

NO EXAMINATIONS SCHEDULED THIS OUTAGE

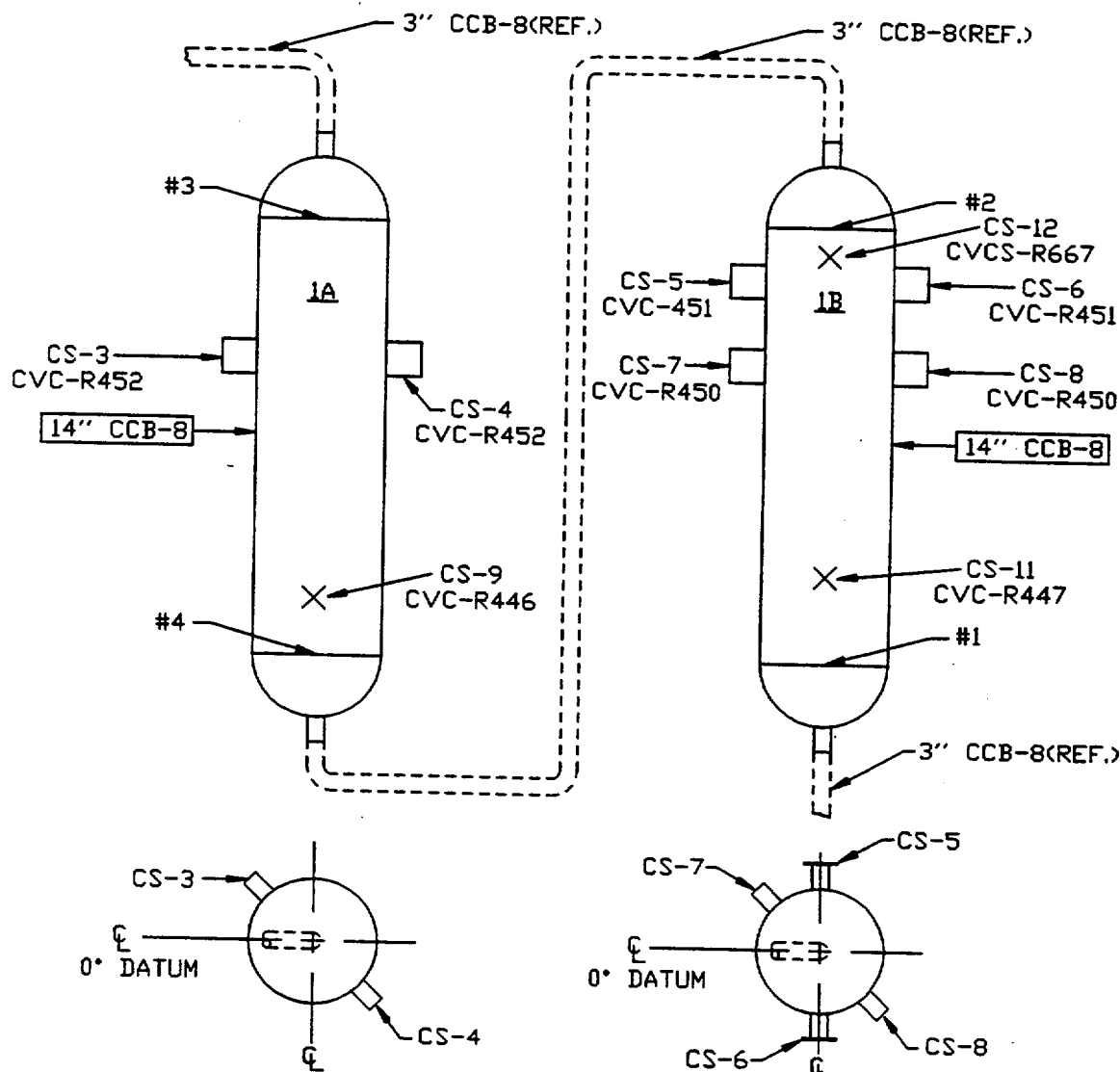
DRAWING ALA2-1110
LETDOWN DELAY TANKS

[illegible]

CONTAINMENT
EL. 106'-0"

LETDOWN DELAY TANKS

ALA2-1110



PLAN VIEW

MATERIAL:	1.250" T 14" SCH. 140
WELDS:	14" DIAMETER 43.96" CIRCUMFERENCE (TYP. 4 PLACES) (FNP-FIG-023)
WELDED SUPPORTS:	6 WELDED 6" SCH. 160 PIPES - 0.719" THICK
SUPPORTS:	10 TOTAL SUPPORTS (FNP-FIG - 037)
CAL. BLOCK:	ALA-18
PIPING ISO'S:	D-514639 SH.1

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG	DEV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCM	WRH	AH	DML
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for LETDOWN DELAY TANKS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

A-351192

SHEET

73

REV.

1

CAD ALA2110
AUTOCAD RAV-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-1110-3	Date 3/12/00	Sheet No. S00F1U027	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-18	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	031279	Thickness	1.250"	1T	80	2.0	.9	1T	80	2.2	1.27
Ax. dB		Size	.375	Cal. Temp.	72	2T	35	4.0	1.7	2T	35	4.4	2.75
Ref.	30	Frequency/Mode	2.25 / S	Cal. In	0910	3T	20	6.0	2.53				
Scan	40	"A" Dimension	.3	Cal. Chk.	1230	4T	10	8.0	3.28				
Reject	OFF	Nominal Angle	45	Cal. Out	1350	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	38	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15"	Amplitude/Sweep	20% / 1.4								

Comp. Temp.: 70 °F		Configuration: LTD DEL TANK SHELL TO HEAD		Wo Location C/L				Lo Location (*)			
Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax L2	Reference Measurement W1 Wmax W2	Sweep Position S1 Smax S2	Thickness 1" < -- C/L -- > 1"	Notes:		
2	● ○ ○	N/A									
5	● ○ ○	N/A									
7	● ○ ○	N/A									
8	● ○ ○	N/A									

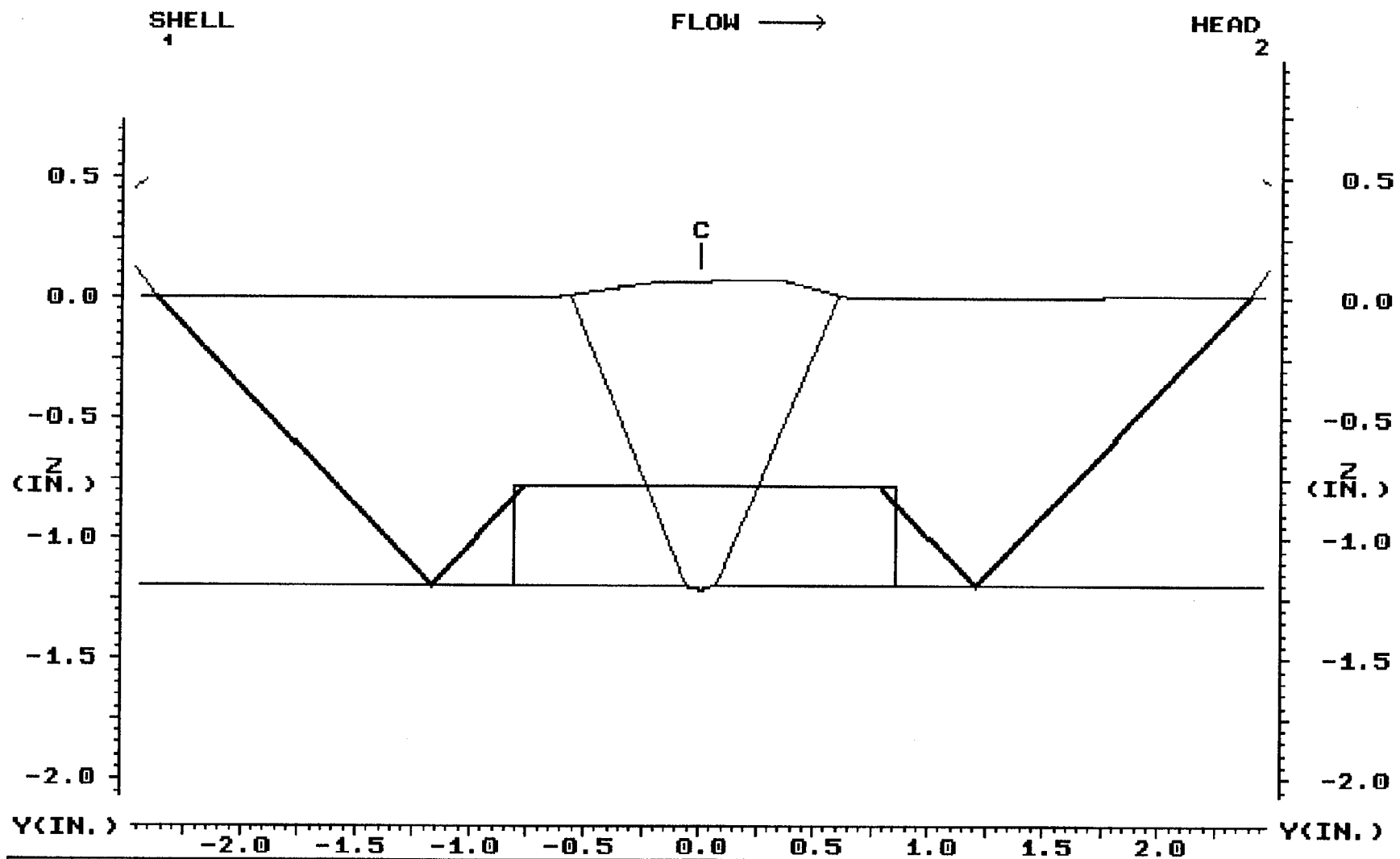
Examination/Limitation Remarks:

(*) 90° CW FROM ABOVE PIPE ELBOW

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
44 1/4"	1.3"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from .75 to NL	2 - from .75 to NL	From (5) NL to (2) NL			
Primary Examiner JOSEPH D. FUNYAK	Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>		Date 3-15-2000	
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-14-00	Percentage of Code Coverage 100 %			ANII Review <i>[Signature]</i>		Date 3/17/00		

Figure 1

Revision 7



1	SET	1R16005.dat 1R16005A.SCR						2	SET
1.60	DEP							1.61	DEP
2.27	MP	45 DEGREE ASME COVRAGE PLOT						2.27	MP
44.30	TOF	100% CODE COVERAGE OBTAINED						44.35	TOF
	ARC	DR CORDES L/III							ARC
	GATE								GATE
0.050	STEP							0.050	STEP
	EXIT	MAKERAY	UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT	EXIT
PLANT: FARLEY 1 SYSTEM: LETDOWN DELAY TANKS COMPONENT: ALA2-1110-3									
				3/14/00	CIRC. POS.: TYP				
				12:58	ANALYST: DR CORDES L/III				
					CAL. SHEET: S00F1U027				

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-1110-3		Sheet Number S00F1U028		Date 3/12/00
ISO/Drawing Number ALA2-1110		Couplant/Batch Number SONATRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS ANGLE / 4976		Model Number SONIC 136		Serial Number 136-898K
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA		Size .375
Examiner N/A		SNT Level N/A	Serial Number D15618		Frequency 2.25 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow LTD DEL TANK SHELL TO HEAD	
Location LMAX		* WMAX C/L		Component Temp °F 70	Thermometer S/N PTC 38081

