

PRESERVICE INSPECTION AUTOMATED EXAMINATIONS SCAN PLAN
FOR REACTOR VESSEL WELDS

LONG ISLAND LIGHTING COMPANY
SHOREHAM NUCLEAR POWER STATION
UNIT 1

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PRESERVICE INSPECTION AUTOMATED EXAMINATIONS SCAN PLAN

1. SCOPE

- 1.1 The automated examinations scan plan herein is the scanning sequence for the Reactor Pressure Vessel (RPV) Shell Welds, excluding the lower head meridional welds. The scan plan specifies the welds to be examined, area of examination for each weld, the scanning sequence to be followed for this examination and other pertinent data. The scanning sequence allows for as complete coverage as possible of each weld from one or more permanent tracks.
- 1.2 The plan will be modified as required when as-built conditions dictate the need for such modifications and will be presented as a final report after the examinations are finished. The report will serve as the basis for ISI considerations.

2. REFERENCES

The following documents form a part of this scan plan.

1. ASME Boiler and Pressure Vessel Code, Section XI, 1971 Edition and Summer of 1972 Addenda
2. ASME Boiler and Pressure Vessel Code, Section III, 1971 Edition and Summer of 1972 Addenda
3. NES Document 80A0482, Preservice Inspection Program Plan, Unit 1 (Latest Revision)
4. NES Document 80A0480 Automated Ultrasonic Examination Procedures for Reactor Vessel Welds
5. NES Document 80A4438, Report on the Shoreham Vessel Scanner On-Site Fit-up Procedure (Latest Revision)
6. NES Drawing 80E3710 RPV Rollout Shoreham I (Latest Revision)
7. NES Drawing 80E3696 Scanner Track System Locations Shoreham I (Latest Revision)
8. NES Drawing 80E3719 Vessel Scanner Outline Drawing Shoreham (Latest Revision)
9. NES Drawing 80D3700 Scan Path Layout RPV Sled Attitude Horizontal Shoreham I (Latest Revision)
10. NES Drawing 80D3704 Scan Path Layout RPV Sled Attitude Vertical Shoreham I (Latest Revision).

3. EQUIPMENT

- 3.1 This examination is to be performed from the OD of the RPV.
- 3.2 The vessel scanner travels in the vertical plane on permanent tracks attached to the RPV biological shield wall. This motion is denoted Y, with the 0" RPV elevation as its starting point, Y increasing with elevation above this point.
- 3.3 The sled/transducer assembly is mounted on the movable arm of the vessel scanner, allowing travel in the horizontal plane. This second motion is denoted X, with the 0° azimuth of the RPV as its starting point, X increasing with clockwise rotation around the RPV.
- 3.4 A third motion is denoted Z, which is movement of the arm and attached sled in the radial (in and out) direction. This movement is to insure sufficient contact between the sled and the OD surface of the RPV.

4. SCANNING SEQUENCE SUMMARY

- 4.1 The examination scanning sequence has been developed to fulfill several objectives: to keep ultrasonic calibrations to a minimum, to have as few equipment changes as possible, and to lessen movement around the RPV.
- 4.2 Based on these criteria, the examination should be performed on a track-by-track basis around the RPV, first from the top of the vessel with calibration block SNPS-6. Next, calibration block SNPS-7% is utilized to complete the examination from the top of the RPV. The equipment is moved to the bottom of the RPV and the examination is finished with calibration block SNPS-7%. Calibration is then performed with SNPS-6 and the examination completed from the bottom of the vessel.
- 4.3 The Scan Sequence Sheets list the scans required from each track, depending on the calibration block used. The page number of the sheet will prefix the scan number to form a unique number for that scan. Each scan has calculated values already entered. Below these entries are spaces for recording the actual values used, if they differ.
- 4.4 Following the Scan Sequence Sheets are the Weld Scan Check-off Sheets. These sheets form a part of the data review process, and list the scans needed to complete each weld, based on the calibration block required and the direction of the scan. By recording the actual values for each scan on the appropriate sheet(s), a record of the completion of each weld is obtained.

TABLE 1A
AREA OF EXAMINATION - VERTICAL WELDS

5-7/8" SHELL COURSE
(See Figure 1)

Weld No.	°	Exam Coverage Y"		⊥ Scan Path X°		= Scan Path X°	
		From	To	From	To	From	To
1-308A	30°	553	618	24.75	35.25	28	32
1-308B	150°	553	618	144.75	155.25	148	152
1-308C	270°	553	618	264.75	275.25	268	272
1-308D	0°	403	553	354.75	5.25	358	2
1-308E	120°	403	553	114.75	125.25	118	122
1-308F	240°	403	553	234.75	245.25	238	242
1-308G	30°	253	403	24.75	35.25	28	32
1-308H	150°	253	403	144.75	155.25	148	152
1-308J	270°	253	403	264.75	275.25	268	272



6-7/8" SHELL COURSE
(See Figure 2)

Weld No.	°	Exam Coverage Y"		⊥ Scan Path X°		= Scan Path X°	
		From	To	From	To	From	To
1-307A *	18°	104	140	11.75	24.25	15.5	20.5
		227	253				
1-307B	138°	104	253	131.75	144.25	135.5	140.5
1-307C	258°	104	253	251.75	264.25	255.5	260.5

* The other areas of the weld were examined manually.

TABLE 1B
AREA OF EXAMINATION - CIRCUMFERENTIAL WELDS

5-7/8" SHELL COURSE
(See Figure 3)

Weld No.	C	Exam Coverage X°		⊥ Scan Coverage Y"		= Scan Coverage Y"	
		From	To	From	To	From	To
4-308A*	553"	340.03	26.65	542.5	563.5	548.75	557.25
4-308A*	553"	106.41	115.37	542.5	563.5	548.75	557.25
4-308A*	553"	245.40	278.02	542.5	563.5	548.75	557.25
4-308B*	403"	359.95	35.52	392.5	413.5	398.75	407.25
4-308B*	403"	106.41	124.24	392.5	413.5	398.75	407.25
4-308B*	403"	147.81	165.64	392.5	413.5	398.75	407.25
4-308B*	403"	236.53	254.36	392.5	413.5	398.75	407.25
4-308B*	403"	266.10	283.93	392.5	413.5	398.75	407.25

1

5-7/8" - 6-7/8" SHELL COURSE
(See Figure 4)

Weld No.	C	Exam Coverage X°		⊥ Scan Coverage Y"		= Scan Coverage Y"	
		From	To	From	To	From	To
1-313*	253"	17.70°	35.52°	5-7/8" Shell Course		5-7/8" Shell Course	
1-313*	253"	127.11°	165.64°	251.75	263.5	253	257.25
1-313*	253"	245.40°	283.93°	6-7/8" Shell Course		6-7/8" Shell Course	
				241	254.25	248	253

* The other areas of the weld were examined manually.

