSET	-1.25 IN.

MODULE CONFIGURATION NO.16

SHEET NO. 1241

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1300) DATE(8 NOV 87)

EXAM NO. 124 OPERATOR(S) (ALEJANDRO) (N/A) WELD NO. 27.5-RC-1140-4 & 5

PARAMETERS

NOZZLE AZIMUTH 67 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC.(IN.) .6 (CTS.) .6 WELD LENGTH 96.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	53.76	0	36000	CTS. START @ 100 TDC. Ø
2	CCW	54.36	36000	0	CTS STOP @ 36100 TDC. Ø
3	CW	54.96	0	36000	
4	CCW	55.56	36000	0	
5	CW	56.16	0	36000	
6	CCW	56.76	36000	0	
7	CW	57.36	0	36000	
8	CCW	57.96	36000	0	
9	CW	58.56	0	36000	
10	CCW	59.16	36000	0	
11	CW	59.76	0	36000	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(08 Nov, 87)

EXAM.NO. 125

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=125
4.WELD NO.=27.5-RC-1130-4 & 5
5.COMPONENT=ELBOW-SE-NOZ
6.SUBASSEMBLY=RC
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=~~0~~100 DJK
5. X-STOP POS.=~~36000~~3600 DJK
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(CW=1,CCW=0)=0
8.CAL.BLK.THICKNESS(IN.)=2.312
9.Y-START POS.(FM.CL)=125.51
10.COVERAGE IN INCHES=6
11.HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 NOV 87 DJK

057200

EXAM NO. 125

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH DESIGNATION
COMPONENT ELBOW-SE-NOZ SUBASSEMBLY RC WELD NO. C7.5-RC-1130-4 & 5
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.312-88-37-SAM DEVICE DWG.NO./CONFIG.NO. 3305226S

CALIBRATION PARAMETERS
INST.NO. 3 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.85	SCAN	START	STOP
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	-.532 IN.
Y-OFFSET	-1.25 IN.

MODULE CONFIGURATION NO.16

SHEET NO.10510!

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1320) DATE(8 NOV 87

EXAM NO. 125 OPERATOR(S) (JALEJANDRO N/A) WELD NO. 27.5-RC-11[illegible]

PARAMETERS

NOZZLE AZIMUTH 113 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC.(IN.) .6 (CTS.) .6 WELD LENGTH 86.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	53.76	0	36000	CTS START @ 100 T.D.C.
2	CCW	54.36	36000	0	CTS STOP @ 36100 T.D.C.
3	CW	54.96	0	36000	
4	CCW	55.56	36000	0	
5	CW	56.16	0	36000	
6	CCW	56.76	36000	0	
7	CW	57.36	0	36000	
8	CCW	57.96	36000	0	
9	CW	58.56	0	36000	
10	CCW	59.16	36000	0	
11	CW	59.76	0	36000	

REVIEWED BY Linda M Barnes (LEVEL(II) DATE(08,Nov,87)

EXAM.NO. 126

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=126
4. WELD NO.=27.5-RC-1110-4 & 5
5. COMPONENT=ELBOW-SE-NOZ
6. SUBASSEMBLY=RC
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=~~2~~ 100 DLK
5. X-STOP POS.=~~36000~~ 3600 DLK
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. Y-START POS.(FM.CL)=125.51
10. COVERAGE IN INCHES=6
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 6 NOV 87 DLK

059900

EXAM NO. 126

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1092 SCAN PATH SK. SSKC0827E3
COMPONENT ELBOW-SE-NCZ SUBASSEMBLY RC WELD NO. 27.5-RC-1110-4 & 5
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.312-SS-37-SAM DEVICE DWG.NO./CONFIG.NO. D3083266

CALIBRATION PARAMETERS
INST.NO. 1 / 45 DEG.
3 AWK

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.85	SCAN	START	STOP
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	-.532 IN.
Y-OFFSET	-1.25 IN.

MODULE CONFIGURATION NO.16

SHEET NO. 124 of 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1433) DATE(8 Nov 87)

EXAM NO. 126 OPERATOR(S)(P GAINES)(N/A) WELD NO. 27.3-RC-1110-4 & 5

PARAMETERS

NOZZLE AZIMUTH 247 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC.(IN.) .6 (CTS.) .6 WELD LENGTH 86.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	53.76	0	36000	
2	CCW	54.36	36000	0	
3	CW	54.96	0	36000	
4	CCW	55.56	36000	0	
5	CW	56.16	0	36000	
6	CCW	56.76	36000	0	
7	CW	57.36	0	36000	
8	CCW	57.96	36000	0	
9	CW	58.56	0	36000	
10	CCW	59.16	36000	0	
11	CW	59.76	0	36000	

REVIEWED BY (Carlos M Barrera) (LEVEL(II) DATE(08 Nov 87)

EXAM.NO. 127

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1

PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=127
4. WELD NO.=27.5-RC-1120-4 & 5
5. COMPONENT=ELBOW-SE-NOZ
6. SUBASSEMBLY=RC
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=Ø100 DLK
5. X-STOP POS.=~~36000~~ 36100 DLK
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(CW=1,CCW=0)=0
8. CAL.BLK.THICKNESS(IN.)=2.312
9. Y-START POS.(FM.CL)=125.51
10. COVERAGE IN INCHES=6
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23

DEGREES PER INCH= 4.16

Completed 8NOV87 DLK

058500
058600

EXAM NO. 127

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DS/30E2778
COMPONENT ELBOW-SE-N02 SUBASSEMBLY RC WELD NO. 27.E-RC-1121-1 & 2
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.312-89-37-SAM DEVICE DWG.NO./CONFIG.NO. D30E2263

CALIBRATION PARAMETERS
INST.NO. 1 / 45 DEG.
3 NW

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
			SCAN	START	STOP
1/8	/	.85			
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	-.532 IN.
Y-OFFSET	-1.25 IN.

MODULE CONFIGURATION NO.16

SHEET NO. 107101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(1448) DATE(8 NOV 87)

EXAM NO. 127 OPERATOR(S)(P. Gaines)(MT N/A) WELD NO. 27.S-RC-1101-4 S.E

PARAMETERS

NOZZLE AZIMUTH 293 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC.(IN.) .6 (CTS.) .6 WELD LENGTH 86.24
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	53.76 (PA)	0	36000	
2	CCW	54.36 (PB)	36000	0	
3	CW	54.96 (PC)	0	36000	
4	CCW	55.56 (PD)	36000	0	
5	CW	56.16 (PE)	0	36000	
6	CCW	56.76 (PF)	36000	0	
7	CW	57.36 (PG)	0	36000	
8	CCW	57.96 (PH)	36000	0	
9	CW	58.56 (PI)	0	36000	
10	CCW	59.16 (PJ)	36000	0	
11	CW	59.76 (PK)	0	36000	

REVIEWED BY Carlos M. Barrera (LEVEL(II) DATE(08 Nov 87)

EXAM.NO. 128

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=128
4. WELD NO.=27.5-RC-1140-4 & 5
5. COMPONENT=ELBOW-SE-NOZ
6. SUBASSEMBLY=RC
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=67
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=~~0~~ 100 DAK
5. X-STOP POS.=~~36000~~ 36100 DAK
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=2.312
9. Y-START POS.(FM.CL)=125.51
10. COVERAGE IN INCHES=6
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 NOV 87 DAK

EXAM NO. 128

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052738
COMPONENT ELBOW-SE-NOZ SUBASSEMBLY RC WELD NO. 27.5-RC-1140-4 & 5
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.312-SS-37-SAM DEVICE DWG.NO./CONFIG.NO. D3052268

CALIBRATION PARAMETERS
INST.NO. 3 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.85	SCAN	START	STOP
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	+ .532 IN.
Y-OFFSET	+1.25 IN.

MODULE CONFIGURATION NO.17

SHEET NO. 1CD101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 1800) DATE (8 NOV, 87

EXAM NO. 128 OPERATOR(S) (JALEJANDRO (N/A) WELD NO. 27.5-RC-1140-4 & 5

PARAMETERS

NOZZLE AZIMUTH 67 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC.(IN.) .6 (CTS.) .6 WELD LENGTH 86.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	51.26 -	0	36000	CTS START @ 100 T.D.C. #
2	CCW	51.86 -	36000	0	CTS STOP @ 36100 T.D.C. #
3	CW	52.46 -	0	36000	
4	CCW	53.06 -	36000	0	
5	CW	53.66 -	0	36000	
6	CCW	54.26 -	36000	0	
7	CW	54.86 -	0	36000	
8	CCW	55.46 -	36000	0	
9	CW	56.06 -	0	36000	
10	CCW	56.66 -	36000	0	
11	CW	57.26 -	0	36000	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (8 Nov, 87)

EXAM.NO. 129

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=129
4. WELD NO.=27.5-RC-1130-4 & 5
5. COMPONENT=ELBOW-SE-NOZ
6. SUBASSEMBLY=RC
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=113
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=~~0~~ 100 DSK
5. X-STOP POS.=~~36000~~ 36100 DSK
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=2.312
9. Y-START POS.(FM.CL)=125.51
10. COVERAGE IN INCHES=6
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

Completed 8 NOV 87 DSK

057200

EXAM NO. 129

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1332 SCAN PATH SK. DSK10327'3
COMPONENT ELBOW-SE-NOZ SUBASSEMBLY RC WELD NO. 27.5-RC-1170-4 & 5
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.312-SS-37-SAM DEVICE DWG.NO./CONFIG.NO. DTV32268

CALIBRATION PARAMETERS
INST.NO. X / 45 DEG.
3 MK

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.85	SCAN	START	STOP
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	+ .532 IN.
Y-OFFSET	+1.25 IN.

MODULE CONFIGURATION NO.17

SHEET NO. 129101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (1826 DATE (8 NOV 87)

EXAM NO. 129 OPERATOR(S) (ALEJANDRO) (N/A) WELD NO. 27.5-RC-111D-4 1 I

PARAMETERS

NOZZLE AZIMUTH 113 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC.(IN.) .6 (CTS.) .6 WELD LENGTH 86.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	51.26 -	0	36000	CTS START @ 100 T.D.C. A
2	CCW	51.86-	36000	0	CTS STOP @ 36100 T.D.C. A
3	CW	52.46-	0	36000	
4	CCW	53.06-	36000	0	
5	CW	53.66-	0	36000	
6	CCW	54.26-	36000	0	
7	CW	54.86-	0	36000	
8	CCW	55.46-	36000	0	
9	CW	56.06-	0	36000	
10	CCW	56.66 -	36000	0	
11	CW	57.26-	0	36000	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (08 Nov 87)

EXAM.NO. 130

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1

PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=130
4. WELD NO.=27.5-RC-1110-4 & 5
5. COMPONENT=ELBOW-SE-NOZ
6. SUBASSEMBLY=RC
7. PROCEDURE/REV/DEV=700-10/3
8. SCAN PATH SKETCH NO.=DSK3052738
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=247
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=~~0~~ 100 OAK
5. X-STOP POS.=~~36000~~ 36100 OAK
6. Y-OFFSET (PIV.TO VES.C.L.)=73
7. BEAM DIR.(CW=1,CCW=0)=1
8. CAL.BLK.THICKNESS(IN.)=2.312
9. Y-START POS.(FM.CL)=125.51
10. COVERAGE IN INCHES=6
11. HOIST POS.=85.62

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23

DEGREES PER INCH= 4.16

Completed 6NOV87 OAK

059900
060000

EXAM NO. 130

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1352 SCAN PATH SK. DSK[illegible]
COMPONENT ELBOW-SE-NOZ SUBASSEMBLY RC WELD NO. 27.S-RC-1110-4 & 5
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE [illegible]
CAL.BLK.NO. 2.312-SS-37-SAM DEVICE DWG.NO./CONFIG.NO. D3055[illegible]

CALIBRATION PARAMETERS
INST.NO. 1 3 / 45 DEG.

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	.85	SCAN	START	STOP
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	+ .532 IN.
Y-OFFSET	+1.25 IN.

MODULE CONFIGURATION NO.17

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (1925) DATE: 8 NOV 87

EXAM NO. 130 OPERATOR(S) (ALEJANDRO N/A) WELD NO. 27.5-RC-1110-A & B

PARAMETERS

NOZZLE AZIMUTH 247 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC. (IN.) .6 (CTS.) .6 WELD LENGTH 86.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	51.26	0	36000	CTS. START @ 100 TDC A
2	CCW	51.86	36000	0	CTS. STOP @ 36100 T.D.C. A
3	CW	52.46	0	36000	
4	CCW	53.06	36000	0	
5	CW	53.66	0	36000	
6	CCW	54.26	36000	0	
7	CW	54.86	0	36000	
8	CCW	55.46	36000	0	
9	CW	56.06	0	36000	
10	CCW	56.66	36000	0	
11	CW	57.26	0	36000	

REVIEWED BY John M Barnes (LEVEL (II) DATE (08, Nov 87)

EXAM.NO. 131

EXAM SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=131
4.WELD NO.=27.5-RC-1120-4 & 5
5.COMPONENT=ELBOW-SE-NOZ
6.SUBASSEMBLY=RC
7.PROCEDURE/REV/DEV=700-10/3
8.SCAN PATH SKETCH NO.=DSK3052738
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052268

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=293
2. NOZZLE BORE DIA.=27.5
3. WALL THICKNESS=2.5
4. X-START POS.=0
5. X-STOP POS.=36000
6.Y-OFFSET (PIV.TO VES.C.L.)=73
7.BEAM DIR.(CW=1,CCW=0)=1
8.CAL.BLK.THICKNESS(IN.)=2.312
9.Y-START POS.(FM.CL)=125.51
10.COVERAGE IN INCHES=6
11.HOIST POS.=85.62

Comp 8 NOV-87

JS

X-CONVERSION PARAMETERS

INCHES PER DEGREE= .23 DEGREES PER INCH= 4.16

058600/58500

EXAM NO. 131

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK30552733
COMPONENT ELBOW-SE-NOZ SUBASSEMBLY RC WELD NO. 27.3-RC-1120-4 & 5
PROCEDURE/REV/DEV 700-10/3 WELD TYPE BUTT SCAN TYPE TRANSVERSE
CAL.BLK.NO. 2.312-SS-37-SAM DEVICE DWG.NO./CONFIG.NO. D30S2262

CALIBRATION PARAMETERS
INST.NO. 1 / 45 DEG.
3 OK

TRANSDUCER SIZE .75 FREQ. 1.5 MHZ. NOM.BEAM ANGLE(DEG) 45
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
			SCAN	START	STOP
1/8	/	.85			
3/8	/	2.4			
5/8	/	4	1-11	1	4.55
7/8	/	5.6			

MODULE PARAMETERS

	45 DEG.T
X-OFFSET	+ .532 IN.
Y-OFFSET	+1.25 IN.

MODULE CONFIGURATION NO.17

SHEET NO. 17...1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (1945) DATE 8 NOV 87

EXAM NO. 101 OPERATOR(S) (JALEJANDRO) (N/A) WELD NO. 27.5-RC-...