FLOW

WELD EDGE 1.3" WELD EDGE

COMPONENT WELD Q COMPONENT

0.65" 0.65"

T. MEASUREMENTS

O.D. PROFILE

1.34 1.28 1.26 1.24 1.22 1.28 1.34 1.25 1.14 1.17 1.18 1.18 1.18

T. MEASUREMENT EACH .25 IN.

REMARKS: * 90° CW FROM ABOVE PIPE ELBOW

NDE LII/III Review <i>James Corda</i>	Level Date III 3-14-00	Non-Technical Review <i>Lynda Duke</i>	Date 3-14-00

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-1110-CS-6 (W4)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P002
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 75 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 96J05K 93D12K 93J02P	
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100 % of Area Coverage 100	Date 3/12/00
Ind. No. N/A	Results NRI	Indication Desc. / Exam Limitations / etc. N/A	Remarks N/A

Remarks:

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>JWB</i>	Assistant Examiner N/A	ASNT Level N/A	Initials 	Non-Technical Review <i>Lynda Duke</i>	Date 3-16-00
SNQ NDE Level II/III Review <i>Sam Cooks</i>		Date 3-16-00	Percentage of Code Coverage 100 %	ANII Review <i>Lynda Duke</i>		Date 3/17/00	

Figure 1

Revision 6

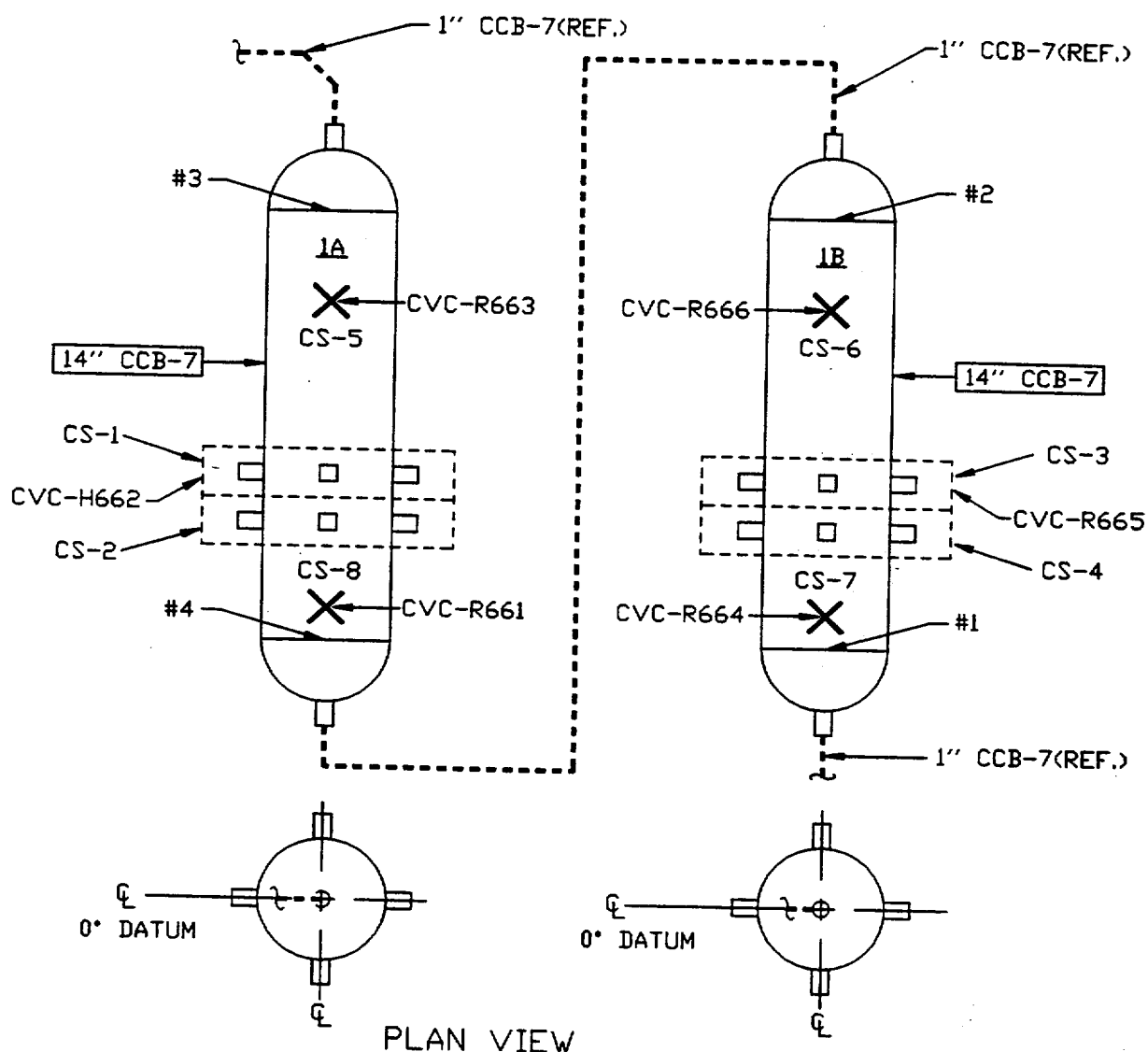
DRAWING ALA2-1120
EXCESS LETDOWN DELAY TANKS

[illegible]

CONTAINMENT

EXCESS LETDOWN DELAY TANKS

ALA2-1120



PLAN VIEW

MATERIAL:	1.250" T 14" SCH. 140
WELDS:	14" DIAMETER 43.96" CIRCUMFERENCE (TYP. 4 PLACES) (FNP-FIG-023)
WELDED SUPPORTS:	4 INTEGRALLY WELDED SUPPORTS - 4 LUGS PER SUPPORT AREA (FNP-FIG - 037) (LUG DIMENSIONS: 1 1/2" X 1 3/4" X 1 3/4")
SUPPORTS:	8 TOTAL SUPPORT COMPONENTS (FNP-FIG - 037)
CAL. BLOCK:	ALA-18
PIPING ISO'S:	D-518149 SH.1

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG	DEV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCM	FOR	WRH	
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for LETDOWN DELAY TANKS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

74

1

 CAD ALA21120
 AUTOCAD RAV-02

SHARED

FNP-0-NDE-100.5

Farley Nuclear Plant

PT-F-Form 001

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-1120-CS-2 (W4)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P004	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 75 °F <u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type Batch 96J05K 93D12K 93J02P				
Component Configuration WELDED ATTACHMENT			% of Length Coverage 100 % of Area Coverage 100	Date 3/12/00
Ind. No. N/A	Results NRI	Indication Desc. / Exam Limitations / etc. N/A	Remarks N/A	

Remarks:

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>JWB</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynnda Duke</i>	Date 3-16-00
SNC NDE Level II/III Review <i>Danny Carde L III</i>		Date 3-16-00	Percentage of Code Coverage 100 %	ANII Review <i>CSG</i>		Date 3/17/00	

Figure 1

Revision 6

RTYPE: L1.09

SOUTHERN NUCLEAR OPERATING COMPANY

N/A

DRAWING ALA2-4100
32" MAIN STEAM LINE-LOOP 1

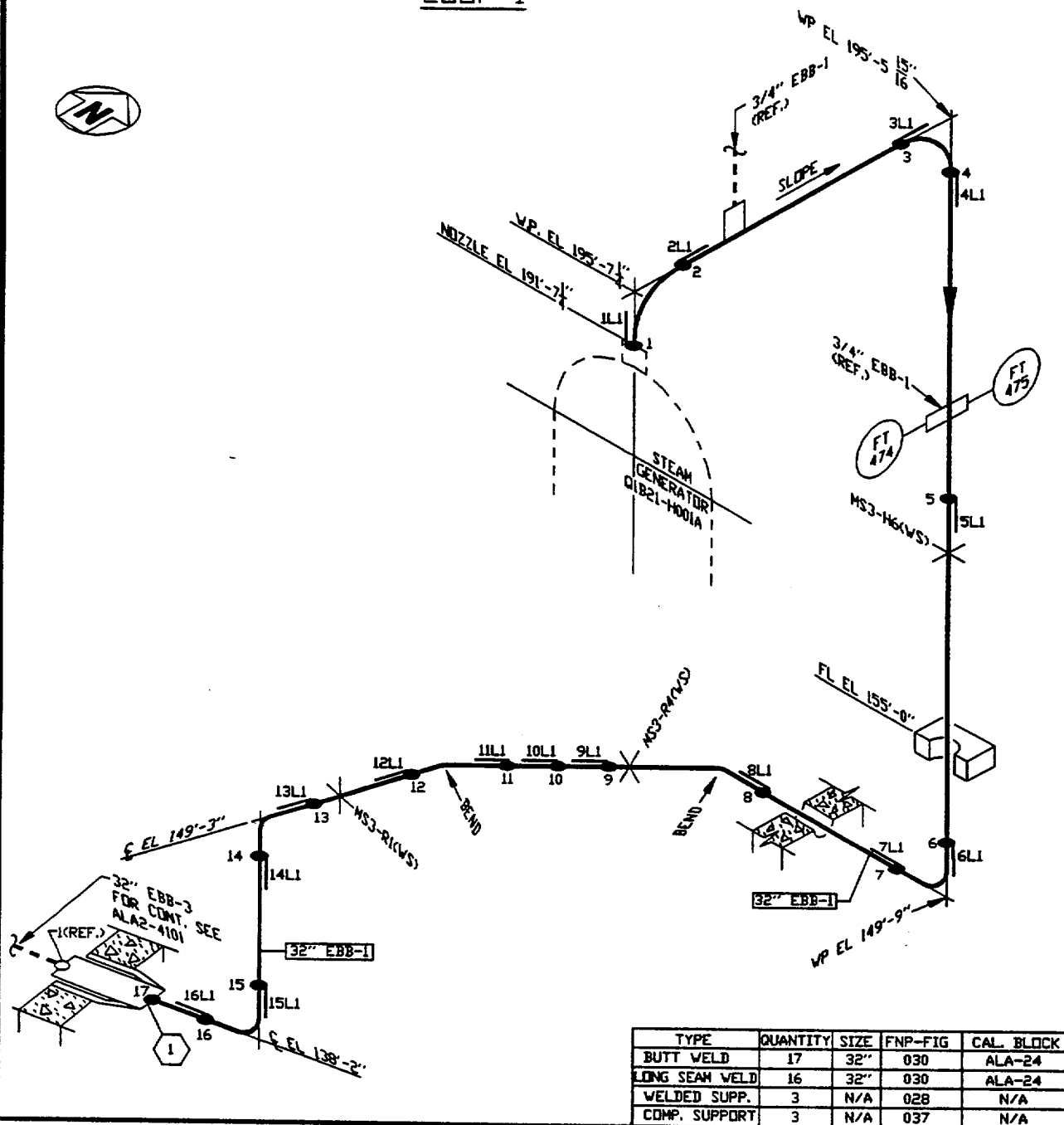
[illegible]

CONTAINMENT

32" MAIN STEAM LINE

ALA2-4100

LOOP 1



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	17	32"	030	ALA-24
LONG SEAM WELD	16	32"	030	ALA-24
WELDED SUPP.	3	N/A	028	N/A
COMP. SUPPORT	3	N/A	037	N/A