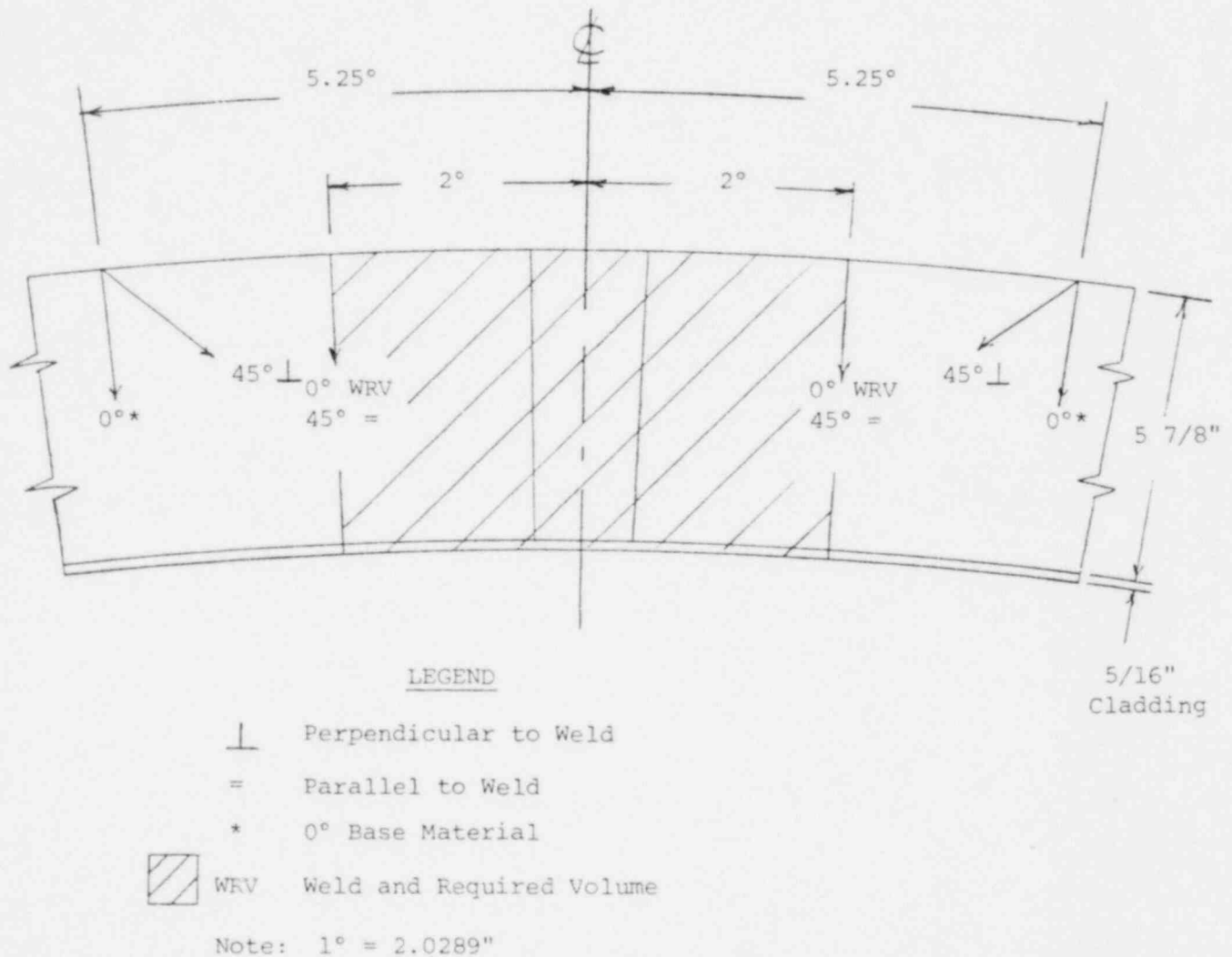
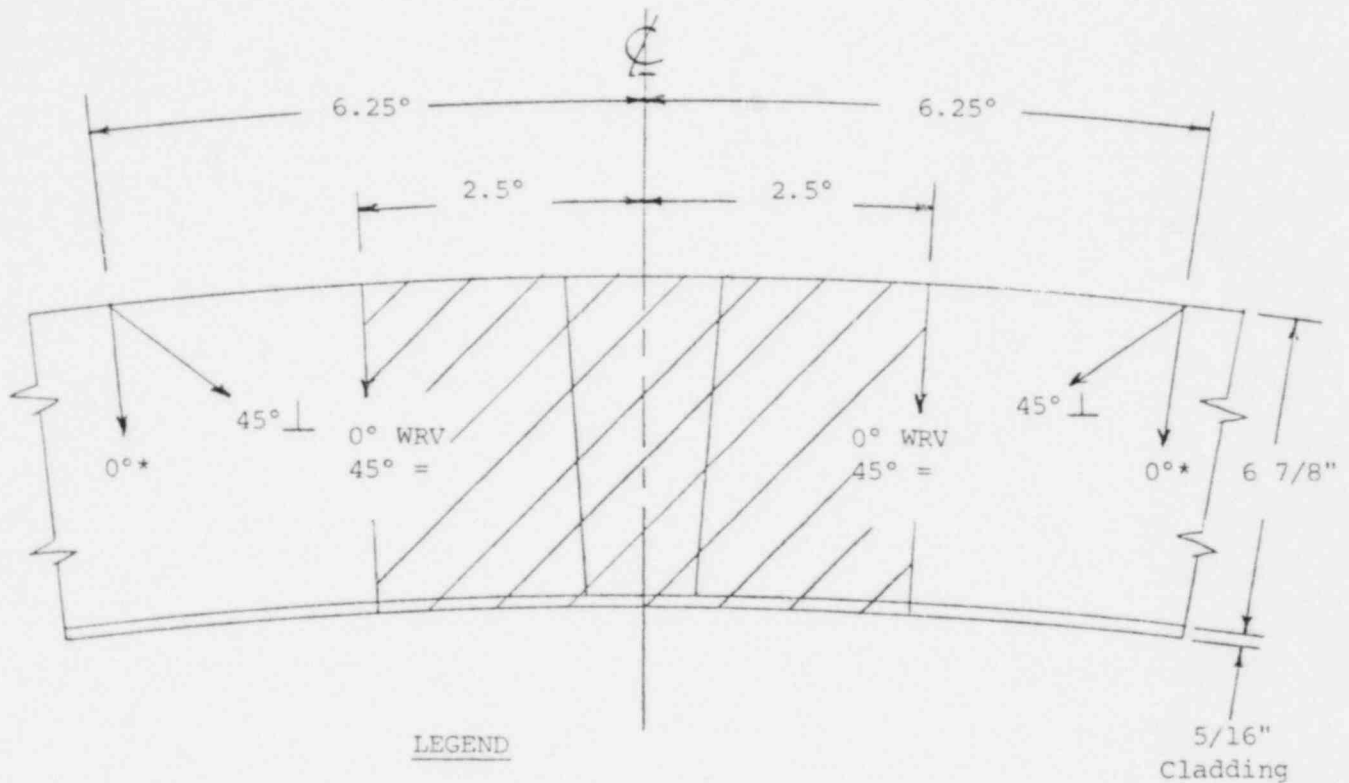