PARAMETERS

NOZZLE AZIMUTH 293 NOZZLE DIA. 27.5 WALL THICKNESS 2.5
SCAN INC. (IN.) .6 (CTS.) .6 WELD LENGTH 86.34
X-FUNCTION SWRI ROTATOR HOIST POS. 85.62 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	51.26	0	36000	CTS. START @ 100 T.D.C.
2	CCW	51.86	36000	0	CTS. STOP @ 36100 T.D.C.
3	CW	52.46	0	36000	
4	CCW	53.06	36000	0	
5	CW	53.66	0	36000	
6	CCW	54.26	36000	0	
7	CW	54.86	0	36000	
8	CCW	55.46	36000	0	
9	CW	56.06	0	36000	~~1945 STA~~
10	CCW	56.66	36000	0	
11	CW	57.26	0	36000	

REVIEWED BY (Alex M Barrera) (LEVEL (II) DATE (09 Nov, 87

EXAM.NO. 132

DATA BOARD FLAW PARAMETER FILE

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=132
4.WELD NO.=29-RC-1140-1&2
5.COMPONENT=RC
6.SUBASSEMBLY=NOZ-SE-PIPE
7.PROCEDURE/REV/DEV=700-10/4
8.SCAN PATH SKETCH NO.=DSK3052709
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052249

CALIBRATION AND DEVICE PARAMETERS

1.NOZZLE AZIMUTH=32
2.PIPE THICKNESS=2.5
3.WELD LOC FROM VES CL(IN)=118.56
4.Y-START POS.=41
5.Y-STOP POS.=54.75
6.NOZZLE BORE DIAMETER=29
7.Y-OFFSET (PIV.TO RFV C.L.)=73
8.HOIST POSITION=85.62
9.X-START POS.=0
10.X-STOP POS.=36000

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 395.34
COUNTS PER DEGREE= 100

Completed 7 Nov 85 DAC

04-1300

EXAM NO. 132

BORE SCAN PLAN SUMMARY

SITE NAME/FILE: [illegible] TRACE NO. 17-[illegible] STA. [illegible]
UNIT/UNIT NO.: SUBASSEMBLY: N2-SE-[illegible]
WELD NO. 2P-RC-[illegible]
PROCEDURE/REV/DEV700-10/4 WELD TYPE SE/BE EXAM TYPE [illegible]
DRL.BLK.NO. 2.312-SS-37-SAM
SERVICE DWG.NO./CONFIG.NO. D005226?

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VESSEL. SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
		SCAN	START	STOP
1	/ 2 DIV.			
2	/ 4 DIV.			
3	/ 6 DIV.	1-255	1 DIV.	7 DIV.

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT AWAY FM. VESSEL SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
		SCAN	START	STOP
1	/ 2 DIV.			
2	/ 4 DIV.			
3	/ 6 DIV.	1-255	1 DIV.	7 DIV.

****

MODULE PARAMETERS

X-OFFSET	0 DEG. INST.1	180 DEG. INST.2	NOT USED INST.3	NOT USED INST.4
X-OFFSET	0 IN.	180 DEG	NOT USED	NOT USED
Y-OFFSET	0 IN.	0 IN.	NOT USED	NOT USED

MODULE CONFIGURATION NO.49

SWRI PIPE SCAN DATA SHEET

1256 7 Dec 87

P. Gaines N/A

PARAMETERS

NOZZLE LOC.22 WELD LOC FROM VES CL118.54 PIPE T2.5
SCAN INC.(IN.) .36 CTS.142 NOZ.BORE DIA. 29 WELD POS. 90 DEG
X-FUNCTION SWRI ROTATOR Y-FUNCTION SCAN EXTENS

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	41	54.75	
2	RET	142	54.75	41	
3	EXT	284	41	54.75	
4	RET	426	54.75	41	
5	EXT	568	41	54.75	
6	RET	710	54.75	41	
7	EXT	852	41	54.75	
8	RET	994	54.75	41	
9	EXT	1136	41	54.75	
10	RET	1278	54.75	41	
11	EXT	1420	41	54.75	
12	RET	1562	54.75	41	
13	EXT	1704	41	54.75	
14	RET	1846	54.75	41	
15	EXT	1988	41	54.75	
16	RET	2130	54.75	41	
17	EXT	2272	41	54.75	
18	RET	2414	54.75	41	
19	EXT	2556	41	54.75	
20	RET	2698	54.75	41	
21	EXT	2840	41	54.75	
22	RET	2982	54.75	41	
23	EXT	3124	41	54.75	
24	RET	3266	54.75	41	
25	EXT	3408	41	54.75	
26	RET	3550	54.75	41	
27	EXT	3692	41	54.75	
28	RET	3834	54.75	41	
29	EXT	3976	41	54.75	
30	RET	4118	54.75	41	
31	EXT	4260	41	54.75	
32	RET	4402	54.75	41	
33	EXT	4544	41	54.75	
34	RET	4686	54.75	41	
35	EXT	4828	41	54.75	
36	RET	4970	54.75	41	
37	EXT	5112	41	54.75	
38	RET	5254	54.75	41	
39	EXT	5376	41	54.75	

P. Gaines N/A

1	RET	1233	54.75	41	
41	EXT	5630	41	54.75	
42	RET	5822	54.75	41	
43	EXT	5964	41	54.75	
44	RET	6106	54.75	41	
45	EXT	6248	41	54.75	
46	RET	6390	54.75	41	
47	EXT	6532	41	54.75	
48	RET	6674	54.75	41	
49	EXT	6816	41	54.75	
50	RET	6958	54.75	41	
51	EXT	7100	41	54.75	
52	RET	7242	54.75	41	
53	EXT	7384	41	54.75	
54	RET	7526	54.75	41	
55	EXT	7668	41	54.75	
56	RET	7810	54.75	41	
57	EXT	7952	41	54.75	
58	RET	8094	54.75	41	
59	EXT	8236	41	54.75	
60	RET	8378	54.75	41	
61	EXT	8520	41	54.75	
62	RET	8662	54.75	41	
63	EXT	8804	41	54.75	
64	RET	8946	54.75	41	
65	EXT	9088	41	54.75	
66	RET	9230	54.75	41	
67	EXT	9372	41	54.75	
68	RET	9514	54.75	41	
69	EXT	9656	41	54.75	
70	RET	9798	54.75	41	
71	EXT	9940	41	54.75	
72	RET	10082	54.75	41	
73	EXT	10224	41	54.75	
74	RET	10366	54.75	41	
75	EXT	10508	41	54.75	
76	RET	10650	54.75	41	
77	EXT	10792	41	54.75	
78	RET	10934	54.75	41	
79	EXT	11076	41	54.75	
80	RET	11218	54.75	41	
81	EXT	11360	41	54.75	
82	RET	11502	54.75	41	
83	EXT	11644	41	54.75	
84	RET	11786	54.75	41	
85	EXT	11928	41	54.75	
86	RET	12070	54.75	41	
87	EXT	12212	41	54.75	
88	RET	12354	54.75	41	
89	EXT	12496	41	54.75	

P. Grimes N/A

SEQ	DIR	X-POS	Y-START	Y-STOP	TEXT
90	RET	12638	54.75	41	
91	EXT	12780	41	54.75	
92	RET	12922	54.75	41	
93	EXT	13064	41	54.75	
94	RET	13206	54.75	41	
95	EXT	13348	41	54.75	
96	RET	13490	54.75	41	
97	EXT	13632	41	54.75	
98	RET	13774	54.75	41	
99	EXT	13916	41	54.75	
100	RET	14058	54.75	41	
101	EXT	14200	41	54.75	
102	RET	14342	54.75	41	
103	EXT	14484	41	54.75	
104	RET	14626	54.75	41	
105	EXT	14768	41	54.75	
106	RET	14910	54.75	41	
107	EXT	15052	41	54.75	
108	RET	15194	54.75	41	
109	EXT	15336	41	54.75	
110	RET	15478	54.75	41	
111	EXT	15620	41	54.75	
112	RET	15762	54.75	41	
113	EXT	15904	41	54.75	
114	RET	16046	54.75	41	
115	EXT	16188	41	54.75	
116	RET	16330	54.75	41	
117	EXT	16472	41	54.75	
118	RET	16614	54.75	41	
119	EXT	16756	41	54.75	
120	RET	16898	54.75	41	
121	EXT	17040	41	54.75	
122	RET	17182	54.75	41	
123	EXT	17324	41	54.75	
124	RET	17466	54.75	41	
125	EXT	17608	41	54.75	
126	RET	17750	54.75	41	
127	EXT	17892	41	54.75	
128	RET	18034	54.75	41	
129	EXT	18176	41	54.75	
130	RET	18318	54.75	41	
131	EXT	18460	41	54.75	
132	RET	18602	54.75	41	
133	EXT	18744	41	54.75	
134	RET	18886	54.75	41	
135	EXT	19028	41	54.75	
136	RET	19170	54.75	41	
137	EXT	19312	41	54.75	
138	RET	19454	54.75	41	
139	EXT	19596	41	54.75	

P. GAINES N/A

140	RET	19718	54.75	41
141	EXT	19860	41	54.75
142	RET	20002	54.75	41
143	EXT	20144	41	54.75
144	RET	20306	54.75	41
145	EXT	20448	41	54.75
146	RET	20590	54.75	41
147	EXT	20732	41	54.75
148	RET	20874	54.75	41
149	EXT	21016	41	54.75
150	RET	21158	54.75	41
151	EXT	21300	41	54.75
152	RET	21442	54.75	41
153	EXT	21584	41	54.75
154	RET	21726	54.75	41
155	EXT	21868	41	54.75
156	RET	22010	54.75	41
157	EXT	22152	41	54.75
158	RET	22294	54.75	41
159	EXT	22436	41	54.75
160	RET	22578	54.75	41
161	EXT	22720	41	54.75
162	RET	22862	54.75	41
163	EXT	23004	41	54.75
164	RET	23146	54.75	41
165	EXT	23288	41	54.75
166	RET	23430	54.75	41
167	EXT	23572	41	54.75
168	RET	23714	54.75	41
169	EXT	23856	41	54.75
170	RET	23998	54.75	41
171	EXT	24140	41	54.75
172	RET	24282	54.75	41
173	EXT	24424	41	54.75
174	RET	24566	54.75	41
175	EXT	24708	41	54.75
176	RET	24850	54.75	41
177	EXT	24992	41	54.75
178	RET	25134	54.75	41
179	EXT	25276	41	54.75
180	RET	25418	54.75	41
181	EXT	25560	41	54.75
182	RET	25702	54.75	41
183	EXT	25844	41	54.75
184	RET	25986	54.75	41
185	EXT	26128	41	54.75
186	RET	26270	54.75	41
187	EXT	26412	41	54.75
188	RET	26554	54.75	41
189	EXT	26696	41	54.75

(83)

P. GAINES : JALEJANDRO

SCAN	DIR	Y-POS	Y-START	Y-STOP	REMARKS
190	RET	26378	54.75	41	
191	EXT	26980	41	54.75	
192	RET	27122	54.75	41	
193	EXT	27264	41	54.75	
194	RET	27406	54.75	41	
195	EXT	27548	41	54.75	
196	RET	27690	54.75	41	
197	EXT	27832	41	54.75	
198	RET	27974	54.75	41	
199	EXT	28116	41	54.75	
200	RET	28258	54.75	41	
201	EXT	28400	41	54.75	
202	RET	28542	54.75	41	
203	EXT	28684	41	54.75	
204	RET	28826	54.75	41	
205	EXT	28968	41	54.75	
206	RET	29110	54.75	41	
207	EXT	29252	41	54.75	
208	RET	29394	54.75	41	
209	EXT	29536	41	54.75	
210	RET	29678	54.75	41	
211	EXT	29820	41	54.75	
212	RET	29962	54.75	41	
213	EXT	30104	41	54.75	
214	RET	30246	54.75	41	
215	EXT	30388	41	54.75	
216	RET	30530	54.75	41	
217	EXT	30672	41	54.75	
218	RET	30814	54.75	41	
219	EXT	30956	41	54.75	
220	RET	31098	54.75	41	
221	EXT	31240	41	54.75	
222	RET	31382	54.75	41	
223	EXT	31524	41	54.75	
224	RET	31666	54.75	41	
225	EXT	31808	41	54.75	
226	RET	31950	54.75	41	
227	EXT	32092	41	54.75	
228	RET	32234	54.75	41	
229	EXT	32376	41	54.75	
230	RET	32518	54.75	41	
231	EXT	32660	41	54.75	
232	RET	32802	54.75	41	
233	EXT	32944	41	54.75	
234	RET	33086	54.75	41	
235	EXT	33228	41	54.75	
236	RET	33370	54.75	41	
237	EXT	33512	41	54.75	
238	RET	33654	54.75	41	
239	EXT	33796	41	54.75	