LINE NUMBER: Q-1-N11-EBB-1

BOUNDARY DIAGRAM D-351110 SH. 1

REFERENCE ISO'S D-514178 SH. 1

LINE SIZE: 32" EBB-1

2	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG	REV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCH/WRH	AH	IML	
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for N11 - MAIN STEAM

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

89

2

CAD ALA24100
AUTOCAD RAV-03

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

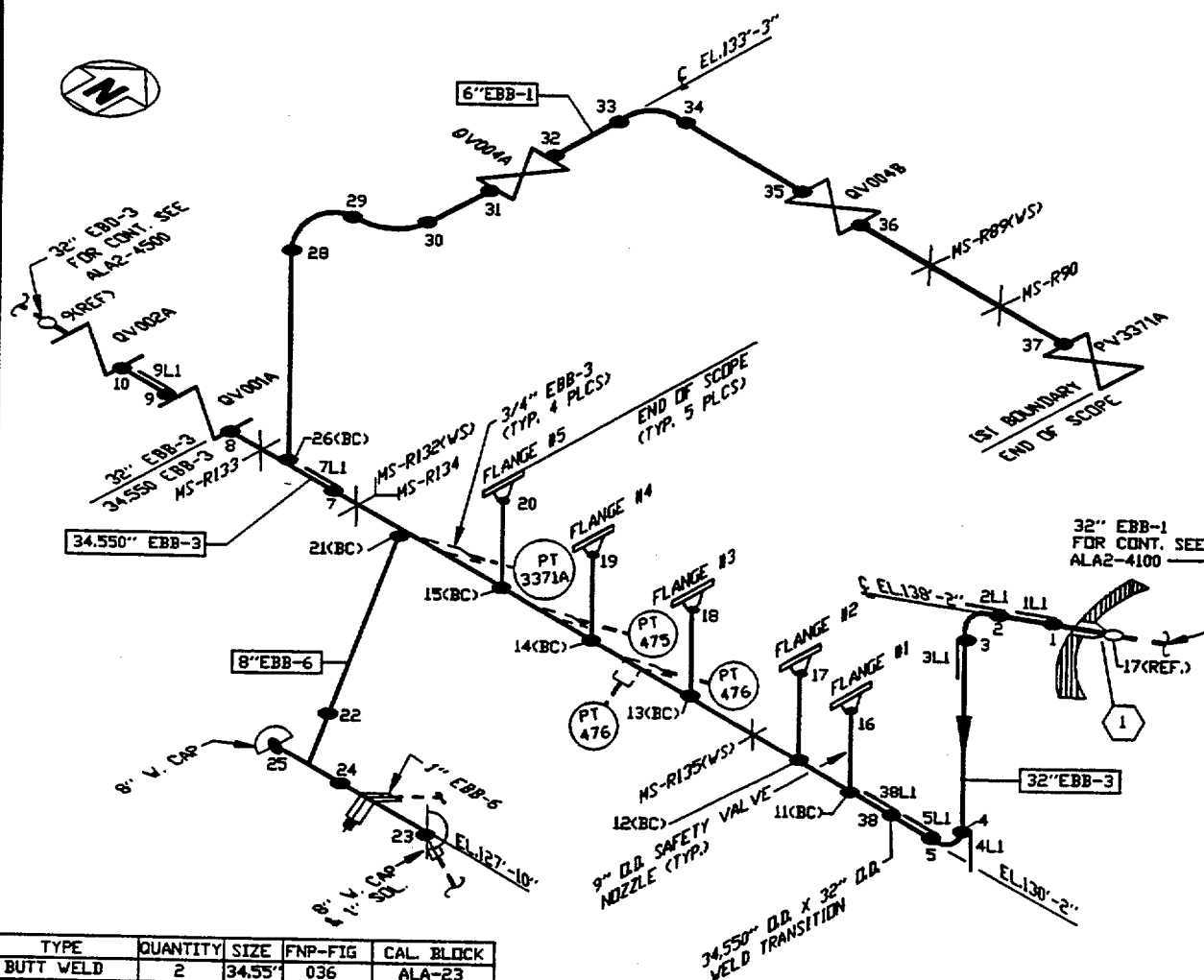
Plant/Unit Farley / 1	System/Support No. ALA2-4100-MS3-R4	WOWA/STP N/A	Sheet No. S00F1V001
Hanger Type ONE DIRECTIONAL RESTRAINT W/ATTACH		Type Exam/Technique VT-3 / DIRECT	Exam Date 3/6/00
Examiner / Initial SCOTT R. ERICKSON Sig. <i>Scott R. Erickson</i>		Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)
Examiner / Initial N/A Sig.		Level N/A	Tools FLASHLIGHT, MIRROR, SCALE
EXAMINATION LIST:		Acceptable/ Unacceptable	SKETCH (if applicable)
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments:			

Janny Cordes
L III
3-11-2000
ANET REVIEW: *CG Ward* 3/15/00

DRAWING ALA2-4101
32" MAIN STEAM LINE-LOOP 1

[illegible]

[illegible]



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	2	34.55"	036	ALA-23
BUTT WELD	8	32"	036	ALA-24
BUTT WELD	5	9"	030	ALA-30
BUTT WELD	4	8"	030	ALA-26
BUTT WELD	10	6"	030	ALA-27
BRANCH CONN.	5	9"	036	ALA-23
BRANCH CONN.	1	8"	034	ALA-23 & 26
BRANCH CONN.	1	6"	034	ALA-23 & 27
LONG SEAM WELD	2	34.55"	036	ALA-23
LONG SEAM WELD	6	32"	036	ALA-24
SOCKET WELD	0	N/A	N/A	N/A
WELDED SUPP.	3	N/A	028	N/A
COMP. SUPPORT	6	N/A	037	N/A

LINE NUMBER: Q-1-N11-EBB-1, 3, & 6

BOUNDARY DIAGRAM	D-351110 SH. 1

REFERENCE ISO'S	D-514303 SH. 1

LINE SIZE: 32"EBB-3, 34.55"EBB-3
9"EBB-3, 6"EBB-1, 8"EBB-6

D-514771 SH, 1

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG ^{FOR} DEV	☒	☒
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCM ^{FOR} WRH	AH	DML
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc. for N11 - MAIN STEAM

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

90

1

(CAD)	ALA24101	RAW
AUTOCAD		

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-1	Date 3/25/00	Sheet No. S00F1U189	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"								
Ax. dB		Size	.50	Cal. Temp.	68°								
Ref.	30	Frequency/Mode	2.25 / S	Cal. In	0845								
Scan	42	"A" Dimension	0.5"	Cal. Chk.	0927								
Reject	OFF	Nominal Angle	45	Cal. Out	1010	1T	80	2.0	1.19	1T	80	2.0	1.25
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	2T	40	4.0	2.30	2T	35	4.05	2.45
Mode	P/E	Cable Type	RG174	Reflector	HOLE	3T	30	6.0	3.45	3T	25	6.1	3.70
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2	4T	15	8.0	4.70	4T	10	8.1	4.70
						Calibration Remarks: NONE							

Comp. Temp.: **68°** °F Configuration: **PENETRATION TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld		Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)												
101"		1.5"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI			Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>				Date 3-25-00								
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-27-00	Percentage of Code Coverage N/A %				AMI Review <i>[Signature]</i>				Date 3/27/00									

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number <i>64-04</i> ALA/2-4101-1	Sheet Number S00F1U193	Date 3/25/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PEN TO PIPE		
Location LMAX TDC WMAX WELD CL			Component Temp °F Thermometer S/N 68° PTC 38081		
<u>Pen</u> COMPONENT <u>WELD EDGE</u> <u>WELD EDGE</u> COMPONENT <u>Pipe</u>					
T. MEASUREMENTS					
O.D. PROFILE					
T. MEASUREMENT EACH IN.					
REMARKS:					
NDE LII/III Review <i>Dan Cordes</i>		Level III	Date 3-27-00	Non-Technical Review <i>J. Eric Aycock</i>	
				Date 3-25-00	
Revision 1					

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-1L1	Date 3/25/00	Sheet No. S00F1U190	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"								
	Ax. dB Circ. dB	Size	.50	Cal. Temp.	68°								
Ref.	30 32	Frequency/Mode	2.25 / S	Cal. In	0845								
Scan	42 44	"A" Dimension	0.5"	Cal. Chk.	0930								
Reject	OFF	Nominal Angle	45	Cal. Out	1010								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **68°** °F Configuration: **PIPE LONG SEAM** Wo Location **WELD CL** Lo Location **CIRC WELD 1**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld 1.75"		Crown Width 1.0"		Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL				Extent of Parallel Scans (L) 2 - from NL to NL				From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-27-00					
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-27-00		Percentage of Code Coverage N/A %				ANR Review <i>[Signature]</i>				Date 3/27/00					

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-1L1	Sheet Number S00F1U194	Date 3/25/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE LONG SEAM		
Location LMAX CL WELD 1 WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	
<u>FLOW</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE I/II/III Review <i>John Cordis</i>		Level III	Date 3-27-00	Non-Technical Review <i>J. Eric Ryceck</i>	Date 3-25-00
					Revision 1

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNFP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-2** Date **3/25/00** Sheet No. **S00F1U191** Page **1** of **2**
 Procedure/Rev./TCN **FNFP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"									
Ax. dB		Circ. dB		Cal. Temp.	68°									
Ref.	30	32	Size	.50	Cal. In									0845
Scan	42	44	Frequency/Mode	2.25 / S	Cal. Chk.									0950
Reject	OFF		Nominal Angle	45	Cal. Out	1010								
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	12'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **68°** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI						W1 Wmax W2	S1 Smax S2	1" < -- C/L -- > 1"	
2		1	50%	(1)	0"	(1)	3.6"	2.7	1.55 1.3 1.3	(1) 360°
5		N/A								
7		N/A								
8		N/A								

Examination/Limitation Remarks: **NONE**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
101"	1.2"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner		Level		Assistant Examiner				Level		Non-Technical Review				Date						
GEORGE A. MORINI		II		N/A				N/A		<i>[Signature]</i>				3-28-00						
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review				Date						
<i>[Signature]</i>				3-27-00		N/A %				<i>[Signature]</i>				3/30/00						