FIGURE 1. EXTENT OF COVERAGE IN THE X DIRECTION FOR VERTICAL WELDS 1-308A THRU H AND J (TYP.)



LEGEND

⊥ Perpendicular to Weld

= Parallel to Weld

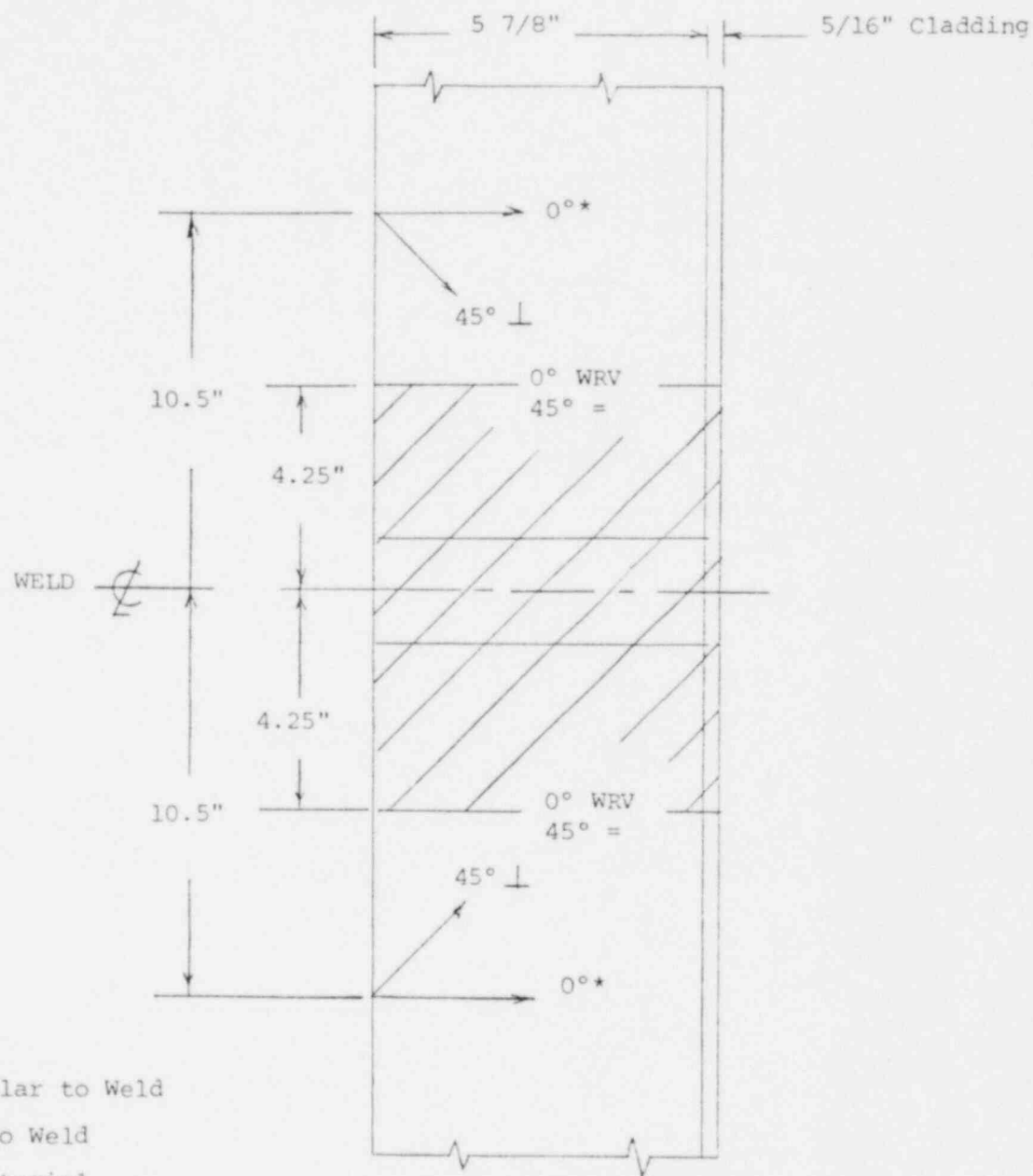
* 0° Base Material



WRV Weld and Required Volume

Note: 1° = 2.0289"

FIGURE 2. EXTENT OF COVERAGE IN THE X DIRECTION FOR VERTICAL WELDS 1-307A, B, AND C (TYP.)



⊥ Perpendicular to Weld

= Parallel to Weld

* 0° Base Material

 WRV Weld and Required Volume

FIGURE 3. EXTENT OF COVERAGE IN THE Y DIRECTION FOR CIRCUMFERENTIAL WELDS 4-308A AND B (TYP.)