[illegible] JALEJANDRO N/A

[illegible]	S.T.	[illegible]	X-START	Y-STOP	[illegible]
240	RET	33736	54.75	41	
241	EXT	34080	41	54.75	
242	RET	34222	54.75	41	
243	EXT	34364	41	54.75	
244	RET	34506	54.75	41	
245	EXT	34648	41	54.75	
246	RET	34790	54.75	41	
247	EXT	34932	41	54.75	
248	RET	35074	54.75	41	
249	EXT	35216	41	54.75	
250	RET	35358	54.75	41	
251	EXT	35500	41	54.75	
252	RET	35642	54.75	41	
253	EXT	35784	41	54.75	
254	RET	35926	54.75	41	
255	EXT	36068	41	54.75	

REVIEWED BY Carlos M Barrera LEVEL (II) DATE (07 Nov 87

EXAM.NO. 133

SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=133
4. WELD NO.=29-RC-1130-1&2
5. COMPONENT=RC
6. SUBASSEMBLY=NOZ-SE-PIPE
7. PROCEDURE/REV/DEV=700-1C/4
8. SCAN PATH SKETCH NO.=DSK3052719
9. CAL. BLK. NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052369

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=158
2. PIPE THICKNESS=2.5
3. WELD LOC FROM VES CL(IN)=118.56
4. Y-START POS.=41
5. Y-STOP POS.=54.75
6. NOZZLE BORE DIAMETER=29
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. X-START POS.=0
10. X-STOP POS.=36000

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 395.34

COUNTS PER DEGREE= 100

Completed 7 Nov 87 DSK

EXAM NO. 100

[redacted]

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG. INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.	TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VESSEL. SWEEP DISTANCE(IN.) 5	BEAM COMPONENT AWAY FM. VESSEL SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS			CAL.NODES/SWEEP DIST.	GATE SETTINGS		
	SCAN	START	STOP		SCAN	START	STOP
1 / 2 DIV.				1 / 2 DIV.			
2 / 4 DIV.				2 / 4 DIV.			
3 / 6 DIV.	1-255	1 DIV.	7 DIV.	3 / 6 DIV.	1-255	1 DIV.	7 DIV.

****

MODULE PARAMETERS

X-OFFSET	0 DEG. INST.1	180 DEG. INST.2	NOT USED INST.3	NOT USED INST.4
X-OFFSET	0 IN.	180 DEG	NOT USED	NOT USED
Y-OFFSET	0 IN.	0 IN.	NOT USED	NOT USED

MODULE CONFIGURATION NO.48

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1151 TIME 1100 17 NOV 87

ENTRY NO. ITT OPERATOR(S) P. GAINES / J. ALEJANDRO
WELD NO. 07-RC-113-102

PARAMETERS

NOZZLE LOC.158 WELD LOC FROM VES CL 113.56 PIPE T2.5
SCAN INC.(IN.) .36 OTS.142 NOZ.BORE DIA. 29 HOIST POS. 35.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	41	54.75	
2	RET	142	54.75	41	
3	EXT	284	41	54.75	
4	RET	426	54.75	41	
5	EXT	568	41	54.75	
6	RET	710	54.75	41	
7	EXT	852	41	54.75	
8	RET	994	54.75	41	
9	EXT	1136	41	54.75	
10	RET	1278	54.75	41	
11	EXT	1420	41	54.75	
12	RET	1562	54.75	41	
13	EXT	1704	41	54.75	
14	RET	1846	54.75	41	
15	EXT	1988	41	54.75	
16	RET	2130	54.75	41	
17	EXT	2272	41	54.75	
18	RET	2414	54.75	41	
19	EXT	2556	41	54.75	
20	RET	2698	54.75	41	
21	EXT	2840	41	54.75	
22	RET	2982	54.75	41	
23	EXT	3124	41	54.75	
24	RET	3266	54.75	41	
25	EXT	3408	41	54.75	
26	RET	3550	54.75	41	
27	EXT	3692	41	54.75	
28	RET	3834	54.75	41	
29	EXT	3976	41	54.75	
30	RET	4118	54.75	41	
31	EXT	4260	41	54.75	
32	RET	4402	54.75	41	
33	EXT	4544	41	54.75	
34	RET	4686	54.75	41	
35	EXT	4828	41	54.75	
36	RET	4970	54.75	41	
37	EXT	5112	41	54.75	
38	RET	5254	54.75	41	
39	EXT	5396	41	54.75	

ALEJANDRO n/a

1	RET	3222	54.75	41	
2	EXT	3430	41	54.75	
3	RET	3822	54.75	41	
4	EXT	5964	41	54.75	
5	RET	6106	54.75	41	
6	EXT	6248	41	54.75	
7	RET	6390	54.75	41	
8	EXT	6532	41	54.75	
9	RET	6674	54.75	41	
10	EXT	6816	41	54.75	
11	RET	6958	54.75	41	
12	EXT	7100	41	54.75	
13	RET	7242	54.75	41	
14	EXT	7384	41	54.75	
15	RET	7526	54.75	41	
16	EXT	7668	41	54.75	
17	RET	7810	54.75	41	
18	EXT	7952	41	54.75	
19	RET	8094	54.75	41	
20	EXT	8236	41	54.75	
21	RET	8378	54.75	41	
22	EXT	8520	41	54.75	
23	RET	8662	54.75	41	
24	EXT	8804	41	54.75	
25	RET	8946	54.75	41	
26	EXT	9088	41	54.75	
27	RET	9230	54.75	41	
28	EXT	9372	41	54.75	
29	RET	9514	54.75	41	
30	EXT	9656	41	54.75	
31	RET	9798	54.75	41	
32	EXT	9940	41	54.75	
33	RET	10082	54.75	41	
34	EXT	10224	41	54.75	
35	RET	10366	54.75	41	
36	EXT	10508	41	54.75	
37	RET	10650	54.75	41	
38	EXT	10792	41	54.75	
39	RET	10934	54.75	41	
40	EXT	11076	41	54.75	
41	RET	11218	54.75	41	
42	EXT	11360	41	54.75	
43	RET	11502	54.75	41	
44	EXT	11644	41	54.75	
45	RET	11786	54.75	41	
46	EXT	11928	41	54.75	
47	RET	12070	54.75	41	
48	EXT	12212	41	54.75	
49	RET	12354	54.75	41	
50	EXT	12496	41	54.75	

JAIGJANDRO NIA

SCN.	DIA	X-PCE	Y-START	Y-STOP	REMARKS
90	RET	12638.	54.75	41	
91	EXT	12780.	41	54.75	
92	RET	12922.	54.75	41	
93	EXT	13064.	41	54.75	
94	RET	13206.	54.75	41	
95	EXT	13348.	41	54.75	
96	RET	13490.	54.75	41	
97	EXT	13632.	41	54.75	
98	RET	13774.	54.75	41	
99	EXT	13916.	41	54.75	
100	RET	14058.	54.75	41	
101	EXT	14200.	41	54.75	
102	RET	14342.	54.75	41	
103	EXT	14484.	41	54.75	
104	RET	14626.	54.75	41	
105	EXT	14768.	41	54.75	
106	RET	14910.	54.75	41	
107	EXT	15052.	41	54.75	
108	RET	15194.	54.75	41	
109	EXT	15336.	41	54.75	
110	RET	15478.	54.75	41	
111	EXT	15620.	41	54.75	
112	RET	15762.	54.75	41	
113	EXT	15904.	41	54.75	
114	RET	16046.	54.75	41	
115	EXT	16188.	41	54.75	
116	RET	16330.	54.75	41	
117	EXT	16472.	41	54.75	
118	RET	16614.	54.75	41	
119	EXT	16756.	41	54.75	
120	RET	16898.	54.75	41	
121	EXT	17040.	41	54.75	
122	RET	17182.	54.75	41	
123	EXT	17324.	41	54.75	
124	RET	17466.	54.75	41	
125	EXT	17608.	41	54.75	
126	RET	17750.	54.75	41	
127	EXT	17892.	41	54.75	
128	RET	18034.	54.75	41	
129	EXT	18176.	41	54.75	
130	RET	18318.	54.75	41	
131	EXT	18460.	41	54.75	
132	RET	18602.	54.75	41	
133	EXT	18744.	41	54.75	
134	RET	18886.	54.75	41	
135	EXT	19028.	41	54.75	
136	RET	19170.	54.75	41	
137	EXT	19312.	41	54.75	
138	RET	19454.	54.75	41	
139	EXT	19596.	41	54.75	

OPERATOR: JALLJAVARO N/A

SCAN	DIR	X-FEET	Y-START	Y-STOP	REMARKS
140	RET	19722.	54.75	41	
141	EXT	19880.	41	54.75	
142	RET	20022.	54.75	41	
143	EXT	20164.	41	54.75	
144	RET	20306.	54.75	41	
145	EXT	20448.	41	54.75	
146	RET	20590.	54.75	41	
147	EXT	20732.	41	54.75	
148	RET	20874.	54.75	41	
149	EXT	21016.	41	54.75	
150	RET	21158.	54.75	41	
151	EXT	21300.	41	54.75	
152	RET	21442.	54.75	41	
153	EXT	21584.	41	54.75	
154	RET	21726.	54.75	41	
155	EXT	21868.	41	54.75	
156	RET	22010.	54.75	41	
157	EXT	22152.	41	54.75	
158	RET	22294.	54.75	41	
159	EXT	22436.	41	54.75	
160	RET	22578.	54.75	41	
161	EXT	22720.	41	54.75	
162	RET	22862.	54.75	41	
163	EXT	23004.	41	54.75	
164	RET	23146.	54.75	41	
165	EXT	23288.	41	54.75	
166	RET	23430.	54.75	41	
167	EXT	23572.	41	54.75	
168	RET	23714.	54.75	41	
169	EXT	23856.	41	54.75	
170	RET	23998.	54.75	41	
171	EXT	24140.	41	54.75	
172	RET	24282.	54.75	41	
173	EXT	24424.	41	54.75	
174	RET	24566.	54.75	41	
175	EXT	24708.	41	54.75	
176	RET	24850.	54.75	41	
177	EXT	24992.	41	54.75	
178	RET	25134.	54.75	41	
179	EXT	25276.	41	54.75	
180	RET	25418.	54.75	41	
181	EXT	25560.	41	54.75	
182	RET	25702.	54.75	41	
183	EXT	25844.	41	54.75	
184	RET	25986.	54.75	41	
185	EXT	26128.	41	54.75	
186	RET	26270.	54.75	41	
187	EXT	26412.	41	54.75	
188	RET	26554.	54.75	41	
189	EXT	26696.	41	54.75	

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JALEJANDRO N/A

BEAM	EXT	X-POS	Y-SETUP	Z-SETUP	REMARKS
191	RET	25930.	54.75	41	
192	EXT	26930.	41	54.75	
192	RET	27122.	54.75	41	
193	EXT	27264.	41	54.75	
194	RET	27406.	54.75	41	
195	EXT	27548.	41	54.75	
196	RET	27690.	54.75	41	
197	EXT	27832.	41	54.75	
198	RET	27974.	54.75	41	
199	EXT	28116.	41	54.75	
200	RET	28258.	54.75	41	
201	EXT	28400.	41	54.75	
202	RET	28542.	54.75	41	
203	EXT	28684.	41	54.75	
204	RET	28826.	54.75	41	
205	EXT	28968.	41	54.75	
206	RET	29110.	54.75	41	
207	EXT	29252.	41	54.75	
208	RET	29394.	54.75	41	
209	EXT	29536.	41	54.75	
210	RET	29678.	54.75	41	
211	EXT	29820.	41	54.75	
212	RET	29962.	54.75	41	
213	EXT	30104.	41	54.75	
214	RET	30246.	54.75	41	
215	EXT	30388.	41	54.75	
216	RET	30530.	54.75	41	
217	EXT	30672.	41	54.75	
218	RET	30814.	54.75	41	
219	EXT	30956.	41	54.75	
220	RET	31098.	54.75	41	
221	EXT	31240.	41	54.75	
222	RET	31382.	54.75	41	
223	EXT	31524.	41	54.75	
224	RET	31666.	54.75	41	
225	EXT	31808.	41	54.75	
226	RET	31950.	54.75	41	
227	EXT	32092.	41	54.75	
228	RET	32234.	54.75	41	
229	EXT	32376.	41	54.75	
230	RET	32518.	54.75	41	
231	EXT	32660.	41	54.75	
232	RET	32802.	54.75	41	
233	EXT	32944.	41	54.75	
234	RET	33086.	54.75	41	
235	EXT	33228.	41	54.75	
236	RET	33370.	54.75	41	
237	EXT	33512.	41	54.75	
238	RET	33654.	54.75	41	
239	EXT	33796.	41	54.75	

SPECIAL: HANDED N/A

SEAM	DIR	X-FEED	Y-START	Y-STOP	TEMPS
240	RET	33938.	54.75	41	
241	EXT	34000.	41	54.75	
242	RET	34222.	54.75	41	
243	EXT	34364.	41	54.75	
244	RET	34506.	54.75	41	
245	EXT	34648.	41	54.75	
246	RET	34790.	54.75	41	
247	EXT	34932.	41	54.75	
248	RET	35074.	54.75	41	
249	EXT	35216.	41	54.75	
250	RET	35358.	54.75	41	
251	EXT	35500.	41	54.75	
252	RET	35642.	54.75	41	
253	EXT	35784.	41	54.75	
254	RET	35926.	54.75	41	
255	EXT	36068.	41	54.75	

REVIEWED BY Carlos M Barrera (LEVEL(II) DATE(07 Nov 87)

EXAM.NO. 134

BATTELLE SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=134
4. WELD NO.=29-RC-1110-1&2
5. COMPONENT=RC
6. SUBASSEMBLY=NOZ-SE-PIPE
7. PROCEDURE/REV/DEV=700-10/0
8. SCAN PATH SKETCH NO.=08K3052739
9. CAL.BLK.NO.=2.312-SS-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=03052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=202
2. PIPE THICKNESS=2.5
3. WELD LOC FROM VES CL(IN)=118.56
4. Y-START POS.=41
5. Y-STOP POS.=54.75
6. NOZZLE BORE DIAMETER=29
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. X-START POS.=0
10. X-STOP POS.=36000

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 395.34

COUNTS PER DEGREE= 100

Completed 7/20/87 BSK

052700

EXAM NO. 174

[illegible]

[illegible]
COMPONENT ID: SUBASSEMBLY NOZZLE-PIPE
WELD NO. LP-N2-1111-1&2
PROCEDURE ID/REV.700-10/4 WELD TYPE VEE/SE [illegible]
CAL.BLK.NO. 2.312-SC-37-SAM
DEVICE DWG.NO./CONFIG.NO. D3032269

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG. INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VESSEL. SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-255	1 DIV.	7 DIV.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT AWAY FM. VESSEL SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-255	1 DIV.	7 DIV.