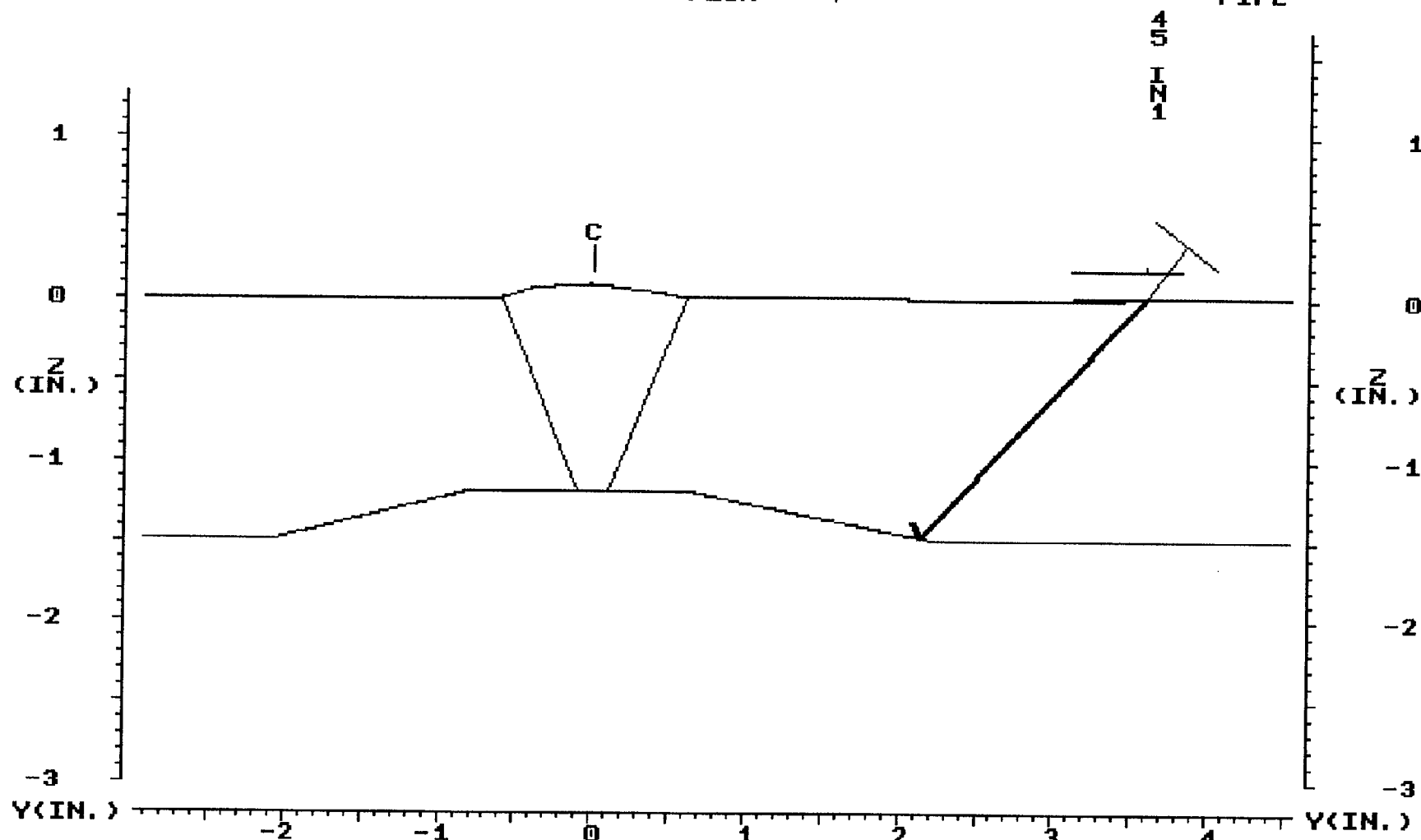
Figure 1

Revision 7

TEE

FLOW →

PIPE



45 IN1	SET	1R16020.DAT 1R16020A.SCR						SET
1.56	DEP							DEP
2.20	MP	45 DEG INDICATION # 1 - ID GEOMETRY						MP
43.20	TOF	COMPARES WITH 1988 DATA (SEE 1988 IER 008)						TOF
	ARC							ARC
	GATE							GATE
0.050	STEP	DR CORDES L/III <i>Jac</i>						STEP
	EXIT	MAKERAY/UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT	EXIT
PLANT: FARLEY 1		3/27/00		CIRC. POS.: TYP				
SYSTEM: MAIN STEAM				ANALYST: DR CORDES L/III				
COMPONENT: ALA2-4101-2		11:08		CAL. SHEET: SOME 10191				

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-2	Sheet Number S00F1U195	Date 3/25/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW		
Location LMAX	TDC	WMAX	WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081
<u>Pen</u> <u>WELD EDGE</u> <u>FLOW</u> <u>WELD EDGE</u> <u>ELbow</u> <u>COMPONENT</u> 1.9" <u>WELD Q</u> <u>COMPONENT</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
1.5 1.2 1.3 1.3 1.5					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Darryl Cordes</i>		Level III	Date 3-27-00	Non-Technical Review <i>John W. Bell</i>	Date 3-25-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-2L1	Date 3/20/00	Sheet No. S00F1U093	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A		Couplant/Batch No. SONOTRACE 40 / 94243		Thermometer SN/Cal Due Date 38081 / 8/27/2000
Linearity Sheet No. S00F1L003				

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"	1T	80	2.00	1.19	1T	80	2.00	1.25
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.00	2.30	2T	35	4.05	2.44
Ref.	30	Frequency/Mode	2.25 / S	Cal. In	1245	3T	30	6.00	3.45	3T	25	6.10	3.70
Scan	42	"A" Dimension	.5"	Cal. Chk.	1453	4T	15	8.00	4.70	4T	10	8.10	4.70
Reject	OFF	Nominal Angle	45	Cal. Out	1635	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796424								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **68** °F Configuration: **ELBOW LONG SEAM** Wo Location **WELD CL** Lo Location **CIRC WELD 2**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

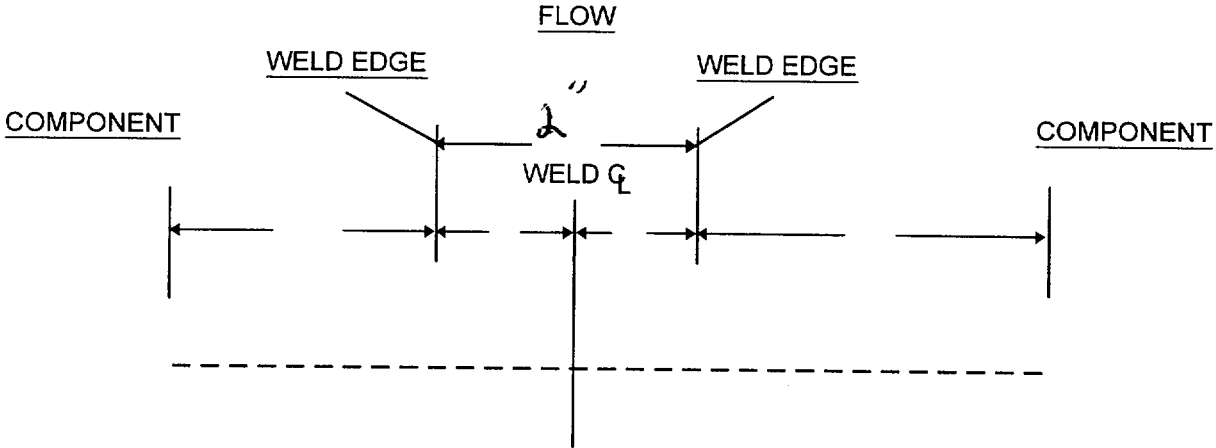
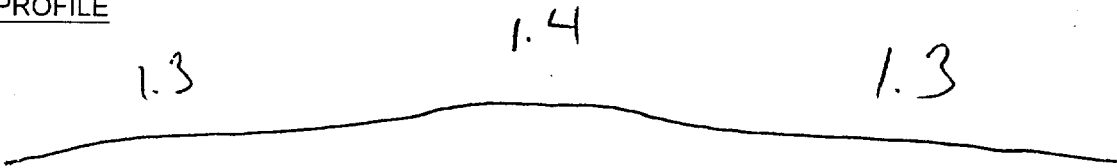
Long Seam on O.R. of Elbow and 3-22-00

Total Length of Weld		Crown Width		Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
41"	2.0"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI						Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Darryl Cordis</i>				Date 3-23-00		
SNC NDE Level II/III Review <i>Darryl A. Cordis</i>						Date 3-22-00		Percentage of Code Coverage N/A %				ANII Review <i>C. G. Ward</i>				Date 3/27/00				

Figure 1

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Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-2L1		Sheet Number S00F1U115		Date 3/21/00
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884		Model Number SONIC 136	Serial Number 136-898K	
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow ELBOW LONG SEAM		
Location LMAX CIRC WELD 2 WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	
<u>FLOW</u> 					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u> 					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Darryl D. Lofgren</i>		Level III	Date 3-22-00	Non-Technical Review <i>Darryl Condra</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-2L2	Date 3/21/00	Sheet No. S00F1U111
Procedure/Rev./TCN FNP-0-NDE100.31 / N/A / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"	1T	80	2.00	1.19	1T	80	2.00	1.25
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.00	2.30	2T	35	4.05	2.44
Ref.	30	Frequency/Mode	2.25 /	Cal. In	1245	3T	30	6.00	3.45	3T	25	6.10	3.70
Scan	42	"A" Dimension	.5"	Cal. Chk.	1501	4T	15	8.00	4.70	4T	10	8.10	4.70
Reject	OFF	Nominal Angle	45	Cal. Out	1635	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **68** °F Configuration: **ELBOW LONG SEAM - IR** Wo Location **WELD CL** Lo Location **CIRC WELD 2**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **NONE**

Long Seam on IR of Elbow Bal 3-22-00

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
92.0"	2.0"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL				
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A		Level N/A	Non-Technical Review <i>Dany Cards</i>		Date 3-23-00			
SNC NDE Level II/III Review <i>Dany A. Lopez</i>		Date 3-22-00	Percentage of Code Coverage N/A %		ANII Review <i>EGW</i>		Date 3/27/00				

Figure 1

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Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-2L2	Sheet Number S00F1U112	Date 3/21/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow ELBOW LONG SEAM - IR		
Location LMAX CIRC WELD 2 WMAX WELD CL		Component Temp °F 68°	Thermometer S/N PTC 38081		
<u>FLOW</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u> <i>1.2</i> <i>1.3</i> <i>1.3</i>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Darryl A. Lofgren</i>		Level III	Date 3-22-00	Non-Technical Review <i>Darryl Corde</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-3	Date 3/20/00	Sheet No. S00F1U094	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"	1T	80	2.00	1.19	1T	80	2.00	1.25
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.00	2.30	2T	35	4.05	2.44
Ref.	30	Frequency/Mode	2.25 / S	Cal. In	1245	3T	30	6.00	3.45	3T	25	6.10	3.70
Scan	42	"A" Dimension	.5"	Cal. Chk.	1512	4T	15	8.00	4.70	4T	10	8.10	4.70
Reject	OFF	Nominal Angle	45	Cal. Out	1635	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **68 °F** Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **OR ELBOW**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
103"	2.2"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-23-00						
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/25/00								

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-3	Sheet Number S00F1U099	Date 3/20/00		
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY		
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOHN W. BELL	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A			
Component Configuration/Flow ELBOW TO PIPE					
Location LMAX EX DOSE WMAX WELD CL		Component Temp °F 68		Thermometer S/N PTC 38081	
<u>ELBOW</u> <u>FLOW</u> <u>PIPE</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u> 1.3" 1.3" 1.125"					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Darryl D. Gifford</i>		Level III	Date 3-22-00	Non-Technical Review <i>Darryl Cordus</i>	
				Date 3-22-00	