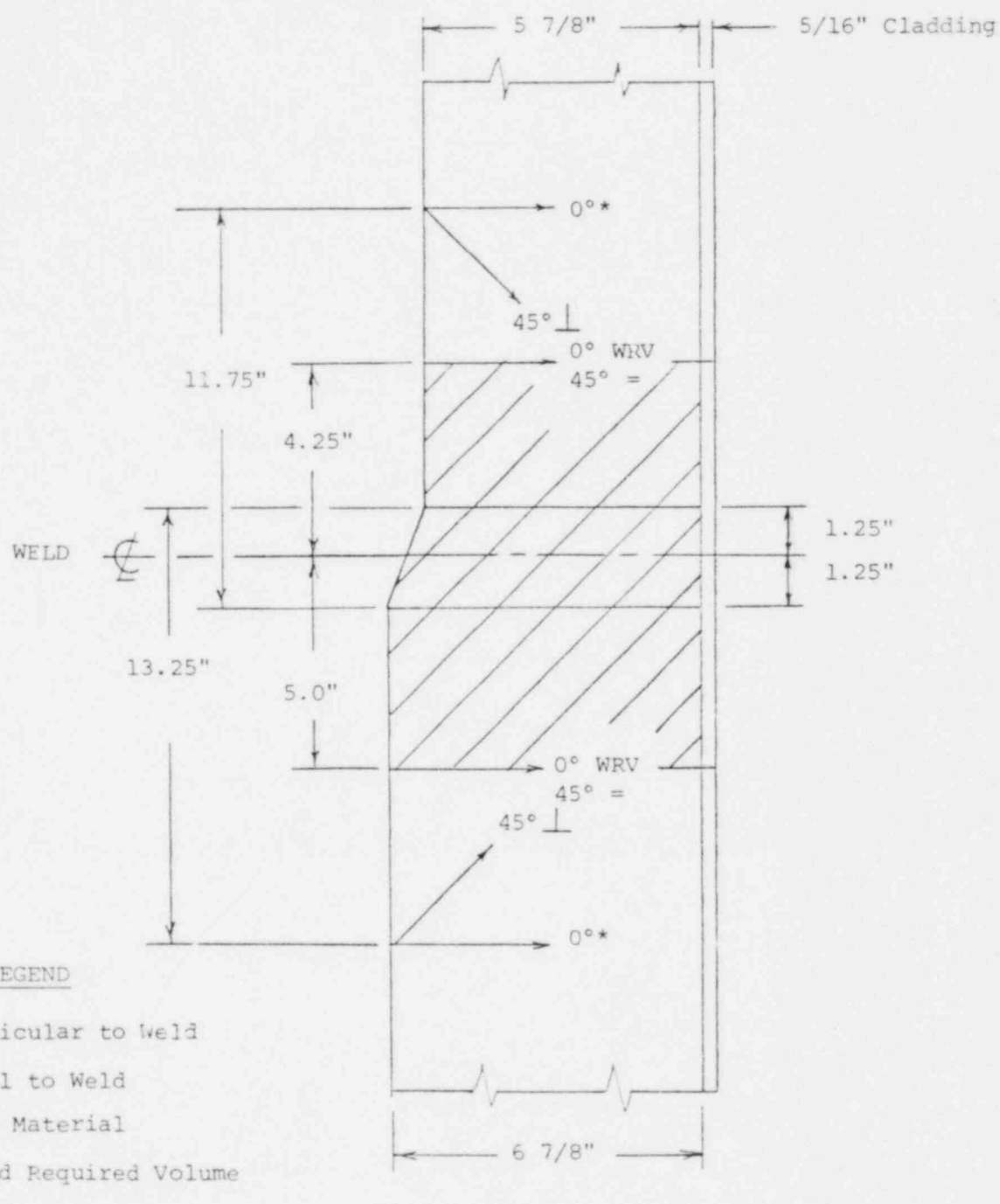


FIGURE 4. EXTENT OF COVERAGE IN THE Y DIRECTION FOR CIRCUMFERENTIAL WELD 1-313

5. GENERAL PROCEDURE FOR SETTING OF POSITIONAL REFERENCE (SLED LOCATION)

- 5.1 Determine requirements for scanner and sled from Scan Sequence Sheet.
- 5.2 Adjust scanner for correct mode (upright or inverted) and direction of rack teeth (see Figures 7 and 8).
- 5.3 Install required arm on scanner.
- 5.4 Install sled in the required position and orientation (see Figures 5 and 6).
- 5.5 Install scanner from the top or bottom of track.
- 5.6 Install temporary top stop (80D3711) as required (see Figures 7 and 8).
- 5.7 Run scanner to primary positional reference for Y (top or bottom stop) with Z motion retracted and set encoder to given value (see Figures 7 and 8).
- 5.8 Run arm/sled to primary positional reference for X (extended or retracted) and set encoder to given value (see Figures 5 and 6).
- 5.9 Secondary positional references may be used as needed.