MODULE PARAMETERS

X-OFFSET	0 DEG. INST.1	180 DEG. INST.2	NOT USED INST.3	NOT USED INST.4
X-OFFSET	0 IN.	180 DEG	NOT USED	NOT USED
Y-OFFSET	0 IN.	0 IN.	NOT USED	NOT USED

MODULE CONFIGURATION NO.48

SWRI IPAR SCAN SHEET

SITE/FILE: 1 PROJECT NO. 17-1202 FILE: 0919 DATE: 7 NOV 87

SEAL NO. 151 OPERATOR: JALEJANDRO N/A
WELD NO. 27 PS-1110-112

PARAMETERS

NOZZLE LOC.202 WELD LOC FROM VES CL110.56 PIPE TO E
SCAN INC.(IN.) .36 CTS.142 NOZ.BORE DIA. 29 HOIST POS. 96.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTENS

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0	41	54.75	
2	RET	142	54.75	41	
3	EXT	284	41	54.75	
4	RET	426	54.75	41	
5	EXT	568	41	54.75	
6	RET	710	54.75	41	
7	EXT	852	41	54.75	
8	RET	994	54.75	41	
9	EXT	1136	41	54.75	
10	RET	1278	54.75	41	
11	EXT	1420	41	54.75	
12	RET	1562	54.75	41	
13	EXT	1704	41	54.75	
14	RET	1846	54.75	41	
15	EXT	1988	41	54.75	
16	RET	2130	54.75	41	
17	EXT	2272	41	54.75	
18	RET	2414	54.75	41	
19	EXT	2556	41	54.75	
20	RET	2698	54.75	41	
21	EXT	2840	41	54.75	
22	RET	2982	54.75	41	
23	EXT	3124	41	54.75	
24	RET	3266	54.75	41	
25	EXT	3408	41	54.75	
26	RET	3550	54.75	41	
27	EXT	3692	41	54.75	
28	RET	3834	54.75	41	
29	EXT	3976	41	54.75	
30	RET	4118	54.75	41	
31	EXT	4260	41	54.75	
32	RET	4402	54.75	41	
33	EXT	4544	41	54.75	
34	RET	4686	54.75	41	
35	EXT	4828	41	54.75	
36	RET	4970	54.75	41	
37	EXT	5112	41	54.75	
38	RET	5254	54.75	41	
39	EXT	5396	41	54.75	

ALEJANDRO N17

ITEM	TYP	FEET	INSTANT	Y-STOP	REMARKS
41	EXT	5280 -	41	54.75	
42	RET	5822 -	54.75	41	
43	EXT	5964 -	41	54.75	
44	RET	6106 -	54.75	41	
45	EXT	6248 -	41	54.75	
46	RET	6390 -	54.75	41	
47	EXT	6532 -	41	54.75	
48	RET	6674 -	54.75	41	
49	EXT	6816 -	41	54.75	
50	RET	6958 -	54.75	41	
51	EXT	7100 -	41	54.75	
52	RET	7242 -	54.75	41	
53	EXT	7384 -	41	54.75	
54	RET	7526 -	54.75	41	
55	EXT	7668 -	41	54.75	
56	RET	7810 -	54.75	41	
57	EXT	7952 -	41	54.75	
58	RET	8094 -	54.75	41	
59	EXT	8236 -	41	54.75	
60	RET	8378 -	54.75	41	
61	EXT	8520 -	41	54.75	
62	RET	8662 -	54.75	41	
63	EXT	8804 -	41	54.75	
64	RET	8946 -	54.75	41	
65	EXT	9088 -	41	54.75	
66	RET	9230 -	54.75	41	
67	EXT	9372 -	41	54.75	
68	RET	9514 -	54.75	41	
69	EXT	9656 -	41	54.75	
70	RET	9798 -	54.75	41	
71	EXT	9940 -	41	54.75	
72	RET	10082 -	54.75	41	
73	EXT	10224 -	41	54.75	
74	RET	10366 -	54.75	41	
75	EXT	10508 -	41	54.75	
76	RET	10650 -	54.75	41	
77	EXT	10792 -	41	54.75	
78	RET	10934 -	54.75	41	
79	EXT	11076 -	41	54.75	
80	RET	11218 -	54.75	41	
81	EXT	11360 -	41	54.75	
82	RET	11502 -	54.75	41	
83	EXT	11644 -	41	54.75	
84	RET	11786 -	54.75	41	
85	EXT	11928 -	41	54.75	
86	RET	12070 -	54.75	41	
87	EXT	12212 -	41	54.75	
88	RET	12354 -	54.75	41	
89	EXT	12496 -	41	54.75	

DESCRIPTION: JALETANDEO N/A

SCAN	DIR	Y-TOP	Y-START	Y-STOP	REMARKS
91	RET	12638	54.75	41	
92	EXT	12780	41	54.75	
93	RET	12922	54.75	41	
94	EXT	13064	41	54.75	
95	RET	13206	54.75	41	
96	EXT	13348	41	54.75	
97	RET	13490	54.75	41	
98	EXT	13632	41	54.75	
99	RET	13774	54.75	41	
100	EXT	13916	41	54.75	
101	RET	14058	54.75	41	
102	EXT	14200	41	54.75	
103	RET	14342	54.75	41	
104	EXT	14484	41	54.75	
105	RET	14626	54.75	41	
106	EXT	14768	41	54.75	
107	RET	14910	54.75	41	
108	EXT	15052	41	54.75	
109	RET	15194	54.75	41	
110	EXT	15336	41	54.75	
111	RET	15478	54.75	41	
112	EXT	15620	41	54.75	
113	RET	15762	54.75	41	
114	EXT	15904	41	54.75	
115	RET	16046	54.75	41	
116	EXT	16188	41	54.75	
117	RET	16330	54.75	41	
118	EXT	16472	41	54.75	
119	RET	16614	54.75	41	
120	EXT	16756	41	54.75	
121	RET	16898	54.75	41	
122	EXT	17040	41	54.75	
123	RET	17182	54.75	41	
124	EXT	17324	41	54.75	
125	RET	17466	54.75	41	
126	EXT	17608	41	54.75	
127	RET	17750	54.75	41	
128	EXT	17892	41	54.75	
129	RET	18034	54.75	41	
130	EXT	18176	41	54.75	
131	RET	18318	54.75	41	
132	EXT	18460	41	54.75	
133	RET	18602	54.75	41	
134	EXT	18744	41	54.75	
135	RET	18886	54.75	41	
136	EXT	19028	41	54.75	
137	RET	19170	54.75	41	
138	EXT	19312	41	54.75	
139	RET	19454	54.75	41	
140	EXT	19596	41	54.75	

B

OPERATOR: P. Gaines N/A

BOX	DIR	FROM	TO/TAG	ETC	REMARKS
[illegible]	RET	[illegible]	54.75	41	
141	EXT	19880	41	54.75	
142	RET	20022	54.75	41	
143	EXT	20164	41	54.75	
144	RET	20306	54.75	41	
145	EXT	20448	41	54.75	
146	RET	20590	54.75	41	
147	EXT	20732	41	54.75	
148	RET	20874	54.75	41	
149	EXT	21016	41	54.75	
150	RET	21158	54.75	41	
151	EXT	21300	41	54.75	
152	RET	21442	54.75	41	
153	EXT	21584	41	54.75	
154	RET	21726	54.75	41	
155	EXT	21868	41	54.75	
156	RET	22010	54.75	41	
157	EXT	22152	41	54.75	
158	RET	22294	54.75	41	
159	EXT	22436	41	54.75	
160	RET	22578	54.75	41	
161	EXT	22720	41	54.75	
162	RET	22862	54.75	41	
163	EXT	23004	41	54.75	
164	RET	23146	54.75	41	
165	EXT	23288	41	54.75	
166	RET	23430	54.75	41	
167	EXT	23572	41	54.75	
168	RET	23714	54.75	41	
169	EXT	23856	41	54.75	
170	RET	23998	54.75	41	
171	EXT	24140	41	54.75	
172	RET	24282	54.75	41	
173	EXT	24424	41	54.75	
174	RET	24566	54.75	41	
175	EXT	24708	41	54.75	
176	RET	24850	54.75	41	
177	EXT	24992	41	54.75	
178	RET	25134	54.75	41	
179	EXT	25276	41	54.75	
180	RET	25418	54.75	41	
181	EXT	25560	41	54.75	
182	RET	25702	54.75	41	
183	EXT	25844	41	54.75	
184	RET	25986	54.75	41	
185	EXT	26128	41	54.75	
186	RET	26270	54.75	41	
187	EXT	26412	41	54.75	
188	RET	26554	54.75	41	
189	EXT	26696	41	54.75	

OPERATOR: P GAINES N/A

SCAN	DIR	X-BASE	Y-START	Y-STOP	TEMP
191	RET	26838	54.75	41	
191	EXT	26980	41	54.75	
192	RET	27122	54.75	41	
193	EXT	27264	41	54.75	
194	RET	27406	54.75	41	
195	EXT	27548	41	54.75	
196	RET	27690	54.75	41	
197	EXT	27832	41	54.75	
198	RET	27974	54.75	41	
199	EXT	28116	41	54.75	
200	RET	28258	54.75	41	
201	EXT	28400	41	54.75	
202	RET	28542	54.75	41	
203	EXT	28684	41	54.75	
204	RET	28826	54.75	41	
205	EXT	28968	41	54.75	
206	RET	29110	54.75	41	
207	EXT	29252	41	54.75	
208	RET	29394	54.75	41	
209	EXT	29536	41	54.75	
210	RET	29678	54.75	41	
211	EXT	29820	41	54.75	
212	RET	29962	54.75	41	
213	EXT	30104	41	54.75	
214	RET	30246	54.75	41	
215	EXT	30388	41	54.75	
216	RET	30530	54.75	41	
217	EXT	30672	41	54.75	
218	RET	30814	54.75	41	
219	EXT	30956	41	54.75	
220	RET	31098	54.75	41	
221	EXT	31240	41	54.75	
222	RET	31382	54.75	41	
223	EXT	31524	41	54.75	
224	RET	31666	54.75	41	
225	EXT	31808	41	54.75	
226	RET	31950	54.75	41	
227	EXT	32092	41	54.75	
228	RET	32234	54.75	41	
229	EXT	32376	41	54.75	
230	RET	32518	54.75	41	
231	EXT	32660	41	54.75	
232	RET	32802	54.75	41	
233	EXT	32944	41	54.75	
234	RET	33086	54.75	41	
235	EXT	33228	41	54.75	
236	RET	33370	54.75	41	
237	EXT	33512	41	54.75	
238	RET	33654	54.75	41	
239	EXT	33796	41	54.75	

O. GAINES N/A

[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
240	RET	33738	54.75	41
241	EXT	34080	41	54.75
242	RET	34222	54.75	41
243	EXT	34364	41	54.75
244	RET	34506	54.75	41
245	EXT	34648	41	54.75
246	RET	34790	54.75	41
247	EXT	34932	41	54.75
248	RET	35074	54.75	41
249	EXT	35216	41	54.75
250	RET	35358	54.75	41
251	EXT	35500	41	54.75
252	RET	35642	54.75	41
253	EXT	35784	41	54.75
254	RET	35926	54.75	41
255	EXT	36068	41	54.75

Scans 1-200 REVIEWED BY(Heather Aliz (PD)) (LEVEL(III) DATE(7 Nov 87

201-255 Carlos M Barrera II 07 Nov 87

EXAM.NO. 135

SCAN PLAN PARAMETER SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=135
4.WELD NO.=29-RC-1120-1&2
5.COMPONENT=RC
6.SUBASSEMBLY=NOZ-SE-PIPE
7.PROCEDURE/REV/DEV=700-10/4
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1.NOZZLE AZIMUTH=338
2.PIPE THICKNESS=2.5
3.WELD LOC FROM VES CL(IN)=118.56
4.Y-START POS.=41
5.Y-STOP POS.=54.75
6.NOZZLE BORE DIAMETER=29
7.Y-OFFSET (PIV.TO REV C.L.)=77
8.HOIST POSITION=85.62
9.X-START POS.=0
10.X-STOP POS.=36000

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 395.34
COUNTS PER DEGREE= 100

Completed 7 Nov 97 SAK

out

EXAM NO. 132

[redacted]

CAL.BLK.NO. 2.312-88-07-GAM
DEVICE DWG.NO./CONFIG.NO. D3052267

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VESSEL. SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-255	1 DIV.	8 DIV.