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNFP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-3L1	Date 3/20/00	Sheet No. S00F1U095	Page 1 of 1
Procedure/Rev./TCN FNFP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"								
Ax. dB		Size	.50	Cal. Temp.	68°								
Ref.	30	Frequency/Mode	2.25 /	Cal. In	1245								
Scan	42	"A" Dimension	.5"	Cal. Chk.	1514								
Reject	OFF	Nominal Angle	45	Cal. Out	1635	1T	80	2.00	1.19	1T	80	2.00	1.25
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	2T	40	4.00	2.30	2T	35	4.05	2.44
Mode	P/E	Cable Type	RG174	Reflector	HOLE	3T	30	6.00	3.45	3T	25	6.10	3.70
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2	4T	15	8.00	4.70	4T	10	8.10	4.70
						Calibration Remarks: NONE							

Comp. Temp.: **68** °F Configuration: **PIPE LONG SEAM** Wo Location **WELD CL** Lo Location **CIRC WELD 3**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld 4"		Crown Width 2.0"		Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI				Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>	
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-22-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>		Date 3-23-00 3/25/00	

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-3L1	Sheet Number S00F1U100	Date 3/20/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE LONG SEAM		
Location LMAX CIRC WELD 3 WMAX WELD CL			Component Temp °F 68	Thermometer S/N PTC 38081	
<u>FLOW</u> WELD EDGE WELD EDGE COMPONENT COMPONENT WELD Q 2" 1"					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<i>1.375 1.375" 1.375</i>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Barry A. Hoff</i>		Level III	Date 3-22-00	Non-Technical Review <i>Dan Corda</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-4	Date 3/20/00	Sheet No. S00F1U096	Page / of /
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																					
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	<table><tr><th>Cal. Refl.</th><th>Signal Amp.</th><th>Sweep Div.</th><th>Wmax</th><th>Cal. Refl.</th><th>Signal Amp.</th><th>Sweep Div.</th><th>Wmax</th></tr><tr><td>1T</td><td>80</td><td>2.00</td><td>1.19</td><td>1T</td><td>80</td><td>2.00</td><td>1.25</td></tr><tr><td>2T</td><td>40</td><td>4.00</td><td>2.30</td><td>2T</td><td>35</td><td>4.05</td><td>2.44</td></tr><tr><td>3T</td><td>30</td><td>6.00</td><td>3.45</td><td>3T</td><td>25</td><td>6.10</td><td>3.70</td></tr><tr><td>4T</td><td>15</td><td>8.00</td><td>4.70</td><td>4T</td><td>10</td><td>8.10</td><td>4.70</td></tr></table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.00	1.19	1T	80	2.00	1.25	2T	40	4.00	2.30	2T	35	4.05	2.44	3T	30	6.00	3.45	3T	25	6.10	3.70	4T	15	8.00	4.70	4T	10	8.10	4.70	Calibration Remarks: NONE
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																							
1T	80	2.00	1.19	1T	80		2.00	1.25																																							
2T	40	4.00	2.30	2T	35		4.05	2.44																																							
3T	30	6.00	3.45	3T	25		6.10	3.70																																							
4T	15	8.00	4.70	4T	10	8.10	4.70																																								
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"																																										
Ax. dB		Circ. dB		Cal. Temp.	68°																																										
Ref.	30	31		Cal. In	1245																																										
Scan	42	43		Cal. Chk.	1540																																										
Reject	OFF			Cal. Out	1635																																										
Frequency	2.25			Ref. Blk. No.	796484																																										
Mode	P/E			Reflector	HOLE																																										
Damping	500 OHMS			Amplitude/Sweep	20%/1.2																																										

Comp. Temp.: **68** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **INTRODOSE**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

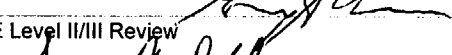
Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)								
103"	1.5"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review				Date				
GEORGE A. MORINI				II		N/A				N/A						3-23-00				
SNC NDE Level II/III Review						Date		Percentage of Code Coverage				AMT Review				Date				
						3-27-00		100 %								3/25/00				

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-4	Sheet Number S00F1U101	Date 3/20/00		
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY		
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOHN W. BELL	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A			
Component Configuration/Flow PIPE TO ELBOW					
Location LMAX	IN DOSE	WMAX	WELD CL	Component Temp °F 68	Thermometer S/N PTC 38081

PIPE WELD EDGE FLOW WELD EDGE ELBOW

COMPONENT WELD Q COMPONENT

T. MEASUREMENTS

O.D. PROFILE

1.125" 1.2" 1.3"

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Gary A. Laffin</i>	Level Date III 3-22-00	Non-Technical Review <i>Darryl Corda</i>	Date 3-23-00

Revision 1

SHARED

FNP-0-NDE-100.11

Farley Nuclear Plant

MT-F-Form 002

Magnetic Particle Examination Record

Southern Nuclear Operating Company

Unit 1	Component No. ALA2-4101-4	Procedure/Rev./TCN FNP-0-NDE-100.11 / 4 / N/A	Sheet No. S00F1M028	Page 1 of 1
<u>Thermometer</u> Mfg./Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 65 ° F		<u>Magnetizing Yoke</u> Mfg.: MAGNAFLUX Power AC Serial No: W13577 Pole Spacing: 8" Field Indicator S/N: N/A Field Indicator Acceptable [Y/N] N/A	<u>MT Materials</u> Mfg.: MAGNAFLUX Batch Number: 98C020 Color: 8A RED Type: N/A	
Component Configuration PIPE TO ELBOW		% of Length Coverage 100% % of Area Coverage 100%	Date 3/24/00	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A	Remarks NONE	

Remarks: **NONE**

Primary Examiner GEORGE A. MORINI	ASNT Level II	Initials <i>[Signature]</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>[Signature]</i>	Non-Technical Review <i>[Signature]</i>	Date 3-25-00
SNC NDE Level II/III Review <i>[Signature]</i> L/III			Date 3-27-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/28/00

Figure 3

Revision 4

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-4L1	Date 3/20/00	Sheet No. S00F1U097	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"	1T	80	2.00	1.19	1T	80	2.00	1.25
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.00	2.30	2T	35	4.05	2.44
Circ. dB		Frequency/Mode	2.25 / S	Cal. In	1245	3T	30	6.00	3.45	3T	25	6.10	3.70
Ref.	30	"A" Dimension	.5"	Cal. Chk.	1523	4T	15	8.00	4.70	4T	10	8.10	4.70
Scan	42	Nominal Angle	45	Cal. Out	1635	Calibration Remarks: NONE							
Reject	OFF	Measured Angle	45	Ref. Blk. No.	796484								
Frequency	2.25	Cable Type	RG174	Reflector	HOLE								
Mode	P/E	Cable Length	12'	Amplitude/Sweep	20%/1.2								
Damping	500 OHMS												

Comp. Temp.: **68** °F Configuration: **ELBOW LONG SEAM** Wo Location **WELD CL** Lo Location **CIRC WELD 4**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Long Seam on O.R. of Elbow Bal 3-22-00

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)																													
42		2.0"		5 (L)		NL		2 (L)		NL		7 & 8 (W)		NL		5 - from		NL		to		NL		2 - from		NL		to		NL		From (5)		NL		to		(2)		NL	
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review				Date																									
GEORGE A. MORINI				II		N/A				N/A		Darryl Corde				3-23-00																									
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review		Date																													
Darryl Corde				3-22-00		N/A %				EGH				3/25/00																											

Figure 1

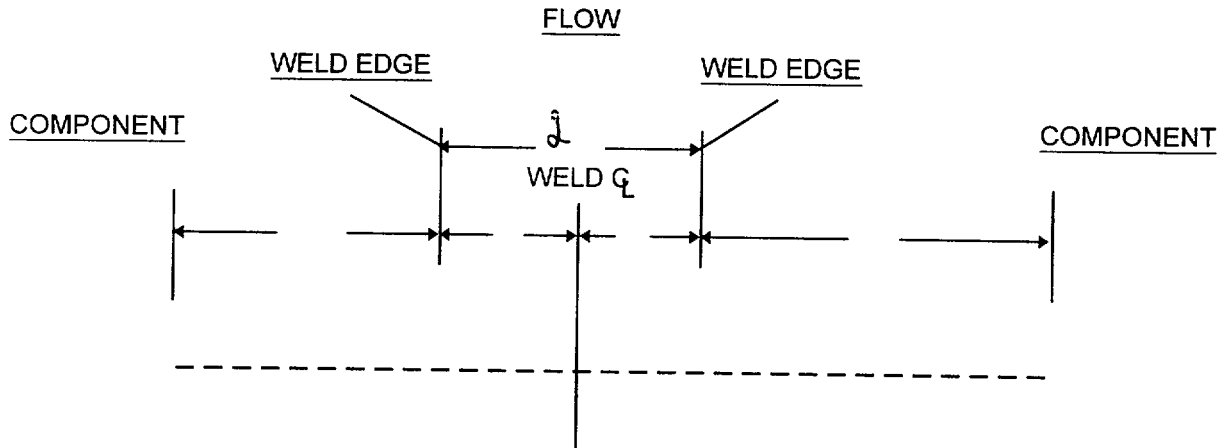
Revision 7

SHARED

Ultrasonic Weld Profile Record Southern Nuclear Operating Company

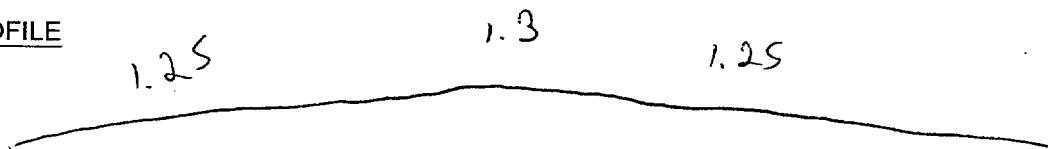
FNP-0-NDE-100.35

Unit 1	Weld Number ALA2-4101-4L1	Sheet Number S00F1U114	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow ELBOW LONG SEAM	
Location LMAX CIRC WELD 4 WMAX WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081	



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Danny A. Loftis</i>	Level III	Date 3-22-00	Non-Technical Review <i>Danny Carde</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page
1	ALA2-4101-4L2	3/21/00	S00F1U110	1 of 1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38081 / 8/27/2000	S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"	1T	80	2.00	1.19	1T	80	2.00	1.25
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.00	2.30	2T	35	4.05	2.44
Ref.	30	Frequency/Mode	2.25 / S	Cal. In	1245	3T	30	6.00	3.45	3T	25	6.10	3.70
Scan	42	"A" Dimension	.5"	Cal. Chk.	1501	4T	15	8.00	4.70	4T	10	8.10	4.70
Reject	OFF	Nominal Angle	45	Cal. Out	1635	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: 68 °F Configuration: ELBOW LONG SEAM - IR Wo Location **WELD CL** Lo Location **CIRC WELD 4**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: NONE

Long. Seam on IR of Elbow Hal 3-22-00

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)		Extent of Parallel Scans (L)	
92"	2.0"	5 (L) NL 2 (L) NL 7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL	
Primary Examiner		Level	Assistant Examiner		Level	Non-Technical Review
GEORGE A. MORINI <i>[Signature]</i>		II	N/A		N/A	<i>[Signature]</i>
SNC NDE Level II/III Review			Date	Percentage of Code Coverage	ANII Review	Date
<i>[Signature]</i>		III	3-22-00	N/A %	<i>[Signature]</i>	3-23-00 3/25/00