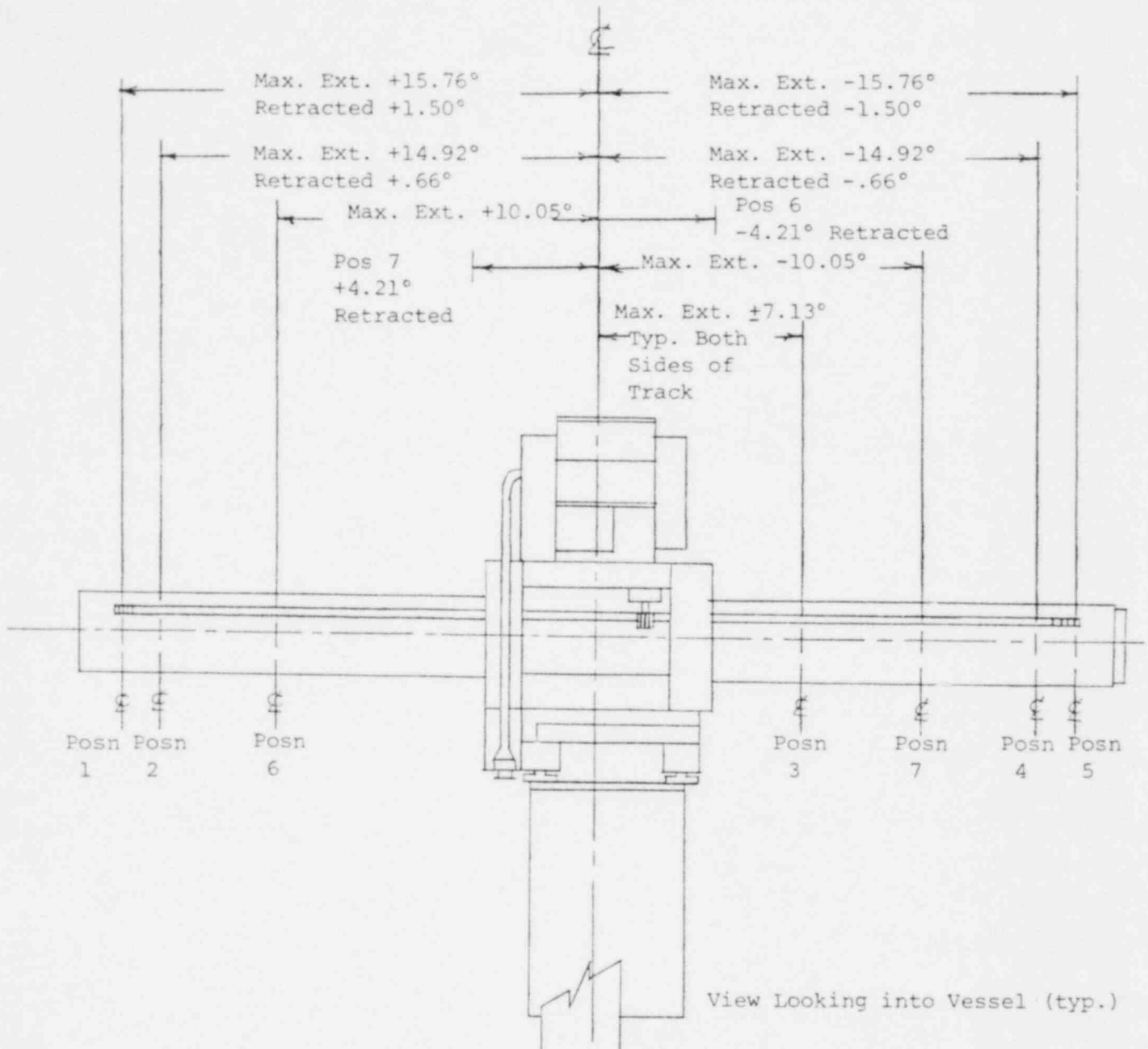


FIGURE 5. SLED POSITIONS AND DISTANCES FROM TRACK ϕ WITH 40" ARM.
VESSEL SCANNER - UPRIGHT POSITION

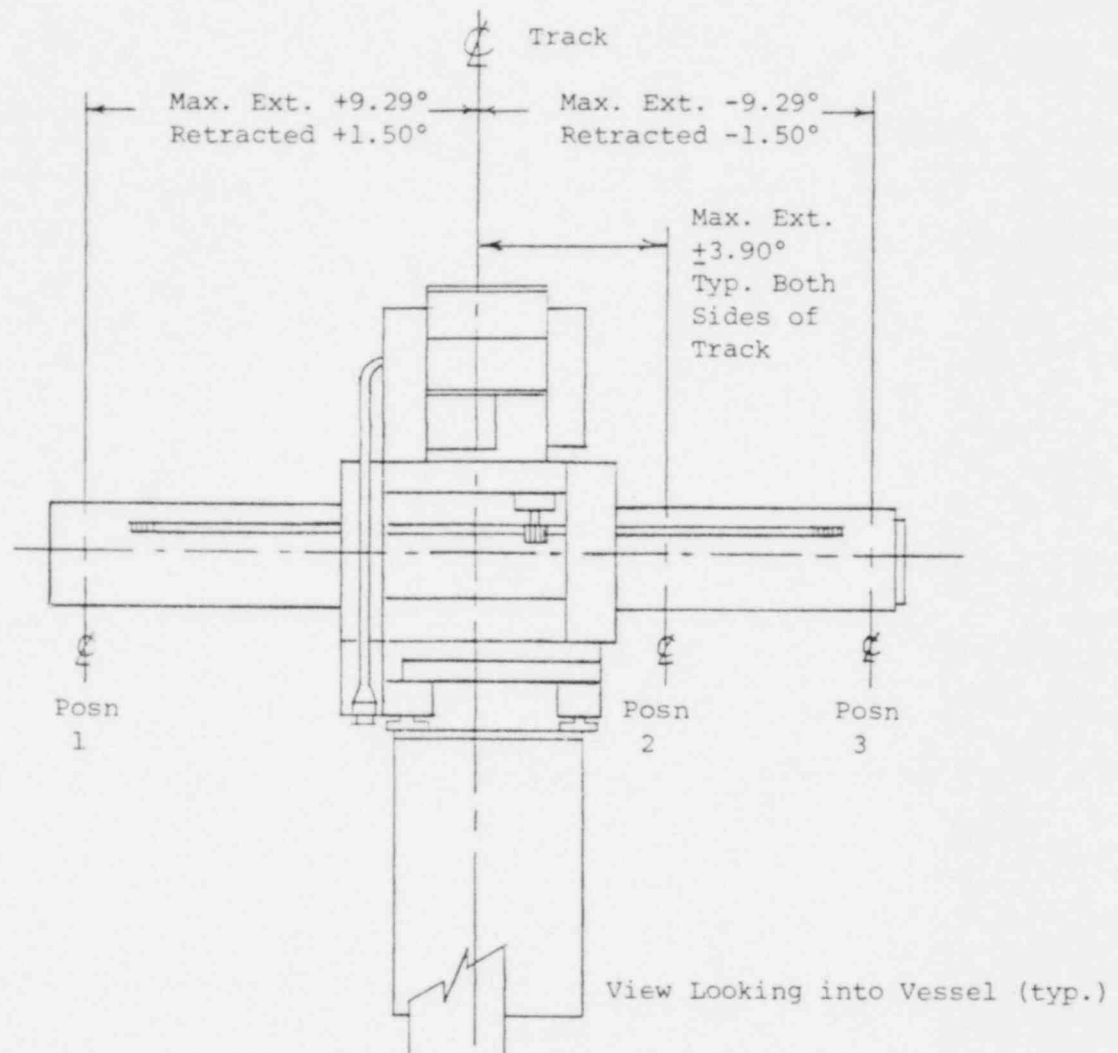


FIGURE 6. SLED POSITIONS AND DISTANCES FROM TRACK WITH 26 1/2" ARM
VESSEL SCANNER - UPRIGHT POSITION

Track Azimuth	Direction of Rack Teeth**	Scanner at Top Shop	Scanner at Bottom Stop	Type of Bottom Stop
0°		* 622.05	384.93	Round
22°		146.68	49.06	Flat
24°		* 622.19	230.93	Round
113°		* 598.10	384.93	Round
135°		279.68	49.15	Flat
157°		* 622.19	252.93	Round
247°		* 598.10	384.93	Round
255°		279.68	49.15	Flat
270°		* 598.19	537.11	Flat
274°		* 437.20	252.91	Round
347°		* 622.19	537.15	Flat

* Elevations shown with temporary stop 80D3711
Installed (Z motion retracted)

** Indicate direction rack teeth on track are facing, view looking
towards vessel



FIGURE 7. PERMANENT TRACK AZIMUTHS AND SLED ELEVATIONS (VESSEL EL.)
VESSEL SCANNER - UPRIGHT POSITION

Track Azimuth	Direction of Rack Teeth**	Scanner at Top Shop	Scanner at Bottom Stop	Type of Bottom Stop
0°		* 597.80	358.31	Round
22°		120.06	24.81	Flat
24°		* 597.94	204.31	Round
113°		* 573.85	358.31	Round
135°		253.06	24.90	Flat
157°		* 597.94	226.31	Round
247°		* 573.85	358.31	Round
255°		253.06	24.90	Flat
270°		* 573.94	512.36	Flat
274°		* 412.95	226.27	Round
347°		* 597.94	512.90	Flat