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT AWAY FM. VESSEL SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-255	1 DIV.	8 DIV.

MODULE PARAMETERS

X-OFFSET	0 DEG. INST.1	180 DEG. INST.2	NOT USED INST.3	NOT USED INST.4
Y-OFFSET	0 IN.	180 DEG	NOT USED	NOT USED
Y-OFFSET	0 IN.	0 IN.	NOT USED	NOT USED

MODULE CONFIGURATION NO.48

[illegible] SCAN PLAN SHEET

[illegible] 0651 [illegible] 7 NOV 87

[illegible] OPERATOR(S): L.R. MATHENA N/F
[illegible]

PARAMETERS

MOBILE LOC.3IB WELD LOC FROM VES CL1:8.54 PIPE TH.C
SCAN INC.(IN.) .36 OTB.142 NOZ.BORE DIA. 37 HOIST POS. [illegible]
X-FUNCTION SWRI ROTATOR Y-FUNCTION [illegible]

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
1	EXT	0 ✓	41	54.75	
2	RET	142 ✓	54.75	41	
3	EXT	284 ✓	41	54.75	
4	RET	426 ✓	54.75	41	
5	EXT	568 ✓	41	54.75	
6	RET	710 ✓	54.75	41	
7	EXT	852 ✓	41	54.75	
8	RET	994 ✓	54.75	41	
9	EXT	1136 ✓	41	54.75	
10	RET	1278 ✓	54.75	41	
11	EXT	1420 ✓	41	54.75	
12	RET	1562 ✓	54.75	41	
13	EXT	1704 ✓	41	54.75	
14	RET	1846 ✓	54.75	41	
15	EXT	1988 ✓	41	54.75	
16	RET	2130 ✓	54.75	41	
17	EXT	2272 ✓	41	54.75	
18	RET	2414 ✓	54.75	41	
19	EXT	2556 ✓	41	54.75	
20	RET	2698 ✓	54.75	41	
21	EXT	2840 ✓	41	54.75	
22	RET	2982 ✓	54.75	41	
23	EXT	3124 ✓	41	54.75	
24	RET	3266 ✓	54.75	41	
25	EXT	3408 ✓	41	54.75	
26	RET	3550 ✓	54.75	41	
27	EXT	3692 ✓	41	54.75	
28	RET	3834 ✓	54.75	41	
29	EXT	3976 ✓	41	54.75	
30	RET	4118 ✓	54.75	41	
31	EXT	4260 ✓	41	54.75	
32	RET	4402 ✓	54.75	41	
33	EXT	4544 ✓	41	54.75	
34	RET	4686 ✓	54.75	41	
35	EXT	4828 ✓	41	54.75	
36	RET	4970 ✓	54.75	41	
37	EXT	5112 ✓	41	54.75	
38	RET	5254 ✓	54.75	41	
39	EXT	5396 ✓	41	54.75	

tw

L.R. MATHENA N/P

1	RET	2228 ✓	54.75	41
2	EXT	3682 ✓	41	54.75
3	RET	5522 ✓	54.75	41
4	EXT	5764 ✓	41	54.75
5	RET	6136 ✓	54.75	41
6	EXT	6248 ✓	41	54.75
7	RET	6390 ✓	54.75	41
8	EXT	6532 ✓	41	54.75
9	RET	6674 ✓	54.75	41
10	EXT	6816 ✓	41	54.75
11	RET	6958 ✓	54.75	41
12	EXT	7100 ✓	41	54.75
13	RET	7242 ✓	54.75	41
14	EXT	7384 ✓	41	54.75
15	RET	7526 ✓	54.75	41
16	EXT	7668 ✓	41	54.75
17	RET	7810 ✓	54.75	41
18	EXT	7952 ✓	41	54.75
19	RET	8094 ✓	54.75	41
20	EXT	8236 ✓	41	54.75
21	RET	8378 ✓	54.75	41
22	EXT	8520 ✓	41	54.75
23	RET	8662 ✓	54.75	41
24	EXT	8804 ✓	41	54.75
25	RET	8946 ✓	54.75	41
26	EXT	9088 ✓	41	54.75
27	RET	9230 ✓	54.75	41
28	EXT	9372 ✓	41	54.75
29	RET	9514 ✓	54.75	41
30	EXT	9656 ✓	41	54.75
31	RET	9798 ✓	54.75	41
32	EXT	9940 ✓	41	54.75
33	RET	10082 ✓	54.75	41
34	EXT	10224 ✓	41	54.75
35	RET	10366 ✓	54.75	41
36	EXT	10508 ✓	41	54.75
37	RET	10650 ✓	54.75	41
38	EXT	10792 ✓	41	54.75
39	RET	10934 ✓	54.75	41
40	EXT	11076 ✓	41	54.75
41	RET	11218 ✓	54.75	41
42	EXT	11360 ✓	41	54.75
43	RET	11502 ✓	54.75	41
44	EXT	11644 ✓	41	54.75
45	RET	11786 ✓	54.75	41
46	EXT	11928 ✓	41	54.75
47	RET	12070 ✓	54.75	41
48	EXT	12212 ✓	41	54.75
49	RET	12354 ✓	54.75	41
50	EXT	12496 ✓	41	54.75

CREATED BY: LR/MATHEWS/ALEJANDRO

SCAN	SET	X-POS	Y-START	Y-STOP	POINT
77	RET	12638	54.75	41	
91	EXT	12780	41	54.75	
92	RET	12922	54.75	41	
93	EXT	13064	41	54.75	
94	RET	13206	54.75	41	
95	EXT	13348	41	54.75	
96	RET	13490	54.75	41	
97	EXT	13632	41	54.75	
98	RET	13774	54.75	41	
99	EXT	13916	41	54.75	
100	RET	14058	54.75	41	
101	EXT	14200	41	54.75	
102	RET	14342	54.75	41	
103	EXT	14484	41	54.75	
104	RET	14626	54.75	41	
105	EXT	14768	41	54.75	
106	RET	14910	54.75	41	
107	EXT	15052	41	54.75	
108	RET	15194	54.75	41	
109	EXT	15336	41	54.75	
110	RET	15478	54.75	41	
111	EXT	15620	41	54.75	
112	RET	15762	54.75	41	
113	EXT	15904	41	54.75	
114	RET	16046	54.75	41	
115	EXT	16188	41	54.75	
116	RET	16330	54.75	41	
117	EXT	16472	41	54.75	
118	RET	16614	54.75	41	
119	EXT	16756	41	54.75	
120	RET	16898	54.75	41	
121	EXT	17040	41	54.75	
122	RET	17182	54.75	41	
123	EXT	17324	41	54.75	
124	RET	17466	54.75	41	
125	EXT	17608	41	54.75	
126	RET	17750	54.75	41	
127	EXT	17892	41	54.75	
128	RET	18034	54.75	41	
129	EXT	18176	41	54.75	
130	RET	18318	54.75	41	
131	EXT	18460	41	54.75	
132	RET	18602	54.75	41	
133	EXT	18744	41	54.75	
134	RET	18886	54.75	41	
135	EXT	19028	41	54.75	
136	RET	19170	54.75	41	
137	EXT	19312	41	54.75	
138	RET	19454	54.75	41	
139	EXT	19596	41	54.75	

JALEJANDRO N/A

[illegible]	RET	17712-	54.75	41	
141	EXT	17854-	41	54.75	
142	RET	17996-	54.75	41	
143	EXT	18138-	41	54.75	
[illegible]	RET	18280-	54.75	41	
145	EXT	18422-	41	54.75	
146	RET	18564-	54.75	41	
147	EXT	18706-	41	54.75	
148	RET	18848-	54.75	41	
149	EXT	18990-	41	54.75	
150	RET	19132-	54.75	41	
151	EXT	19274-	41	54.75	
152	RET	19416-	54.75	41	
153	EXT	19558-	41	54.75	
154	RET	19700-	54.75	41	
155	EXT	19842-	41	54.75	
156	RET	19984-	54.75	41	
157	EXT	20126-	41	54.75	
158	RET	20268-	54.75	41	
159	EXT	20410-	41	54.75	
160	RET	20552-	54.75	41	
161	EXT	20694-	41	54.75	
162	RET	20836-	54.75	41	
163	EXT	20978-	41	54.75	
164	RET	21120-	54.75	41	
165	EXT	21262-	41	54.75	
166	RET	21404-	54.75	41	
167	EXT	21546-	41	54.75	
168	RET	21688-	54.75	41	
169	EXT	21830-	41	54.75	
170	RET	21972-	54.75	41	
171	EXT	22114-	41	54.75	
172	RET	22256-	54.75	41	
173	EXT	22398-	41	54.75	
174	RET	22540-	54.75	41	
175	EXT	22682-	41	54.75	
176	RET	22824-	54.75	41	
177	EXT	22966-	41	54.75	
178	RET	23108-	54.75	41	
179	EXT	23250-	41	54.75	
180	RET	23392-	54.75	41	
181	EXT	23534-	41	54.75	
182	RET	23676-	54.75	41	
183	EXT	23818-	41	54.75	
184	RET	23960-	54.75	41	
185	EXT	24102-	41	54.75	
186	RET	24244-	54.75	41	
187	EXT	24386-	41	54.75	
188	RET	24528-	54.75	41	
189	EXT	24670-	41	54.75	

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JAILHOUSE ~ 1A

191	RET	26850	54.75	41	
191	EXT	26980	41	54.75	
192	RET	27122	54.75	41	
193	EXT	27264	41	54.75	
194	RET	27406	54.75	41	
195	EXT	27548	41	54.75	
196	RET	27690	54.75	41	
197	EXT	27832	41	54.75	
198	RET	27974	54.75	41	
199	EXT	28116	41	54.75	
200	RET	28258	54.75	41	
201	EXT	28400	41	54.75	
202	RET	28542	54.75	41	
203	EXT	28684	41	54.75	
204	RET	28826	54.75	41	
205	EXT	28968	41	54.75	
206	RET	29110	54.75	41	
207	EXT	29252	41	54.75	
208	RET	29394	54.75	41	
209	EXT	29536	41	54.75	
210	RET	29678	54.75	41	
211	EXT	29820	41	54.75	
212	RET	29962	54.75	41	
213	EXT	30104	41	54.75	
214	RET	30246	54.75	41	
215	EXT	30388	41	54.75	
216	RET	30530	54.75	41	
217	EXT	30672	41	54.75	
218	RET	30814	54.75	41	
219	EXT	30956	41	54.75	
220	RET	31098	54.75	41	
221	EXT	31240	41	54.75	
222	RET	31382	54.75	41	
223	EXT	31524	41	54.75	
224	RET	31666	54.75	41	
225	EXT	31808	41	54.75	
226	RET	31950	54.75	41	
227	EXT	32092	41	54.75	
228	RET	32234	54.75	41	
229	EXT	32376	41	54.75	
230	RET	32518	54.75	41	
231	EXT	32660	41	54.75	
232	RET	32802	54.75	41	
233	EXT	32944	41	54.75	
234	RET	33086	54.75	41	
235	EXT	33228	41	54.75	
236	RET	33370	54.75	41	
237	EXT	33512	41	54.75	
238	RET	33654	54.75	41	
239	EXT	33796	41	54.75	

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[illegible] JALGANDRO N/A

[illegible]	[illegible]	[illegible]	[illegible]	[illegible]	[illegible]
[illegible]	RET	[illegible]	34.75	41	
241	EXT	34080-	41	54.75	
242	RET	34222	54.75	41	
243	EXT	34364-	41	54.75	
244	RET	34516-	54.75	41	
245	EXT	34648-	41	54.75	
246	RET	34790-	54.75	41	
247	EXT	34932-	41	54.75	
248	RET	35074-	54.75	41	
249	EXT	35216-	41	54.75	
250	RET	35358-	54.75	41	
251	EXT	35500-	41	54.75	
252	RET	35642-	54.75	41	
253	EXT	35784-	41	54.75	
254	RET	35926-	54.75	41	
255	EXT	36068-	41	54.75	

REVIEWED BY(Hector Diaz) (LEVEL(III) DATE(7 NOV 87)

EXAM.NO. 136

UNIT 1 SCAN PLAN PARAMETER SHEET 1

SITE NAME SALEM 1 PROJECT NO. 17-1352

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1352
3.EXAM NO.=136
4.WELD NO.=29-RC-1140-1&2
5.COMPONENT=RC
6.SUBASSEMBLY=NOZ-SE-PIPE
7.PROCEDURE/REV/DEV=70C-10/0
8.SCAN PATH SKETCH NO.=D8K3052739
9.CAL.BLK.NO.=2.312-88-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D8052269

CALIBRATION AND DEVICE PARAMETERS

1.NOZZLE AZIMUTH=22
2.PIPE THICKNESS= 2.5
3.WELD LOC. FROM VESSEL CL (IN.)= 118.56
4.X-START POS.=0
5.X-STOP POS.=18000
6.NOZZLE BORE DIAMETER=29
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=43
10.Y-STOP POSITION=52.75

Comp 8 Nov. 87
JS

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 393.34
COUNTS PER DEGREE= 100

041300/041400

EXAM NO. 17a

[illegible]

CAL.BLK.NO. 2.312-38-37-SAP
DEVICE DWG.NO./CONFIG.NO. D30E2269

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-28	1 DIV	7 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	0 IN.	0 IN.	180 DEG.	180 DEG.
Y-OFFSET	+.6 IN.	-.6 IN.	-.6 IN.	-.6 IN.