Figure 1

Revision 7

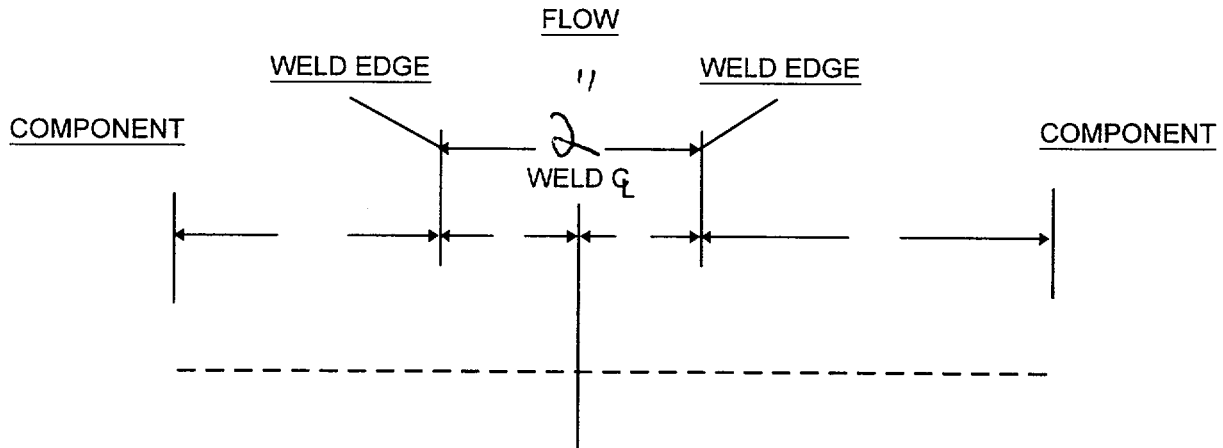
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

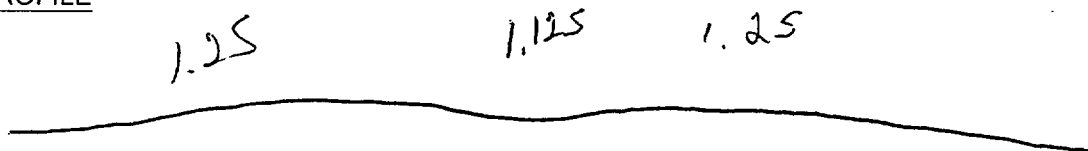
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-4L2	Sheet Number S00F1U113	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow ELBOW LONG SEAM - IR	
Location LMAX CIRC WELD 4 WMAX WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081	



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Darryl A. Hoff</i>	Level III	Date 3-22-00	Non-Technical Review <i>Darryl Cordes</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-5	Date 3/20/00	Sheet No. S00F1U098	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.00</td> <td>1.19</td> <td>1T</td> <td>80</td> <td>2.00</td> <td>1.25</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.00</td> <td>2.30</td> <td>2T</td> <td>35</td> <td>4.05</td> <td>2.44</td> </tr> <tr> <td>3T</td> <td>30</td> <td>6.00</td> <td>3.45</td> <td>3T</td> <td>25</td> <td>6.10</td> <td>3.70</td> </tr> <tr> <td>4T</td> <td>15</td> <td>8.00</td> <td>4.70</td> <td>4T</td> <td>10</td> <td>8.10</td> <td>4.70</td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.00	1.19	1T	80	2.00	1.25	2T	40	4.00	2.30	2T	35	4.05	2.44	3T	30	6.00	3.45	3T	25	6.10	3.70	4T	15	8.00	4.70	4T	10	8.10	4.70
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																						
1T	80	2.00	1.19	1T	80		2.00	1.25																																						
2T	40	4.00	2.30	2T	35		4.05	2.44																																						
3T	30	6.00	3.45	3T	25		6.10	3.70																																						
4T	15	8.00	4.70	4T	10	8.10	4.70																																							
Serial No.	136-898K	Serial No.	009KTL	Thickness	1.20"																																									
Ax. dB		Size	.50	Cal. Temp.	68°																																									
Ref.	30	Frequency/Mode	2.25 / S	Cal. In	1245																																									
Scan	42	"A" Dimension	.5"	Cal. Chk.	1453	Calibration Remarks: NONE																																								
Reject	OFF	Nominal Angle	45	Cal. Out	1635																																									
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484																																									
Mode	P/E	Cable Type	RG174	Reflector	HOLE																																									
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	20%/1.2																																									

Comp. Temp.: **68** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- >1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **EXAMINED FROM ELBOW SIDE WITH ALA-24. REFER TO S00F1U044 FOR PIPE (HEADER) SIDE EXAM.**

Total Length of Weld 101"	Crown Width 1.5"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	N/A	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	N/A	to	N/A	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-23-00						
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/25/00								

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-5	Date 3/13/00	Sheet No. S00F1U044	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	41.8		41.8	Frequency/Mode	2.25 / S								
Scan	53.8		53.8	"A" Dimension	.75								
Reject	OFF	Nominal Angle	45	Cal. Chk.	0955								
Frequency	2.25	Measured Angle	45	Cal. In	0830								
Mode	P/E	Cable Type	RG174	Cal. Out	1300								
Damping	500 OHMS	Cable Length	12'	Ref. Blk. No.	796484								
				Reflector	HOLE	Calibration Remarks: NONE							
				Amplitude/Sweep	60% / 1.1								

Comp. Temp.: **57** °F Configuration: **ELBOW TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **EXAMINED FROM HEADER SIDE 2.3T WITH ALA-23. REFER TO S00F1U098 FOR ELBOW SIDE EXAM. CIRCUMFERENCE ON THE HEADER IS 110" (OD TRANSITION).**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
101"	1.5"	5 (L)	N/A	2 (L)	NL	7 & 8 (W)	NL	5 - from	N/A	to	N/A	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner					Level		Assistant Examiner					Level		Non-Technical Review			Date			
GEORGE A. MORINI					II		N/A					N/A					3-23-00			
SNC NDE Level II/III Review					Date		Percentage of Code Coverage					AMR Review		Date						
 L/III					3-23-00		N/A							3/25/00						

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record

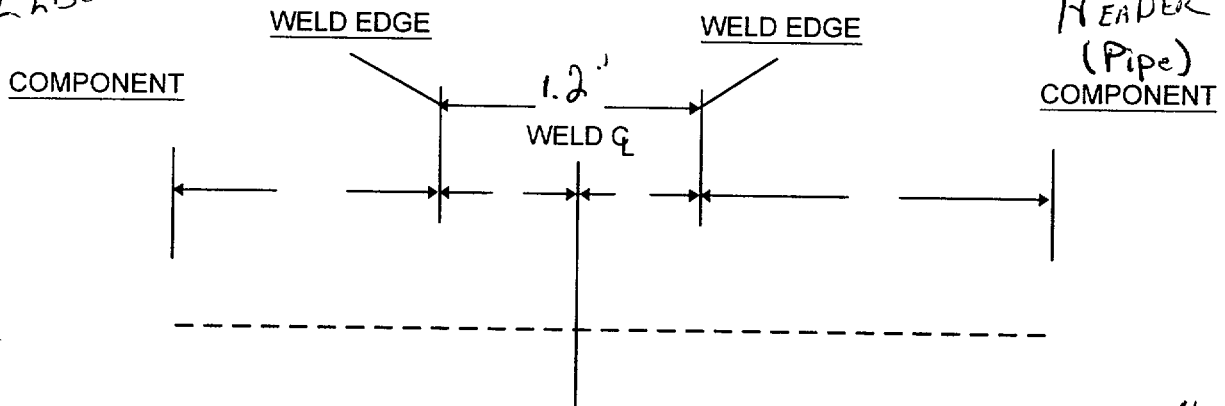
FNP-0-NDE-100.35

Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-5	Sheet Number S00F1U102	Date 3/20/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	
		Component Configuration/Flow ELBOW TO PIPE	
Location LMAX	TDC	WMAX	WELD CL
		Component Temp °F 68	Thermometer S/N PTC 38081

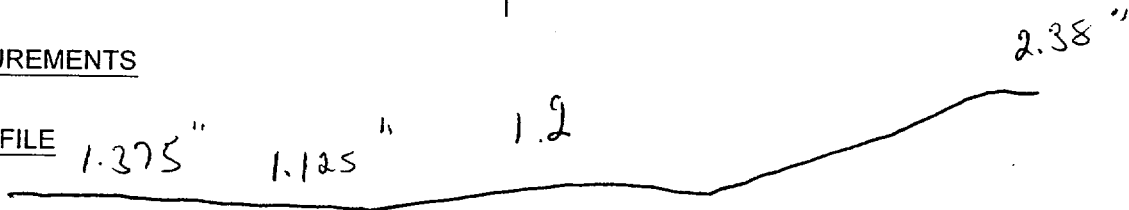
ELBOW

FLOW



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Henry A. Kipton</i>	Level III	Date 3-22-00	Non-Technical Review <i>Dan Corda</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-5L1	Date 3/13/00	Sheet No. S00F1U045	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	41.8		41.8	Frequency/Mode	2.25 / S								
Scan	53.8		53.8	"A" Dimension	.75								
Reject	OFF	Nominal Angle	45	Cal. Chk.	1200								
Frequency	2.25	Measured Angle	45	Cal. In	0830								
Mode	P/E	Cable Type	RG174	Cal. Out	1300								
Damping	500 OHMS	Cable Length	12'	Ref. Blk. No.	796484								
				Reflector	HOLE	Calibration Remarks: NONE							
				Amplitude/Sweep	60% / 1.1								

Comp. Temp.: **57** °F Configuration: **PIPE LONG SEAM** Wo Location **C/L** Lo Location **CIRC WELD 285**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

WELD ATTACHMENT LIMITS 2 SCAN FOR 13.75"

Total Length of Weld 144"		Crown Width 3.2"	Total Length of Weld Examined 5 (L) NL 2 (L) 131" 7 & 8 (W) NL		Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL				Extent of Parallel Scans (L) From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI			Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>Lynda Duke</i>			Date 3-17-00	
SNC NDE Level II/III Review <i>Dan Corda L/III</i>				Date 3-20-00	Percentage of Code Coverage N/A %			ANII Review <i>CF Ward</i>			Date 3/23/00	

Figure 1

Revision 7

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-7	Date 3/13/00	Sheet No. S00F1U032	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"								
Ax. dB		Size	.50 X 1.0	Cal. Temp.	70								
Circ. dB		Frequency/Mode	2.25 / S	Cal. In	0830								
Ref.	41.8					1T	80	3.0	2.25	1T	80	3.0	2.25
Scan	53.8					2T	35	6.0	4.5	2T	35	6.0	4.5
Reject	OFF					3T	20	9.0	6.75	20	20	9.0	6.75
Frequency	2.25					Calibration Remarks: NONE							
Mode	P/E												
Damping	500 OHMS												
		Nominal Angle	45	Cal. Out	1300								
		Measured Angle	45	Ref. Blk. No.	796484								
		Cable Type	RG174	Reflector	HOLE								
		Cable Length	12'	Amplitude/Sweep	60% / 1.1								

Comp. Temp.: **57** °F Configuration: **PIPE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

TWO 14" WELD ATTACHMENTS, ONE 8" BRANCH CONNECTION AND ONE 3" LINE LIMITS 5 SCAN

Total Length of Weld 110"	Crown Width 2.3"	Total Length of Weld Examined 5 (L) 71" 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL				Extent of Parallel Scans (L) From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review Lynda Duke			
SNC NDE Level II/III Review Wang Cordes L/III		Date 3-14-99		Percentage of Code Coverage N/A %				ANII Review CGH		Date 3-14-00			