* Elevations shown with temporary stop 80D3711
Installed (Z motion retracted)

** Indicate direction rack teeth on track are facing, view looking toward vessel



FIGURE 8. PERMANENT TRACK AZIMUTH AND OF SLED ELEVATIONS (VESSEL EL.)
VESSEL SCANNER - INVERTED POSITION

TOLERANCES UNLESS
OTHERWISE SPECIFIED

OTHERWISE SPECIFIED	DECIMALS			BREAK EDGES .02 RADII OR CHAMFER MAX
	1 PLACE	2 PLACE	3 PLACE	
	± N A	± N A	± N A	NATIONAL STANDARD TOLERANCES APPLY TO COMMERCIAL MATS THREADS UNFIFIED CL 3A 2B
	FRACTIONS	ANGLES	CHAMFERS	PER ASA B 1
	± N A	± N A	± N A	DIMENSIONS ARE IN INCHES UNLESS NOTED OTHERWISE FOR FAR HOT TUNOT ALLOWANCE FOR FAR WELD SHIRKAGE
ONLY ON BETTER	SURFACE FINISH RA			DIMS AND TOLERANCES ARE TO BE INTERPRETED IN ACCORDANCE WITH ANSI Y14.6-1973
				FILLETS - .02 TO .03 RADII

ITEM	QTY	PART NO	DESCRIPTION	MATERIAL
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APPENDIX A

SCAN SEQUENCE SHEETS



SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 347°
Rack Teeth Dir. 
From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. 2
Cal. Block No. SNPS-6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
Inv.	40"	6	597.94	336.95	512.90	351.21

[illegible]

Operator _____ Date _____



SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 274°
Rack Teeth Dir. 
From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. 2
Cal. Block No. SNPS-6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Top Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Bottom Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
Inv.	40"	7	412.95	269.79	226.27	284.05

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 274°
Rack Teeth Dir. ▶
From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
INV	40"	6	412.95	263.95	226.27	278.21

Scan	Sled	Scan X°		Scan Y"		Index		Coverage For		Remarks
No.	ATT	From	To	From	To	X/Y	AMT	Weld	Dir.	
3-274-5	Vert.	263.95	269.79	251.75	263.5	X	.36°	1-313	⊥	
								1-308J	=	△1
3-274-6	Vert.	268.0	272.0	263.5	392.5	X	.36°	1-308J	=	
3-274-7	Vert.	266.10	269.79	392.5	413.5	X	.36°	4-308E	⊥	
								1-308J	=	△1
3-274-8	Hor.	263.95	269.79	253.0	257.25	Y	.75"	1-313	=	
								1-308J	⊥	
3-274-9	Hor.	264.75	275.25	257.25	398.75	Y	.75"	1-308J	⊥	
3-274-10	Hor.	264.75	269.79	398.75	403.0	Y	.75"	1-308J	⊥	
								4-308E	=	△1
3-274-11	Hor.	266.10	269.79	403.0	407.25	Y	.75"	4-308E	=	

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 270°
Rack Teeth Dir. ▶
From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. 2
Cal. Block No. SNPS-6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
Inv.	40"	7	573.95	265.79	512.86	280.05

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit 1
 Comp/Syst. Automated
RPV OD Exam

Track 157°
 Rack Teeth Dir. ◀
 From Top of Vessel

Cal. Data Pkg. No. _____
 Proc. No. 80A0480 Rev. 2
 Cal. Block No. SNPS-6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Top Stop		Primary Pos. Ref X° Arm Retracted		Secondary Pos. Ref Y" Bottom Stop		Secondary Pos. Ref X° Arm Extended	
Mode	Arm									
Inv.	40"	1	597.94		141.24		226.31		155.5	

Scan No.	Sled ATT	Scan X°		Scan Y"		Index		Coverage For		Remarks
		From	To	From	To	X/Y	AMT	Weld	Dir.	
10-157-5	Hor.	141.24	155.24	253.0	257.25	Y	.75"	1-313	=	
								1-308H	⊥	
10-157-6	Hor.	144.75	155.25	257.25	403.0	Y	.75"	1-308H	⊥	
								4-308B	=	
10-157-7	Hor.	147.81	155.25	403.0	407.25	Y	.75"	4-308B	=	
10-157-8	Hor.	144.75	155.25	553.0	597.94	Y	.75"	1-308B	⊥	
10-157-9	Vert.	141.24	152.79	251.75	263.5	X	.36°	1-313	⊥	
								1-308H	=	
10-157-10	Vert.	148.0	152.0	263.5	392.5	X	.36°	1-308H	=	
10-157-11	Vert.	147.81	152.79	392.5	413.5	X	.36°	4-308B	⊥	
								1-308H	=	
10-157-12	Vert.	148.0	152.0	553.0	597.94	X	.36°	1-308B	=	

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track $\angle$ 113°
 Rack Teeth Dir. 
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
INV	40"	6	573.85	102.95	358.31	117.21

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Track 24°
 Rack Teeth Dir. ◀
 From Top of Vessel

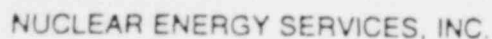
Cal. Data Pkg. No. _____
 Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled	Primary Pos. Ref Y"		Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm	Posn	Top	Stop	Arm Retracted	Bottom Stop	Arm Extended
Inv	40"	4	597.94		24.66	204.31	38.92

Scan No.	Sled ATT	Scan X°		Scan Y"		Index		Coverage For		Remarks
		From	To	From	To	X/Y	AMT	Weld	Dir.	
14-24-1	Vert.	24.66	35.52	251.75	263.5	X	.36°	1-313	⊥	
								1-308G	=	
14-24-2	Vert.	28.0	32.0	263.5	392.5	X	.36°	1-308G	=	
14-24-3	Vert.	24.66	35.53	392.5	413.5	X	.36°	4-308B	⊥	
								1-308G	=	
14-24-4	Vert.	28.0	32.0	553.0	597.94	X	.36°	1-308A	=	
14-24-5	Hor.	24.66	35.52	253.0	257.25	Y	.75"	1-313	=	
								1-308G	⊥	
14-24-6	Hor.	24.75	35.25	257.25	398.75	Y	.75"	1-308G	⊥	
14-24-7	Hor.	24.66	35.53	398.75	407.25	Y	.75"	4-308B	=	
								1-308G	⊥	
14-24-8	Hor.	24.75	35.25	553.0	597.94	Y	.75"	1-308A	⊥	