MODULE CONFIGURATION NO.49

[illegible] SCAN SHEET

[illegible] 0110 8 NOV 87

[illegible] L.R. MATHENA N/A

[illegible]

NOZZLE @ 22°

PARAMETERS

WELD LOC. FROM VESSEL DL. 118.56 SEAM COMP.
SCAN INC.(IN.) .36 CTS.36 NOZ.BORE DIA. 22 HOIST POS. [illegible]
Y-FUNCTION: SWIVEL ROTATOR Y-FUNCTION: SCAN [illegible]

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	4300	0	18000	
2	CCW	4336	18000	0	
3	CW	4372	0	18000	
4	CCW	4408	18000	0	
5	CW	4444	0	18000	
6	CCW	4480	18000	0	
7	CW	4516	0	18000	
8	CCW	4552	18000	0	
9	CW	4588	0	18000	
10	CCW	4624	18000	0	
11	CW	4660	0	18000	
12	CCW	4696	18000	0	
13	CW	4732	0	18000	
14	CCW	4768	18000	0	
15	CW	4804	0	18000	
16	CCW	4840	18000	0	
17	CW	4876	0	18000	
18	CCW	4912	18000	0	
19	CW	4948	0	18000	
20	CCW	4984	18000	0	
21	CW	5020	0	18000	
22	CCW	5056	18000	0	
23	CW	5092	0	18000	
24	CCW	5128	18000	0	
25	CW	5164	0	18000	
26	CCW	5200	18000	0	
27	CW	5236	0	18000	
28	CCW	5272	18000	0	

REVIEWED BY: Carlos M Barrett (LEVEL II) DATE: 08 Nov 87

EXAM.NO. 137

EXTRA SCAN PLAN PARAMETER FAILURE

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=137
4.WELD NO.=29-RC-1130-1&2
5.COMPONENT=RC
6.SUBASSEMBLY=NOZ-SE-PIPE
7.PROCEDURE/REV/DEV=700-10/4
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1.NOZZLE AZIMUTH=158
2.PIPE THICKNESS= 2.5
3.WELD LOC. FROM VESSEL CL (IN.)= 118.56
4.X-START POS.=0
5.X-STOP POS.=16000
6.NOZZLE BORE DIAMETER=29
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=43
10.Y-STOP POSITION=52.75

Comp 8 Nov 87
(JS)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 395.34
COUNTS PER DEGREE= 100

048300
049100

EXAM NO. 137

[illegible]

[illegible]
DAL S/N.NO. 1.312-30-37-9AM
DEVICE DWG.NO./CONFIG.NO. D3CE2269

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-2B	1 DIV.	7 DIV.

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT DCW SWEEP DISTANCE IN. 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-2B	1 DIV.	7 DIV.

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-2B	1 DIV.	7 DIV.

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT DCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
1 / 2 DIV.	SCAN	START	STOP
2 / 4 DIV.			
3 / 6 DIV.	1-2B	1 DIV.	7 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	0 IN.	0 IN.	180 DEG.	180 DEG.
Y-OFFSET	+.6 IN.	-.6 IN.	+.6 IN.	-.6 IN.

MODULE CONFIGURATION NO.49

[illegible] PIPE SCAN SHEET

[illegible] 0210

SYS NO. 137 OPERATOR(S): L.R. Mathews

[illegible]

NOZZLE @ 158°

PARAMETERS

WELD LOC. FROM VESSEL CL. 118.56 BEAM COMP.
SCAN INC.(IN.) .26 STB.36 NOZ.BORE DIA. 29 HOIST POS. SC.LO
X-FUNCTION SWRI ROTATOR Y-FUNCTION ZOOM ENCODE

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	4300	0	18000	
2	CCW	4336	18000	0	
3	CW	4372	0	18000	
4	CCW	4408	18000	0	
5	CW	4444	0	18000	
6	CCW	4480	18000	0	
7	CW	4516	0	18000	
8	CCW	4552	18000	0	
9	CW	4588	0	18000	
10	CCW	4624	18000	0	
11	CW	4660	0	18000	
12	CCW	4696	18000	0	
13	CW	4732	0	18000	
14	CCW	4768	18000	0	
15	CW	4804	0	18000	
16	CCW	4840	18000	0	
17	CW	4876	0	18000	
18	CCW	4912	18000	0	
19	CW	4948	0	18000	
20	CCW	4984	18000	0	
21	CW	5020	0	18000	
22	CCW	5056	18000	0	
23	CW	5092	0	18000	
24	CCW	5128	18000	0	
25	CW	5164	0	18000	
26	CCW	5200	18000	0	
27	CW	5236	0	18000	
28	CCW	5272	18000	0	

REVIEWED BY Carlos M Bonilla (LEVEL: II) DATE: 28 Nov 87

EXAM.NO. 103

BWR SCAN PLAN PARAMETER FILE

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=103
4.WELD NO.=29-RC-1110-1&2
5.COMPONENT=RC
6.SUBASSEMBLY=NOZ-SE-PIPE
7.PROCEDURE/REV/DEV=700-10/4
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=2.312-SS-37-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1.NOZZLE AZIMUTH=202
2.PIPE THICKNESS= 2.5
3.WELD LOC. FROM VESSEL CL (IN.)= 118.56
4.X-START POS.=0
5.X-STOP POS.=18000
6.NOZZLE BORE DIAMETER=29
7.Y-OFFSET (PIV.TO RPV C.L.)=73
8.HOIST POSITION=85.62
9.Y-START POSITION=43
10.Y-STOP POSITION=52.75

Comp 8 Nov 87
(JB)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 393.34
COUNTS PER DEGREE= 100

052650
052700

EXAM NO. 128

[redacted]

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	0 IN.	0 IN.	180 DEG.	180 DEG.
Y-OFFSET	+.6 IN.	-.6 IN.	+.6 IN.	-.6 IN.

MODULE CONFIGURATION NO.49

0245

OPERATOR: L.R. Mathews

NOZZLE @ 202°

PARAMETERS

WELD LOC. FROM VESSEL CL. 118.56 BEAM COMP.
SCAN INC.(IN.) .36 CTS.36 NOZ.BORE DIA. 39 HOIST POS. 81.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BEAM EXTEN

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	4300	0	18000	
2	CCW	4336	18000	0	
3	CW	4372	0	18000	
4	CCW	4408	18000	0	
5	CW	4444	0	18000	
6	CCW	4480	18000	0	
7	CW	4516	0	18000	
8	CCW	4552	18000	0	
9	CW	4588	0	18000	
10	CCW	4624	18000	0	
11	CW	4660	0	18000	
12	CCW	4696	18000	0	
13	CW	4732	0	18000	
14	CCW	4768	18000	0	
15	CW	4804	0	18000	
16	CCW	4840	18000	0	
17	CW	4876	0	18000	
18	CCW	4912	18000	0	
19	CW	4948	0	18000	
20	CCW	4984	18000	0	
21	CW	5020	0	18000	
22	CCW	5056	18000	0	
23	CW	5092	0	18000	
24	CCW	5128	18000	0	
25	CW	5164	0	18000	
26	CCW	5200	18000	0	
27	CW	5236	0	18000	
28	CCW	5272	18000	0	

REVIEWED BY Carlos M Bonilla (LEVEL II) DATE 08 Nov. 87

EXAM.NO. 139

BWR SCAN PLAN PARAMETER FILE

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=139
4. WELD NO.=29-RC-1120-1&2
5. COMPONENT=RC
6. SUBASSEMBLY=NOZ-SE-PIPE
7. PROCEDURE/REV/DEV=700-10/4
8. SCAN PATH SKETCH NO.=DSK3C52739
9. CAL.BLK.NO.=2.312-08-37-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3C52269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=332
2. PIPE THICKNESS= 2.5
3. WELD LOC. FROM VESSEL CL (IN.)= 118.56
4. X-START POS.=0
5. X-STOP POS.=18000
6. NOZZLE BORE DIAMETER=29
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. Y-START POSITION=43
10. Y-STOP POSITION=52.75

Comp 8 Nov. 87
(12)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 395.34

COUNTS PER DEGREE= 100

050900/051000

EXAM NO. 139

[illegible]

[illegible]
PROBE(TYPE/SER.) [illegible] WELD TYPE NOZ. DS [illegible]
CAL.BLK I.D. 2.5IZ-SS-27-80M
DEVICE DWG.NO./CONFIG.NO. DC1500249

CALIBRATION PARAMETERS

INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

INST.NO.4 / 50/70 DEG.

TRANSDUCER SIZE 1X.5 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT CCW SWEEP DISTANCE(IN.) 5

CAL.NODES/SWEEP DIST.		GATE SETTINGS		
1	/ 2 DIV.	SCAN	START	STOP
2	/ 4 DIV.			
3	/ 6 DIV.	1-28	1 DIV.	7 DIV.

MODULE PARAMETERS

	INST.1	INST.2	INST.3	INST.4
X-OFFSET	0 IN.	0 IN.	180 DEG.	180 DEG.
Y-OFFSET	+.6 IN.	-.6 IN.	+.6 IN.	-.6 IN.

MODULE CONFIGURATION NO.49

6325 8 Nov 87

L Mathena N/A

Nozzle @ 338°

PARAMETERS

NOZZ LOC. FROM VESSEL CL. 118.56 BEAM COMP.
SCAN INC.(IN.) .34 CTS.26 NOZ.BORE DIA. 29 NOZZLE REF. ID
Y-FUNCTION SWRI ROTATOR Y-FUNCTION BODY BYTE 2

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	4300	0	18000	
2	CCW	4336	18000	0	
3	CW	4372	0	18000	
4	CCW	4408	18000	0	
5	CW	4444	0	18000	
6	CCW	4480	18000	0	
7	CW	4516	0	18000	
8	CCW	4552	18000	0	
9	CW	4588	0	18000	
10	CCW	4624	18000	0	
11	CW	4660	0	18000	
12	CCW	4696	18000	0	
13	CW	4732	0	18000	
14	CCW	4768	18000	0	
15	CW	4804	0	18000	
16	CCW	4840	18000	0	
17	CW	4876	0	18000	
18	CCW	4912	18000	0	
19	CW	4948	0	18000	
20	CCW	4984	18000	0	
21	CW	5020	0	18000	
22	CCW	5056	18000	0	
23	CW	5092	0	18000	
24	CCW	5128	18000	0	
25	CW	5164	0	18000	
26	CCW	5200	18000	0	
27	CW	5236	0	18000	
28	CCW	5272	18000	0	

REVIEWED BY Carles M Bowles (LEVEL: II) DATE: 08 Nov 87

EXAM.NO. 140

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1.SITE NAME=SALEM 1
2.PROJECT NO.=17-1552
3.EXAM NO.=140
4.WELD NO.=29-RPV-1140-1
5.COMPONENT=RPV
6.SUBASSEMBLY=OUT NOZ @22 DEG
7.PROCEDURE/REV/DEV=700-11/8
8.SCAN PATH SKETCH NO.=DSK3052739
9.CAL.BLK.NO.=N/S-CSCL-110-SAM
10.DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=22
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=12.4
5. Y-STOP POS.=45.45
6.WELD DIAMETER=53
7.NOZZLE BORE DIAMETER AT LIP=37.2
8.Y-OFFSET (PIV.TO RPV C.L.)=73
9.HOIST POSITION=85.62
10.FIRST CAL. REFLECTOR=5.5
11.SECOND CAL.REFLECTOR=11
12.THIRD CAL.REFLECTOR=16
13.EXAM.ANGLE #2=10

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32
COUNTS PER DEGREE= 100

Completed 6 Nov 87 DWK

002700

EXAM NO. 140

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK1002737
COMPONENT RFV SUBASSEMBLY OUT NOZ @22 DEG WELD NO. 29-RFV-1130-1
PROCEDURE/REV/DEV 700-.1/6 WELD TYPE N-SHELL EXAM.TYPE [illegible]
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. 03052269

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 10

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	7.6	SCAN	START	STOP
2/8	/	15.3			
3/8	/	22.3	1-469	4	24

****

INST.NO.2 /10 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 10
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	5.7	SCAN	START	STOP
2/8	/	11.5			
3/8	/	16.7	1-469	4	20

****

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-469	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	45 DEG.	10 DEG.	50/70
X-OFFSET	-.785 IN.	-.785 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13

SHEET NO. (4 OF 4)

SWRI EXAMINATION SHEET

SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1052 DATE: 6 NOV. 97
EXAM NO. L4 OPERATOR(S) L.R., MATHENA (N/A)
WELD NO. 27-RPV-1140-1
OUTLET @ 22°

PARAMETERS

VIDEO REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 0647
Y FUNCTION = Boom EXTEND X FUNCTION = SwRI ROTATOR

SCAN	DIR	INC-POS Y	~~NO VEC GEO OTHER~~ RUN X	X	SCAN RUN	REMARKS
1	CW	1240	0	36000	X CTS 0° TO 360°
2	CCW	1260	36000	0	
3	CW	1280			
4	CCW	1300			
5	CW	1320			
6	CCW	1340			
7	CW	1360			
8	CCW	1380			
9	CW	1400			
10	CCW	1420			
11	CW	1440			
12	CCW	1460			
13	CW	1480			
14	CCW	1500			
15	CW	1520			
16	CCW	1540			
17	CW	1560			
18	CCW	1580			
19	CW	1600			
20	CCW	1620			
21	CW	1640			
22	CCW	1660			
23	CW	1680			
24	CCW	1700			
25	CW	1720			
26	CCW	1740			
27	CW	1760			
28	CCW	1780			
29	CW	1800			
30	CCW	1820			
31	CW	1840			
32	CCW	1860			
33	CW	1880			
34	CCW	1900			
35	CW	1920			
36	CCW	1740			
37	CW	1960			
38	CCW	1780			
39	CW	2000			