Figure 1

Revision 7

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page	of
1	ALA2-4101-7L1	3/13/00	S00F1U033	1	1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.		
FNP-0-NDE-100.31 / 7 / N/A	SONATRACE 40 / 94243	38081 / 8/27/2000	S00F1L005		

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23									
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Ax. dB		Circ. dB		Size	.50 X 1.0	Cal. Temp.								
Ref.	41.8	41.8	Frequency/Mode	2.25 / S	Cal. In	0830	1T	80	3.0	2.25	1T	80	3.0	2.25
Scan	53.8	53.8	"A" Dimension	.75	Cal. Chk.	1130	2T	35	6.0	4.5	2T	35	6.0	4.5
Reject	OFF		Nominal Angle	45	Cal. Out	1300	3T	20	9.0	6.75	3T	20	9.0	6.75
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	12'	Amplitude/Sweep	60% / 1.1								

Comp. Temp.: 57 °F Configuration: PIPE LONG SEAM Wo Location C/L Lo Location CIRC WELD 7

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

PIPE CLAMP FOR MS R133 RESTRICTS ALL SCANS FOR 18"

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)									
30"	2"	5 (L) 12"	2 (L) 12"	7 & 8 (W) 12"	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner	Level	Assistant Examiner			Level	Non-Technical Review			Date								
GEORGE A. MORINI	II	N/A			N/A	Lynda Duke			3-14-00								
SNG-NDE Level II/III Review	Date	Percentage of Code Coverage			ANII Review			Date									
Samy Cordes	3-14-99	N/A %			C. G. W. S.			3/14/00									

Figure 1

Revision 7

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

SHARED

N/A
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-8** Date **3/9/00** Sheet No. **S00F1U216** Page **1** of **2**
 Procedure/Rev./TCN **N/A / N/A / N/A** Couplant/Batch No. **N/A / N/A** Thermometer SN/Cal Due Date **N/A / N/A** Linearity Sheet No. **N/A**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	Serial No.	Transducer Mfg.	Serial No.	Cal. Blk. No.	Thickness	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Ref.	Ax. dB	Circ. dB	Size	Cal. Temp.	Cal. In								
Scan			Frequency/Mode	Cal. Chk.	Cal. Out								
Reject			"A" Dimension	Ref. Blk. No.	Reflector								
Frequency			Nominal Angle	Amplitude/Sweep									
Mode			Measured Angle										
Damping			Cable Type										
			Cable Length										

Calibration Remarks: **NONE**

Comp. Temp.: **N/A** °F Configuration: **PIPE TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length	Lmax	L2	Reference Measurement	W1	Wmax	W2	Sweep Position	S1	Smax	S2	Thickness	1" <-- C/L --> 1"	Notes:

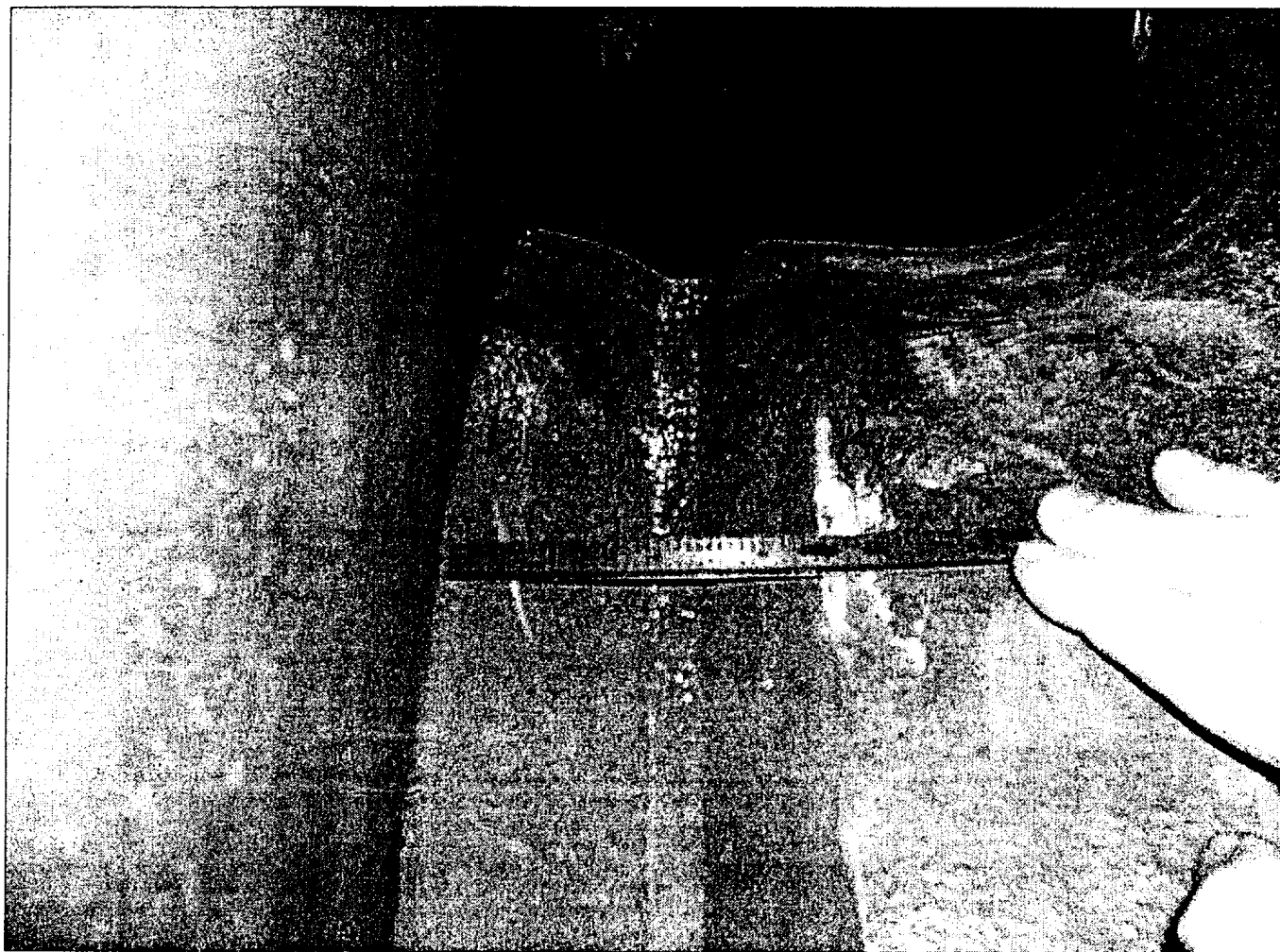
N/A

Examination/Limitation Remarks: **MEANINGFUL ULTRASONIC INSPECTION IMPRACTICAL DUE TO WELD CONFIGURATION AND SUPPORT INTERFERENCE. PERFORMED SUPPLEMENTAL VT-1 EXAMINATION. SEE ATTACHED PICTURE AND VISUAL EXAMINATION REPORT.**

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)	Extent of Parallel Scans (L)
N/A	N/A	5 (L) N/A 2 (L) N/A 7 & 8 (W) N/A	5 - from N/A to N/A	2 - from N/A to N/A
Primary Examiner	Level	Assistant Examiner	Level	Non-Technical Review
PAUL D'VALERIO	II	N/A	N/A	N/A
SNC NDE Level II/III Review	Date	Percentage of Code Coverage		ANII Review
Danny Conner	3-29-00	N/A %		N/A
				Date
				3-29-00
				Date
				3/30/00

Figure 1

Revision 7



Name: ala2-4101-8.jpg
Dimensions: 1024 x 768 pixels

PIPE

WELD

VALVE

SUPPORT MS-R133

SHARED

FARLEY NUCLEAR PLANT

VISUAL EXAMINATION RECORD VT-1 RTYPE: L1.09

FNP-0-NDE-100.21

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit FARLEY / 1	Line Number/Examination Area/Weld No. ALA2-4101-8	Drawing Number ALA2-4101-8	Sheet No. S00F1V064
Photos ☒ Yes ☐ B/W ☐ No ☒ Color	Sketch ☐ Yes ☒ No	Resolution ☐ 1/32" Division (Scale) ☒ 1/32" Line (Gray Card)	Technique ☒ Direct ☐ Remote ☐ Video
Equipment ☒ Mirror ☐ Magnifier ☐ CCTV		Tools ☒ Scale ☐ Depth Gauge ☐ Level ☐ Micrometer ☐ Comparator ☐ Caliper ☐ Weld Gauge	
Lighting ☐ Ambient ☒ Flashlight ☐ Droplight		WO/WA Procedure No. FNP-0-NDE-100.21 Revision No. 1 Examiner/Initial PAUL D'VALERIO Sig. <i>Paul D'Valerio</i> Examiner/Initial N/A Sig. _____ Date (Month/Day/Year) 3/9/00	
		Level II	

WELDS & BASE MATERIAL VT-1

Ground Blend Material
Undercut
Corrosion Build-Up
Gouges
Evidence of Leakage
Arc Strikes
Cracks
Other**

Sat	Un-Sat	N/A
☐	☐	☒
☐	☐	☒
☒	☐	☐
☒	☐	☐
☒	☐	☐
☒	☐	☐
☒	☐	☐
☒	☐	☐

* Provide details on unsat areas by use of supplemental data sheet.

** Provide details on other areas examined.

BOLTS, STUDS, AND WASHERS VT-1

Loose Members
Cracks
Corrosion
Gouges
Thread Damage
Deformation
Protective Coating
Evidence of Leakage
Other **

Sat	Un-Sat	N/A
☐	☐	☐
☐	☐	☐
☐	☐	☐
☐	☐	☐
☐	☐	☐
☐	☐	☐
☐	☐	☐
☐	☐	☐

Comments

VT-1 PERFORMED FOR VOLUMETRIC LIMITATIONS. REFERENCE ULTRASONIC DATA SHEET S00F1U216.