Operator _____ Date _____



SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 0°
 Rack Teeth Dir. 
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Top Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Bottom Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	3	597.80	352.87	358.31	7.13

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Track 4 00
 Rack Teeth Dir. 
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS-6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
INV	40"	4	597.80	0.66	358.31	14.92

[illegible]

Operator _____ Date _____



Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 24°
 Rack Teeth Dir. ◀
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS-7 1/4

Scanner		Sled Posn	Primary Pos. Ref Y" Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	4	204.31	24.66	597.94	38.92

Operator _____ Date _____



Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 24°
 Rack Teeth Dir. 
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Scanner		Sled Posn	Primary Pos. Ref Y" Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	6	204.31	28.21	597.94	13.95

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
 Comp/Syst. Automated
RPV OD Exam

Track C 24°
 Rack Teeth Dir. 
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS-7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	2	204.31	23.34	597.94	9.08

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp. syst. Automated
RPV OD Exam

Track C 157°
Rack Teeth Dir. 
From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS-7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	7	226.31	152.79	597.94	167.05

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 157°
 Rack Teeth Dir. ◀
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y " Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y " Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	1	226.31	155.5	597.94	141.24

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Track 4 274°
 Rack Teeth Dir. ▶
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	7	226.27	269.79	412.95	284.00

[illegible]

Operator _____ Date _____



Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Track 274°
 Rack Teeth Dir. 
 From Top of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Scanner		Sled Posn	Primary Pos. Ref Y" Bottom Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Top Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
INV	40"	2	226.27	273.04	412.95	259.08

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Track C 22°
 Rack Teeth Dir. 
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
UP	40"	7	146.68	26.21	49.06	11.95

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 135°
 Rack Teeth Dir. 
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Top Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Bottom Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
UP	264	1	279.68	136.5	49.15	144.29

[illegible]

Operator _____ Date _____

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

FORM # NES 205 2/80

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit 1
Comp/Syst. Automated
RPV OD Exam

Track C 135°
 Rack Teeth Dir. 
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Top Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Bottom Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
UP	26°	3	279.68	133.5	49.15	125.71

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp./Syst. Automated
RPV OD Exam

Track C 255°
 Rack Teeth Dir. ▶
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS-7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
UP	264	2	279.68	251.1	49.15	258.9

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 255°
 Rack Teeth Dir. ▶
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 7 1/4

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
UP	26½	3	279.68	253.5	49.15	245.71

[illegible]

Operator _____ Date _____



SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 255°
 Rack Teeth Dir. ▶
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
UP	26½	2	279.68	251.1	49.15	258.9

[illegible]

Operator _____ Date _____

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 135°
Rack Teeth Dir. 
From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
UP	264	1	279.68	136.5	49.15	144.29

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 135°
Rack Teeth Dir. ▶
From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y"	Primary Pos. Ref X°	Secondary Pos. Ref Y"	Secondary Pos. Ref X°
Mode	Arm		Top Stop	Arm Retracted	Bottom Stop	Arm Extended
UP	264	2	279.68	131.1	49.15	138.9

[illegible]

Operator _____ Date _____

SCAN SEQUENCE SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Track C 135°
 Rack Teeth Dir. ▶
 From Bottom of Vessel

Cal. Data Pkg. No. _____
Proc. No. 80A0480 Rev. _____
Cal. Block No. SNFS- 6

Positional Reference

Scanner		Sled Posn	Primary Pos. Ref Y" Top Stop	Primary Pos. Ref X° Arm Retracted	Secondary Pos. Ref Y" Bottom Stop	Secondary Pos. Ref X° Arm Extended
Mode	Arm					
UP	264	3	279.68	133.5	49.15	125.71

[illegible]

Operator _____ Date _____



NUCLEAR ENERGY SERVICES, INC.

DOCUMENT NO. 80A4437

APPENDIX B

WELD SCAN CHECK-OFF SHEETS



NUCLEAR ENERGY SERVICES, INC.

DOCUMENT NO. 80A4437

PAGE 1 OF 27

WELD SCAN CHECK-OFF SHEETPlant/Unit LILCOShoreham Unit IComp/Syst. Automated

RPV OD Exam

Proc. No. 80A0480 Rev. _____

Cal. Block No. SNPS-6Weld No. 1-308A ϕ 30°

Required Scans	Exam Coverage		└ Scan Coverage	
	From	To	From	To
	553.0"	618.0"	24.75°	35.25°
14-24-8				
16-24-15				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	553.0"	618.0"	28°	32°
14-24-4				
16-24-16				

Remarks: _____



WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Weld No. 1-308B ϕ 150°

Required Scans	Exam Coverage		┴ Scan Coverage	
	From	To	From	To
	553.0"	618.0"	144.75°	155.25° 1
10-157-8				
11-157-14				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	553.0"	618.0"	148°	152° 1
10-157-12				
11-157-13				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS- 6

Weld No. 1-308C ϕ 270°

Required Scans	Exam Coverage		1 Scan Coverage	
	From	To	From	To
	553.0"	618.0"	264.75°	275.25° 1
4-270-1				
4-270-2				
5-270-5				
5-270-6				
6-270-9				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	553.0"	618.0"	263°	272° 1
4-270-4				
6-270-8				
4-270-3				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS- 6

Weld No. 1-308D 0°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	403"	553"	354.75°	5.25° 
18-0-4				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	403"	553"	358°	2° 
18-0-3				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 1-308E ϕ 120°

Required Scans	Exam Coverage		<u>L</u> Scan Coverage	
	From	To	From	To
	403.0"	553.0"	114.75°	125.25° 1
12-113-2				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	403.0"	553.0"	118°	122° 1
12-113-3				
12-113-4				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 1-308F ϕ 240°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	403.0"	553.0"	234.75°	245.25° 1
8-247-8				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	403.0"	553.0"	238°	242° 1
8-247-6				
8-247-5				1

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 1-308G ϕ 30°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	253.0"	403.0"	24.75°	35.25° $\triangle 1$
14-24-5				
14-24-6				
14-24-7				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	253.0"	403.0"	28°	32° $\triangle 1$
14-24-1				
14-24-2				
14-24-3				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS-6

Weld No. 1-308H ϕ 150°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	253.0"	403.0"	144.75°	155.25° $\triangle$ 1
10-157-5				
10-157-6				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	253.0"	403.0"	148°	152° $\triangle$ 1
10-157-9				
10-157-10				
10-157-11				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 1-308J ϕ 270°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	253.0"	403.0"	264.75	275.25 $\triangle$ 1
2-274-3				
2-274-4				
3-274-8				
3-274-9				
3-274-10				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	253.0"	403.0"	268°	272° $\triangle$ 1
2-274-1				
2-274-2				
3-274-6				
3-274-5				$\triangle$ 1
3-274-7				$\triangle$ 1