TW

EXAM NO. 140 OPERATOR(S) L.R. MATHENA J. ALEJANDRO
WELD NO. 79-RPV-1140-1

SCAN	DIR	INC-POS	~~INDICATIONS~~ Y	~~NO YES REJ OTHER~~ X X	SCAN RUN	REMARKS
40	CCW	2020	360 0		I I	
41	CW	2040	0 360		I I	X CTS 0° TO 360°
42	CCW	2060			I I	
43	CW	2080			I I	
44	CCW	2100			I I	
45	CW	2120			I I	
46	CCW	2140			I I	
47	CW	2160			I I	
48	CCW	2180			I I	
49	CW	2200			I I	
50	CCW	2220			I I	
51	CW	2240			I I	
52	CCW	2260			I I	
53	CW	2280			I I	
54	CCW	2300			I I	
55	CW	2320			I I	
56	CCW	2340			I I	
57	CW	2360			I I	
58	CCW	2380			I I	
59	CW	2400			I I	
60	CCW	2420			I I	
61	CW	2440			I I	
62	CCW	2460			I I	
63	CW	2480			I I	
64	CCW	2500			I I	
65	CW	2520			I I	
66	CCW	2540			I I	
67	CW	2560			I I	
68	CCW	2580			I I	
69	CW	2600			I I	
70	CCW	2620			I I	
71	CW	2640			I I	
72	CCW	2660			I I	
73	CW	2680			I I	
74	CCW	2700			I I	
75	CW	2720			I I	
76	CCW	2740			I I	
77	CW	2760			I I	
78	CCW	2780			I I	
79	CW	2800			I I	
80	CCW	2820			I I	
81	CW	2840			I I	
82	CCW	2860			I I	
83	CW	2880			I I	
84	CCW	2900			I I	
85	CW	2920			I I	
86	CCW	2940			I I	
87	CW	2960			I I	
88	CCW	2980			I I	
89	CW	3000			I I	

EXAM NO. 140 OPERATOR(S): (JALEJANDRO) (N/A)
WELD NO. P7-RFV-1140-1

SCAN	DIR	INC-MOD	INDICATIONS NO	INDICATIONS YES	INDICATIONS UNC	INDICATIONS OTHER	SCAN RUN	REMARKS
			X	X				
90	CCW	3020- 36000		O		I	I	
91	CW	3040- O 36000				I	I	
92	CCW	3060-				I	I	
93	CW	3080-				I	I	
94	CCW	3100-				I	I	
95	CW	3120-				I	I	
96	CCW	3140-				I	I	
97	CW	3160-				I	I	
98	CCW	3180-				I	I	
99	CW	3200-				I	I	
100	CCW	3220-				I	I	
101	CW	3240-				I	I	
102	CCW	3260-				I	I	
103	CW	3280-				I	I	
104	CCW	3300-				I	I	
105	CW	3320-				I	I	
106	CCW	3340-				I	I	
107	CW	3360-				I	I	
108	CCW	3380-				I	I	
109	CW	3400-				I	I	
110	CCW	3420-				I	I	
111	CW	3440-				I	I	
112	CCW	3460-				I	I	
113	CW	3480-				I	I	
114	CCW	3500-				I	I	
115	CW	3520-				I	I	
116	CCW	3540-				I	I	
117	CW	3560-				I	I	
118	CCW	3580-				I	I	
119	CW	3600-				I	I	
120	CCW	3620-				I	I	
121	CW	3640-				I	I	
122	CCW	3660-				I	I	
123	CW	3680-				I	I	
124	CCW	3700-				I	I	
125	CW	3720-				I	I	
126	CCW	3740-				I	I	
127	CW	3760-				I	I	
128	CCW	3780-				I	I	
129	CW	3800-				I	I	
130	CCW	3820-				I	I	
131	CW	3840-				I	I	
132	CCW	3860-				I	I	
133	CW	3880-				I	I	
134	CCW	3900-				I	I	
135	CW	3920-				I	I	
136	CCW	3940-				I	I	
137	CW	3960-				I	I	
138	CCW	3980-				I	I	
139	CW	4000-				I	I	

EXAM NO. 140 OPERATOR(S): (J. ALEJANDRO, N/A)
WELD NO. 29-RPV-1140-1

SCAN	DIR	INC-PTS	INDICATIONS NO	YES	SEQ	OTHER	CCAN RUN	REMARKS
		Y	N	N				
140	CCW	4020 - 36000	0				I	I
141	CW	4040 - 0	36000				I	I
142	CCW	4060 -					I	I
143	CW	4080 -					I	I
144	CCW	4100 -					I	I
145	CW	4120 -					I	I
146	CCW	4140 -					I	I
147	CW	4160 -					I	I
148	CCW	4180 -					I	I
149	CW	4200 -					I	I
150	CCW	4220 -					I	I
151	CW	4240 -					I	I
152	CCW	4260 -					I	I
153	CW	4280 -					I	I
154	CCW	4300 -					I	I
155	CW	4320 -					I	I
156	CCW	4340 -					I	I
157	CW	4360 -					I	I
158	CCW	4380 -					I	I
159	CW	4400 -					I	I
160	CCW	4420 -					I	I
161	CW	4440 -					I	I
162	CCW	4460 -					I	I
163	CW	4480 -					I	I
164	CCW	4500 -					I	I
165	CW	4520 -					I	I

EXAM. TEMP. AFTER N/A, TIME EXAM END N/A.

REVIEWED BY Carlos M Barrera) (LEVEL (II) DATE 06 Nov 87

EXAM.NO. 141

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO: 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=141
4. WELD NO.=29-RPV-1130-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT NOZ @158 DEG
7. PROCEDURE/REV/DEV=700-11/8
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL. BLK. NO.=N/S-CSCL-110-SAM
10. DEVICE DWG. NO./CONFIG. NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZMUTH=158
2. VESSEL DIA.=85.65
3. WALL THICKNESS=11
4. Y-START POS.=12.4
5. Y-STOP POS.=45.45
6. WELD DIAMETER=53
7. NOZZLE BORE DIAMETER AT LIP=37.2
8. Y-OFFSET (PIV. TO RPV C.L.)=73
9. HOIST POSITION=85.62
10. FIRST CAL. REFLECTOR=5.5
11. SECOND CAL. REFLECTOR=11
12. THIRD CAL. REFLECTOR=16
13. EXAM. ANGLE #2=10

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32

COUNTS PER DEGREE= 100

Completed 6 Nov 87 RHF

BWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DSK3052739
COMPONENT RPV SUBASSEMBLY OUT NOZ @158 DEG. WELD NO. 2S-RPV-1130-1
PROCEDURE/REV/DEV 700-11/8 WELD TYPE N-SHELL EXAM.TYPE PT-WELD
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. E3052269

CALIBRATION PARAMETERS
INST.NO.1 / 45 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 45
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	7.6	SCAN	START	STOP
2/8	/	15.3			
3/8	/	22.3	1-469	4	24

****

INST.NO.2 /10 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 10
BEAM COMPONENT TOWARD VESSEL SWEEP DISTANCE(IN.) 20

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1/8	/	5.7	SCAN	START	STOP
2/8	/	11.5			
3/8	/	16.7	1-469	4	20

****

INST.NO.3 / 50/70 DEG.

TRANSDUCER SIZE .5 X.5 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT TOWARD VES. SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-469	1 DIV.	7 DIV.

****

MODULE PARAMETERS

	45 DEG.	10 DEG.	50/70
X-OFFSET	-.785 IN.	-.785 IN.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13

DATE: 6 NOV 87

OUTLET @ 158°

SCAN SHEET
PARAMETERS

FILE REEL NA COUNT NA STRIP CHART ROLL NA
CALIBRATION SHEET (S) NA
EXAM. TEMP. BEFORE NA, TIME EXAM. START 1111.
Y FUNCTION = BOOM EXTEND X FUNCTION = SWRI ROTATOR

SCAN	DIR	INC-POS Y	INDICATIONS NO X	INDICATIONS YES X	INDICATIONS YES Y	INDICATIONS REC	INDICATIONS OTHER	SCAN RUN	REMARKS
1	CW	1240-	0	36000			I	I	
2	CCW	1260-	36000	0			I	I	CTS. START 100 CTS TDC #
3	CW	1280-					I	I	CTS. STOP 36100 CTS TDC #
4	CCW	1300-					I	I	
5	CW	1320-					I	I	
6	CCW	1340-					I	I	
7	CW	1360-					I	I	
8	CCW	1380-					I	I	
9	CW	1400-					I	I	
10	CCW	1420-					I	I	
11	CW	1440-					I	I	
12	CCW	1460-					I	I	
13	CW	1480-					I	I	
14	CCW	1500-					I	I	
15	CW	1520-					I	I	
16	CCW	1540-					I	I	
17	CW	1560-					I	I	
18	CCW	1580-					I	I	
19	CW	1600-					I	I	
20	CCW	1620-					I	I	
21	CW	1640-					I	I	
22	CCW	1660-					I	I	
23	CW	1680-					I	I	
24	CCW	1700-					I	I	
25	CW	1720-					I	I	
26	CCW	1740-					I	I	
27	CW	1760-					I	I	
28	CCW	1780-					I	I	
29	CW	1800-					I	I	
30	CCW	1820-					I	I	
31	CW	1840-					I	I	
32	CCW	1860-					I	I	
33	CW	1880-					I	I	
34	CCW	1900-					I	I	
35	CW	1920-					I	I	
36	CCW	1940-					I	I	
37	CW	1960-					I	I	
38	CCW	1980-					I	I	
39	CW	2000-					I	I	

A

SHEET NO. 1 of 2

EVAL NO: 1-1 OPERATOR(S): JALEJANDRO ; (N/A)
WELL NO. 29-WPV-1130-1

SCAN	DIR	INC-POS	~~SUBSEQUENT~~ SCAN ~~NO. USED FOR OTHER~~ RUN	REMARKS
		4	X X	
40	CCW	2020 -	36000 0	
41	CW	2040-	0 36000	
42	CCW	2060-		
43	CW	2080-		
44	CCW	2100 -		
45	CW	2120-		
46	CCW	2140-		
47	CW	2160-		
48	CCW	2180 -		
49	CW	2200 -		
50	CCW	2220-		
51	CW	2240-		
52	CCW	2260-		
53	CW	2280-		
54	CCW	2300-		
55	CW	2320-		
56	CCW	2340-		
57	CW	2360.		
58	CCW	2380-		
59	CW	2400-		
60	CCW	2420-		
61	CW	2440-		
62	CCW	2460-		
63	CW	2480-		
64	CCW	2500-		
65	CW	2520-		
66	CCW	2540-		
67	CW	2560-		
68	CCW	2580-		
69	CW	2600-		
70	CCW	2620-		
71	CW	2640-		
72	CCW	2660-		
73	CW	2680 -		
74	CCW	2700-		
75	CW	2720-		
76	CCW	2740-		
77	CW	2760-		
78	CCW	2780-		
79	CW	2800-		
80	CCW	2820-		
81	CW	2840-		
82	CCW	2860-		
83	CW	2880-		
84	CCW	2900-		
85	CW	2920-		
86	CCW	2940-		
87	CW	2960-		
88	CCW	2980-		
89	CW	3000-		

A

EXAM NO. 141 OPERATOR(S) (JALEJANDRO) (N/A
WELD NO. 2"-RPV-1130-1

SCAN	DIR	INC-POS Y	~~INDICATIONS~~ NO YES SEC DEPTH	SCAN RUN	REMARKS
			X X		
90	CCW	3020-	36000 0	I I	
91	CW	3040-	0 36000	I I	
92	CCW	3060-		I I	
93	CW	3080-		I I	
94	CCW	3100-		I I	
95	CW	3120-		I I	
96	CCW	3140-		I I	
97	CW	3160-		I I	
98	CCW	3180-		I I	
99	CW	3200-		I I	
100	CCW	3220-		I I	
101	CW	3240-		I I	
102	CCW	3260-		I I	
103	CW	3280-		I I	
104	CCW	3300-		I I	
105	CW	3320-		I I	
106	CCW	3340-		I I	
107	CW	3360-		I I	
108	CCW	3380-		I I	
109	CW	3400-		I I	
110	CCW	3420-		I I	
111	CW	3440-		I I	
112	CCW	3460-		I I	
113	CW	3480-		I I	
114	CCW	3500-		I I	
115	CW	3520-		I I	
116	CCW	3540-		I I	
117	CW	3560-		I I	
118	CCW	3580-		I I	
119	CW	3600-		I I	
120	CCW	3620-		I I	
121	CW	3640-		I I	
122	CCW	3660-		I I	
123	CW	3680-		I I	
124	CCW	3700-		I I	
125	CW	3720-		I I	
126	CCW	3740-		I I	
127	CW	3760-		I I	
128	CCW	3780-		I I	
129	CW	3800-		I I	
130	CCW	3820-		I I	
131	CW	3840-		I I	
132	CCW	3860-		I I	
133	CW	3880-		I I	
134	CCW	3900-		I I	
135	CW	3920-		I I	
136	CCW	3940-		I I	
137	CW	3960-		I I	
138	CCW	3980-		I I	
139	CW	4000-		I I	

AJ

EXAM NO. 141 OPERATOR(S) JALEJANDRO / (N/A)
VE 0 NO. 29-OPV-1120-1

SCAN	DIR	INC-POS	INDICATIONS	SCAN RUN	REMARKS
		y	~~AC VSR HF1 HF2 HFW~~ x x		
140	CCW	4020-	36000 0		
141	CW	4040-	0 36000		
142	CCW	4060-			
143	CW	4080-			
144	CCW	4100-			
145	CW	4120-			
146	CCW	4140-			
147	CW	4160-			
148	CCW	4180-			
149	CW	4200-			
150	CCW	4220-			
151	CW	4240-			
152	CCW	4260-			
153	CW	4280-			
154	CCW	4300-			
155	CW	4320-			
156	CCW	4340-			
157	CW	4360-			
158	CCW	4380-			
159	CW	4400-			
160	CCW	4420-			
161	CW	4440-			
162	CCW	4460-			
163	CW	4480-			
164	CCW	4500-			
165	CW	4520-			

EXAM. TEMP. AFTER N/A, TIME EXAM END N/A.