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS-6

Weld No. 4-308A ϕ 553°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	340.03°	26.65°	542.5"	563.5" $\triangle 1$
1-347-1				
1-347-4				
15-24-11				
18-0-3				
19-0-8				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	340.03°	26.65°	548.75"	557.25" $\triangle 1$
1-347-2				
1-347-3				
15-24-14				
18-0-4				
19-0-6				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS- 6

Weld No. 4-308A ϕ 553"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	106.41°	115.37°	542.5"	563.5" $\triangle$ 1
13-113-8				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	106.41°	115.37°	548.75"	557.25" $\triangle$ 1
13-113-6				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 4-308A ϕ 553"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	245.40°	278.02°	542.5"	563.5" $\triangle$ 1
4-270-3				
5-270-7				
7-247-2				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	245.40°	278.02°	548.75"	557.25" $\triangle$ 1
4-270-1				
5-270-5				
7-247-4				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 4-308B ϕ 403"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	359.95°	35.53°	392.5"	413.5" $\triangle$ 1
14-24-3				
15-24-10				
19-0-7				
18-0-3				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	359.95°	35.52°	398.75"	407.25" $\triangle$ 1
14-24-7				
15-24-13				
18-0-4				
19-0-5				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 4-308B ϕ 403"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	106.41°	124.24°	392.5"	413.5" $\triangle$ 1
12-113-3				
13-113-7				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	106.41°	124.24°	398.75"	407.25" $\triangle$ 1
12-113-1				
12-113-2				
13-113-5				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 4-308B ϕ 403"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	147.81°	165.64°	392.5"	413.5" $\triangle 1$
9-157-4				
10-157-11				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	147.81°	165.64°	398.75"	407.25" $\triangle 1$
9-157-2				
10-157-6				
10-157-7				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 4-308B ϕ 403"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	236.53°	254.36°	392.5"	413.5" $\triangle$ 1
7-247-1				
8-247-5				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	236.53°	254.36°	398.75"	407.25" $\triangle$ 1
7-247-3				
8-247-7				
8-247-8				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 4-308B 403

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	266.10°	283.93°	392.5"	413.5" △ 1
2-274-2				
3-274-7				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	266.10°	283.93°	398.75"	407.25" △ 1
2-274-4				
3-274-11				
3-274-10				△ 1

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 6

Weld No. 1-313 ϕ 253"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	17.70°	35.52°	251.75"	263.5" $\triangle 1$
14-24-1				
15-24-9				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	17.70°	35.52°	253.0"	257.25" $\triangle 1$
14-24-5				
15-24-12				

Remarks: _____



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WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Weld No. 1-313 ϕ 253"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	127.11°	165.64°	251.75"	263.5" $\triangle$ 1
9-157-3				
10-157-9				
37-135-1				
38-135-4				
39-135-5				

Remarks: _____

Required Scans	Exam Coverage		≡ Scan Coverage	
	From	To	From	To
	127.11°	165.64°	253.0"	257.25" $\triangle$ 1
9-157-1				
10-157-5				
37-135-2				
38-135-3				
39-135-6				

Remarks: _____



WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
Shoreham Unit I
Comp/Syst. Automated
RPV OD Exam

Proc. No. 80A0480 Rev. _____
Cal. Block No. SNPS- 6

Weld No. 1-313 Ø 253"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	245.40°	283.93°	251.75"	263.5" ⚠
2-274-1				
3-274-5				
34-255-1				
35-255-4				
36-255-5				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	245.40°	283.93°	253.0"	257.25" ⚠
2-274-3				
3-274-8				
34-255-2				
35-255-3				
36-255-6				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS-

Weld No. 1-307A ϕ 18°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	104.0"	140.0"	11.75°	24.25°
27-22-1				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	104.0"	140.0"	15.5°	120.5°
27-22-2				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS- 7 1/4

Weld No. 1-307A ϕ 18°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	227.0"	253.0"	11.75°	24.25° $\triangle 1$
21-24-3				
21-24-4				
22-24-8				$\triangle 1$

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	227.0"	253.0"	15.5°	20.5° $\triangle 1$
21-24-5				
21-24-6				
21-24-7				$\triangle 1$

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 7 1/4

Weld No. 1-307B ϕ 138°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	104"	253.0"	131.75°	144.25° $\triangle$ 1
24-157-4				
28-135-3				
28-135-4				
29-135-7				
29-135-8				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	104"	253.0"	135.5°	140.5° $\triangle$ 1
28-135-1				
28-135-2				
29-135-5				
29-135-6				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS- 7 1/4

Weld No. 1-307C ϕ 258°

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	104"	253.0"	251.75°	264.25° $\triangle 1$
26-274-4				
31-255-1				
31-255-2				
32-255-5				
32-255-6				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	104"	253.0"	255.5°	260.5° $\triangle 1$
26-274-3				
31-255-3				
31-255-4				
32-255-7				
32-255-8				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Weld No. 1-313 ϕ 253"

Proc. No. 80A0480 Rev.
 Cal. Block No. SNPS- 7 1/4

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	17.70°	35.52°	241"	254.25" $\triangle 1$
20-24-1				
21-24-6				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	17.70°	35.52°	248"	253" $\triangle 1$
20-24-2				
21-24-3				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS-7 1/4

Weld No. 1-313 ϕ 253"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	127.11°	165.64°	241"	254.25" $\triangle$ 1
23-157-1				
24-157-3				
28-135-2				
29-135-6				
30-135-10				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	127.11°	164.64°	248"	253.0" $\triangle$ 1
23-157-2				
24-157-4				
28-135-4				
29-135-8				
30-135-9				

Remarks: _____

WELD SCAN CHECK-OFF SHEET

Plant/Unit LILCO
 Shoreham Unit I
 Comp/Syst. Automated
 RPV OD Exam

Proc. No. 80A0480 Rev. _____
 Cal. Block No. SNPS- 7 1/4

Weld No. 1-313 ϕ 253"

Required Scans	Exam Coverage		⊥ Scan Coverage	
	From	To	From	To
	245.40°	283.93°	241"	254.25" $\triangle$
25-274-1				
26-274-3				
31-255-4				
32-255-8				
33-255-9				

Remarks: _____

Required Scans	Exam Coverage		= Scan Coverage	
	From	To	From	To
	245.40°	283.93°	248"	253.0" $\triangle$
25-274-2				
26-274-4				
31-255-2				
32-255-6				
33-255-10				

Remarks: _____