REVIEWED BY (Carlos M Barrera) (LEVEL(II) DATE(06 Nov 87)

EXAM.NO. 142

EWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO.: 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=142
4. WELD NO.=29-RPV-1140-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT NOZ @22 DEG
7. PROCEDURE/REV/DEV=700-11/8
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=N/S-CSCL-110-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=22
2. OUTSIDE VESSEL DIA.=85.65
3. INSIDE VES DIA.(I.E.IF OUTLET)=166.5
4. X-START POS.=~~0~~ 100 (JS)
5. X-STOP POS.=~~36000~~ 36100
6. NOZZLE BORE DIAMETER=53
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. Y-START POSITION=12.4
10. Y-STOP POSITION=35.05

Comp 7 Nov 87
(JS)

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32

COUNTS PER DEGREE= 100

002700

EXAM NO. 142

EWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DCM30II7[illegible]
COMPONENT RPV SUBASSEMBLY OUT NOZ @22 DEG WELD NO. 29-RPV-11 W
PROCEDURE/REV/DEV 700-11/3 WELD TYPE IRS EXAM.TYPE TRANSVERSE
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. DS0532269

CALIBRATION PARAMETERS
INST.NO. 13 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT ~~CCW~~ CW (12) SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

INST.NO. 14 50/70 DEG.

TRANSDUCER SIZE .5X1 IN. FREQ. 2.25 MHZ.
BEAM COMPONENT ~~CW~~ CCW (12) SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

MODULE PARAMETERS

X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13A

SHEET NO. 142101

SWRI PAR SCAN SHEET

ITE NAME SALEM 1 PROJECT NO. 17-1552 TIME (2313) DATE (6 NOV 87

EXAM NO. 142 OPERATOR(S) LR MATHENA (~/A) WELD NO. 29-RPV-1140-1

PARAMETERS

NOZZLE LOC. 22 VESSEL DIA. 166.5 OUTSIDE VES.DIA.65.63
SCAN INC.(IN.) .5 CTS..5 NOZ.BORE DIA. 53 HOIST POS. 35.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	12.4	0	36000	
2	CCW	12.9	36000	0	
3	CW	13.4	0	36000	
4	CCW	13.9	36000	0	
5	CW	14.4	0	36000	
6	CCW	14.9	36000	0	
7	CW	15.4	0	36000	
8	CCW	15.9	36000	0	
9	CW	16.4	0	36000	
10	CCW	16.9	36000	0	
11	CW	17.4	0	36000	
12	CCW	17.9	36000	0	
13	CW	18.4	0	36000	
14	CCW	18.9	36000	0	
15	CW	19.4	0	36000	
16	CCW	19.9	36000	0	
17	CW	20.4	0	36000	
18	CCW	20.9	36000	0	
19	CW	21.4	0	36000	
20	CCW	21.9	36000	0	
21	CW	22.4	0	36000	
22	CCW	22.9	36000	0	
23	CW	23.4	0	36000	
24	CCW	23.9	36000	0	
25	CW	24.4	0	36000	
26	CCW	24.9	36000	0	
27	CW	25.4	0	36000	
28	CCW	25.9	36000	0	
29	CW	26.4	0	36000	
30	CCW	26.9	36000	0	
31	CW	27.4	0	36000	
32	CCW	27.9	36000	0	
33	CW	28.4	0	36000	
34	CCW	28.9	36000	0	
35	CW	29.4	0	36000	
36	CCW	29.9	36000	0	
37	CW	30.4	0	36000	
38	CCW	30.9	36000	0	
39	CW	31.4	0	36000	

EXAM NO. 142 OPERATOR(S) L.R. MATHEWS (N/A) SHEET NO. 142102
WELD NO. 29--RPV-1140-1

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CCW	31.9 ✓	36000	0	
41	CW	32.4 ✓	0	36000	
42	CCW	32.9 ✓	36000	0	
43	CW	33.4 ✓	0	36000	
44	CCW	33.9 ✓	36000	0	
45	CW	34.4 ✓	0	36000	
46	CCW	34.9 ✓	36000	0	

REVIEWED BY(Carlos M Barrera) (LEVEL(II) DATE(07 Nov 87)

EXAM.NO. 143

EXAM SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=143
4. WELD NO.=29-RPV-1130-1
5. COMPONENT=RPV
6. SUBASSEMBLY=OUT NOZ @158 DEG
7. PROCEDURE/REV/DEV=700-11/8
8. SCAN PATH SKETCH NO.=DSK3052739
9. CAL.BLK.NO.=N/S-CSCL-110-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052269

CALIBRATION AND DEVICE PARAMETERS

1. NOZZLE AZIMUTH=158
2. OUTSIDE VESSEL DIA.=85.65
3. INSIDE VES DIA.(I.E.IF OUTLET)=166.5
4. X-START POS.=~~0~~ 100
5. X-STOP POS.=~~36000~~ 3610
6. NOZZLE BORE DIAMETER=53
7. Y-OFFSET (PIV.TO RPV C.L.)=73
8. HOIST POSITION=85.62
9. Y-START POSITION=12.4
10. Y-STOP POSITION=35.05

Comp 7 Nov 87

JS

X-CONVERSION PARAMETERS

INCHES PER COUNT= 0 COUNTS PER INCH= 216.32

COUNTS PER DEGREE= 100

003300

EXAM NO. 143

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. 25K1C62739
COMPONENT RPV SUBASSEMBLY OUT NOZ @156 DEG WELD NO. 29-RPV-1.1)-1
PROCEDURE/REV/DEV 70C-11/0 WELD TYPE IRS EXAM.TYPE. TRANS/REFL
CAL.BLK.NO. N/S-CSCL-110-SAM DEVICE DWG.NO./CONFIG.NO. 26C532C69

CALIBRATION PARAMETERS
INST.NO.1 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT ~~CCW~~ CW (J9) SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

INST.NO.2 / 50/70 DEG.

TRANSDUCER SIZE .5X1 IN.FREQ. 2.25 MHZ.
BEAM COMPONENT ~~CW~~ CCW (J9) SWEEP DISTANCE(IN.) 2.5

CAL.NODES/SWEEP DIST.			GATE SETTINGS		
1	/	2 DIV.	SCAN	START	STOP
2	/	4 DIV.			
3	/	6 DIV.	1-46	1 DIV.	7 DIV.

****

MODULE PARAMETERS

X-OFFSET	0 DEG.	180 DEG.
Y-OFFSET	-3.2 IN.	-3.2 IN.

MODULE CONFIGURATION NO. 13A

SHEET NO.143101

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME(0110) DATE(7 NOV,87

EXAM NO. 143 OPERATOR(S) (P.C.TURNER) (N/A/M.THEOA) WELD NO. 29-RPV-11J0-1

PARAMETERS

NOZZLE LOC. 158 VESSEL DIA. 166.5 OUTSIDE VES.DIA.85.63
SCAN INC.(IN.) .3 CTS..5 NOZ.BORE DIA. 53 HOIST POS. 33.62
X-FUNCTION SWRI ROTATOR Y-FUNCTION BOOM EXTEND

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	12.4	0	36000	
2	CCW	12.9	36000	0	
3	CW	13.4	0	36000	
4	CCW	13.9	36000	0	
5	CW	14.4	0	36000	
6	CCW	14.9	36000	0	
7	CW	15.4	0	36000	
8	CCW	15.9	36000	0	
9	CW	16.4	0	36000	
10	CCW	16.9	36000	0	
11	CW	17.4	0	36000	
12	CCW	17.9	36000	0	
13	CW	18.4	0	36000	
14	CCW	18.9	36000	0	
15	CW	19.4	0	36000	
16	CCW	19.9	36000	0	
17	CW	20.4	0	36000	
18	CCW	20.9	36000	0	
19	CW	21.4	0	36000	
20	CCW	21.9	36000	0	
21	CW	22.4	0	36000	
22	CCW	22.9	36000	0	
23	CW	23.4	0	36000	
24	CCW	23.9	36000	0	
25	CW	24.4	0	36000	
26	CCW	24.9	36000	0	
27	CW	25.4	0	36000	
28	CCW	25.9	36000	0	
29	CW	26.4	0	36000	
30	CCW	26.9	36000	0	
31	CW	27.4	0	36000	
32	CCW	27.9	36000	0	
33	CW	28.4	0	36000	
34	CCW	28.9	36000	0	
35	CW	29.4	0	36000	
36	CCW	29.9	36000	0	
37	CW	30.4	0	36000	
38	CCW	30.9	36000	0	
39	CW	31.4	0	36000	

SHEET NO.143102

EXAM NO. 143 OPERATOR(S) (LR Mathews) (n/a) WELD NO. 29-RFV-1130-1

SCAN	DIR	X-POS	Y-START	Y-STOP	REMARKS
40	CCW	31.9 ✓	36000	0	
41	CW	32.4 ✓	0	36000	
42	CCW	32.9 ✓	36000	0	
43	CW	33.4 ✓	0	36000	
44	CCW	33.9 ✓	36000	0	
45	CW	34.4 ✓	0	36000	
46	CCW	34.9 ✓	36000	0	

REVIEWED BY (Carla M Barnes) (LEVEL (II) DATE (07 Nov 87)

EXAM.NO. 144

SWRI SCAN PLAN PARAMETER RECORD

SITE NAME SALEM 1 PROJECT NO. 17-1552

EXAMINATION PARAMETERS

1. SITE NAME=SALEM 1
2. PROJECT NO.=17-1552
3. EXAM NO.=144
4. WELD NO.=1-RPV-7042
5. COMPONENT=RPV
6. SUBASSEMBLY=VES-FLANGE
7. PROCEDURE/REV/DEV=700-11/7
8. SCAN PATH SKETCH NO.=DSK3052744
9. CAL.BLK.NO.=VF/S-CSCL-109-SAM
10. DEVICE DWG.NO./CONFIG.NO.=D3052270

CALIBRATION AND DEVICE PARAMETERS

1. WELD LOC.=28.28
2. VESSEL DIA.=171.3
3. WALL THICKNESS=11
4. X-START POS.=0
5. X-STOP POS.=36000
6. WELD LENGTH=538.5
7. Y-POSITION=2.58
8. CAL.BLK.THICKNESS(IN.)=14
9. HOIST POSITION = -1.35

Comp 8 NOV. 87

(JS)

X-CONVERSION PARAMETERS

INCHES PER DEGREE= 1.49 DEGREES PER INCH= .66

002000

SWRI SCAN PLAN EXAMINATION TABLE

SITE NAME SALEM 1 PROJECT NO. 17-1552 SCAN PATH SK. DS[illegible]
COMPONENT RPV SUBASSEMBLY VES-FLANGE WELD NO. 1-RPV-7142
PROCEDURE/REV/DEV 700-11/7 WELD TYPE - CIRC. SCAN TYPE - PARALLEL
CAL.BLK.NO. VF/S-CSCL-109-SAM DEVICE DWG.NO./CONFIG.NO. DS[illegible]

CALIBRATION PARAMETERS
INST.NO.1 / 12.5 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 12.5
BEAM COMPONENT AWAY FM. CL. SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
HOLE(21.25 IN)/21.75	SCAN	START	STOP
HOLE(26.75 IN)/27.4	1	20	35
HOLE(32.25 IN)/33.03			

****

INST.NO.2 / 1.5 DEG

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 1.5
BEAM COMPONENT TOWARD CL. SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
HOLE(21.25 IN)/21.3	SCAN	START	STOP
HOLE(26.75 IN)/26.75	1	20	35
HOLE(32.25 IN)/32.26			

****

INST.NO.3 / 5.7 DEG.

TRANSDUCER SIZE 1 FREQ. 2.25 MHZ. NOM.BEAM ANGLE(DEG.) 5.7
BEAM COMPONENT AWAY FM. CL. SWEEP DISTANCE(IN.) 40

CAL.NODES/SWEEP DIST.	GATE SETTINGS		
HOLE(21.25 IN)/21.36	SCAN	START	STOP
HOLE(26.75 IN)/26.88	1	20	35
HOLE(32.25 IN)/32.41			

****

MODULE PARAMETERS

	12.5 DEG.	1.5 DEG	5.7 DEG
X-OFFSET	+2 IN.	0 IN.	-2 IN.
Y-OFFSET	0 IN.	0 IN.	0 IN.

MODULE CONFIGURATION NO.18

SHEET NO. 1 OF 1

SWRI PAR SCAN SHEET

SITE NAME SALEM 1 PROJECT NO. 17-1552 TIME 2126 DATE 8 Nov 87

EXAM NO. 144 OPERATOR(S) L.R. MATHENA (N/A) WELD NO. 1-RPV-12(4)

PARAMETERS

WELD LOC. 28.28 VESSEL DIA. 171.3 WALL THICKNESS 11
SCAN INC.(IN.) .75(CTS.) .75 WELD LENGTH 536.5
X-FUNCTION BOOM ROTATE SWRI ROTATOR 0 Y-FUNCTION BOOM EXT.

SCAN	DIR	Y-POS	X-START	X-STOP	REMARKS
1	CW	00111	0	360.6	

REVIEWED BY Carlos M Barrera (LEVEL (II) DATE (09 Nov 87)