Danny Cordua L/III

AND REVIEW: C. G. Ward 3/30/00

Figure 1

Revision 1

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNFP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-9	Date 3/9/00	Sheet No. S00F1U002	Page 1 of 1
Procedure/Rev./TCN FNFP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	72	2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150	3T	20	6.0	3.5				
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1411	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1515	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: **70** °F Configuration: **VALVE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"< --	C/L	
2	●			N/A													
7	●			N/A													
8	●			N/A													

Examination/Limitation Remarks:

VALVE RESTRICTS 5 SCAN

Total Length of Weld 101"	Crown Width 1.5"	Total Length of Weld Examined 5 (L) 0 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from N/A to N/A				Extent of Parallel Scans (L) 2 - from NL to NL			
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A		Level N/A		Non-Technical Review Lynda Duke		Date 3-13-00			
SNC-NDE Level II/III Review Nancy Carter L/III		Date 3-13-00		Percentage of Code Coverage N/A %		ANII Review Lynda Duke		Date 3/15/00					

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-9	Date 3/9/00	Sheet No. S00F1U003	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R2Y	Thickness	1.20"								
Ax. dB		Size	.50	Cal. Temp.	72								
Ref.	45.0	Frequency/Mode	2.25 / S	Cal. In	1150								
Scan	51.0	"A" Dimension	.6	Cal. Chk.	N/A								
Reject	OFF	Nominal Angle	60	Cal. Out	1415								
Frequency	2.25	Measured Angle	60	Ref. Blk. No.	796484	Calibration Remarks: N/A							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	85% / 3.0								

Comp. Temp.: 70 °F Configuration: VALVE TO PIPE Wo Location C/L Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2				N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 5 SCAN

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
101"	1.5"	5 (L)	0	2 (L)	NL	7 & 8 (W)	N/A	5 - from	N/A	to	N/A	2 - from	NL	to	NL	From (5)	N/A	to	(2)	N/A
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynda Duke</i>				Date 3-13-00						
SNC NDE Level II/III Review <i>Dan Conde</i>		Date 3-13-00		Percentage of Code Coverage N/A %				ANII Review <i>Lynda Duke</i>				Date 3/15/00								

Figure 1

Revision 7

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-9L1** Date **3/9/00** Sheet No. **S00F1U001** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONATRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L005**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	72	2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150	3T	20	6.0	3.5				
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1411	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1515	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: **70** °F Configuration: **PIPE LONG SEAM** Wo Location **C/L** Lo Location **CIRC WELD 9**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
4.7"	1.6"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner		Level		Assistant Examiner		Level		Non-Technical Review		Date										
GEORGE A. MORINI		II		JOSEPH D. FUNYAK		II		Lynda Duke		3-13-00										
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review		Date								
Wayne Cade L/III				3-13-00		N/A %				1466		3/15/00								

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-10	Date 3/9/00	Sheet No. S00F1U004	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"									
Ax. dB		Circ. dB		Cal. Temp.	72									
Ref.	27.4	29.6	Size	.50	Cal. In									1150
Scan	35.4	37.6	Frequency/Mode	2.25 / S	Cal. Chk.									1357
Reject	OFF		Nominal Angle	45	Cal. Out	1515								
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: N/A							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM		Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: **70** °F Configuration: **PIPE TO VALVE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 2 SCAN

Total Length of Weld 101"	Crown Width 1.3"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	0	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	N/A	to	N/A	From (5)	NL	to	(2)	-.65
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynda Duke</i>				Date 3-13-00						
SNC NDE Level II/III Review <i>Wally Cords</i>		Date 3-13-00		Percentage of Code Coverage N/A %				ANII Review <i>CG</i>				Date 3/15/00								

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-10	Date 3/9/00	Sheet No. S00F1U005	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R2Y	Thickness	1.20"								
	Ax. dB	Circ. dB	Size		Cal. Temp.								
Ref.	45.0	N/A	Frequency/Mode	2.25 / S	Cal. In	1130	1T	80	4.0	1.97			
Scan	51.0	N/A	"A" Dimension	.6	Cal. Chk.	N/A	2T	35	8.0	3.84			
Reject	OFF		Nominal Angle	60	Cal. Out	1415							
Frequency	2.25		Measured Angle	60	Ref. Blk. No.	796484	Calibration Remarks: N/A						
Mode	P/E		Cable Type	RG174	Reflector	HOLE							
Damping	500 OHM		Cable Length	15'	Amplitude/Sweep	85% / 3.0							

Comp. Temp.: **70** °F Configuration: **PIPE TO VALVE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
5				N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 2 SCAN

Total Length of Weld 101"		Crown Width 1.3"	Total Length of Weld Examined 5 (L) NL 2 (L) 0 7 & 8 (W) N/A				Extent of Perpendicular Scans (W) 5 - from N/L to NL				Extent of Parallel Scans (L) 2 - from N/A to N/A				From (5) N/A to (2) N/A			
Primary Examiner GEORGE A. MORINI			Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>Lynda Duke</i>				Date 3-13-00					
SNC NDE Level II/III Review <i>Wayne Carda</i>				Date 3-13-00	Percentage of Code Coverage N/A %				ANII Review <i>CFK</i>				Date 3/15/00					

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-11BC	Date 3/13/00	Sheet No. S00F1U046	Page \ of \
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	41.8		41.8	Size	.50 X 1.0								
Frequency/Mode	2.25 / S	Cal. In	0830	Cal. Chk.	1057	1T	80	3.0	2.25	1T	80	3.0	2.25
Scan	53.8	"A" Dimension	.75	Cal. Out	1300	2T	35	6.0	4.5	2T	35	6.0	4.5
Reject	OFF	Nominal Angle	45	Ref. Blk. No.	796484	3T	20	9.0	6.75	3T	20	9.0	6.75
Frequency	2.25	Measured Angle	45	Reflector	HOLE	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Amplitude/Sweep	60% / 1.1								
Damping	500 OHMS	Cable Length	12'										

Comp. Temp.: **57** °F Configuration: **BRANCH CONNECTION** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

REFERENCE D-175302 FOR WELD PREP DESIGN JRC

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
60"	1.1"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner		Level	Assistant Examiner			Level	Non-Technical Review			Date
GEORGE A. MORINI		II	N/A			N/A	Lynda Duke			3-14-00
SNC NDE Level II/III Review		Date	Percentage of Code Coverage			ANII Review			Date	
[Signature]		3-14-00	N/A %			[Signature]			3/16/00	

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-12BC	Date 3/13/00	Sheet No. S00F1U047	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"								
Ax. dB		Size	.50 X 1.0	Cal. Temp.	70								
Ref.	41.8	Frequency/Mode	2.25 / S	Cal. In	0830								
Scan	53.8	"A" Dimension	.75	Cal. Chk.	1105	1T	80	3.0	2.25	1T	80	3.0	2.25
Reject	OFF	Nominal Angle	45	Cal. Out	1300	2T	35	6.0	4.5	2T	35	6.0	4.5
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	3T	20	9.0	6.75	3T	20	9.0	6.75
Mode	P/E	Cable Type	RG174	Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	60% / 1.1								

Comp. Temp.: 57 °F Configuration: **BRANCH CONNECTION** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														(1)
5	●	○	○	N/A														
7	○	○	●	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: (1) **PREVIOUS INDICATIONS (1988) OBSERVED AT LOWER AMPLITUDE**

WELDED ATTACHMENT RESTRICTS ALL SCANS FOR 18"

IER 1816002

REFERENCE D-175302 FOR WELD PREP DESIGN, INC

Total Length of Weld 60"	Crown Width 1.0"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
		5 (L) 42"	2 (L) 42"	7 & 8 (W) 42"	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>Lynda Duke</i>		Date 3-17-00	
SNC NDE Level II/III Review <i>Donny Carter</i>		Date 3-17-00	Percentage of Code Coverage N A %			ANII Review <i>Cy/Hand</i>		Date 3/21/00		

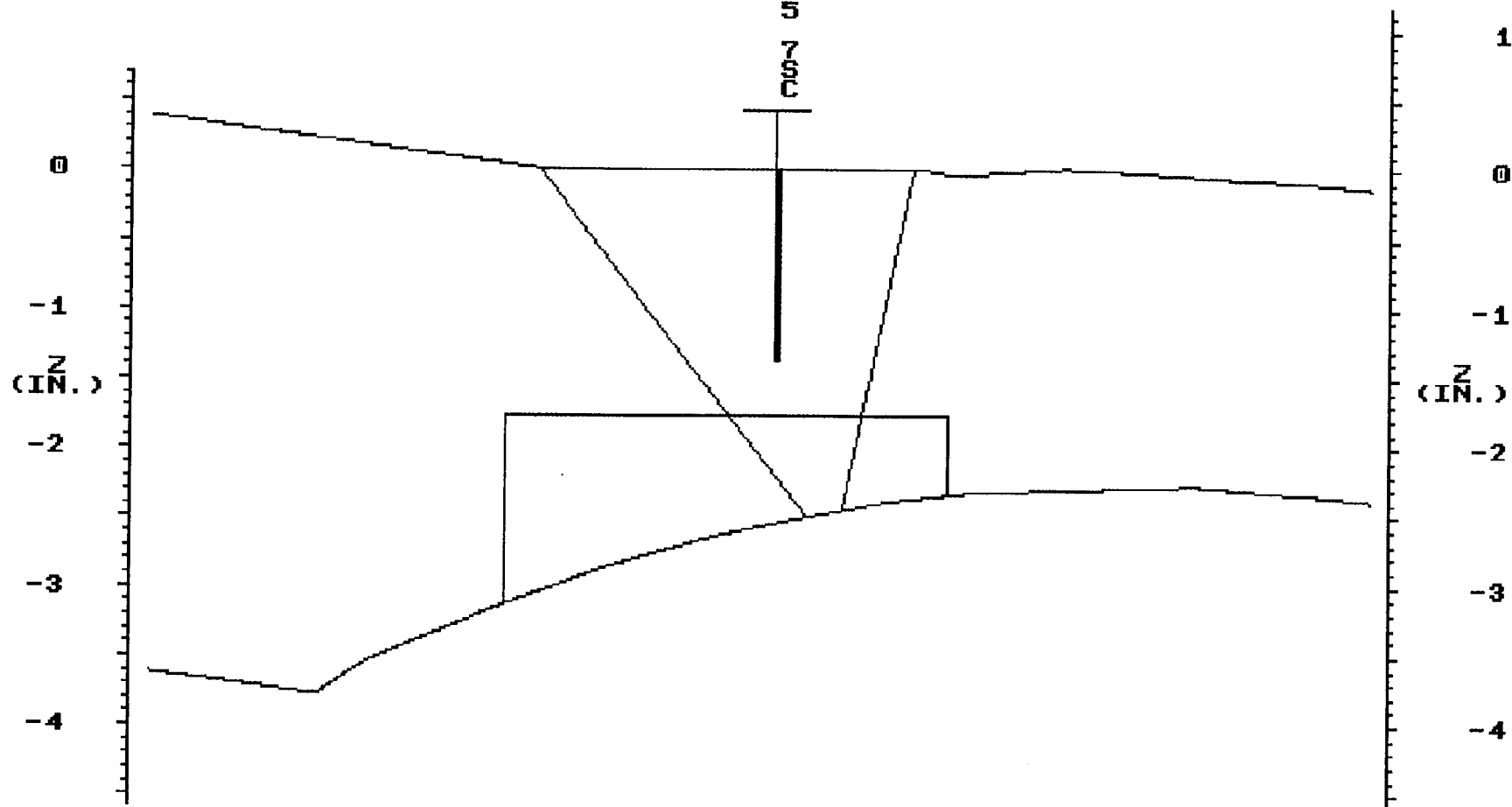
Figure 1

Revision 7

BRANCH

← FLOW
4
5
7
C

MS HEADER



Y(IN.) -4 -3 -2 -1 0 1 2 3 4 Y(IN.)

45 7SC	SET	1R16006.DAT	1R16006A.SCR		SET
1.38	DEP	INDICATIONS OBSERVED FROM PREVIOUS 1988 DATA. SPOT INDICATION OUTSIDE OF ASME EXAM ZONE. NO MEASURABLE THRUWALL OR LENGTH DIMENSIONS. SHOWN HERE IN DEPTH (CIRC SCAN). ASME ACCEPTABLE. <i>DR</i> DR CORDES L/III SEE IER 1R16002.			DEP
1.38	MP				MP
20.12	TOF				TOF
	ARC				ARC
	GATE				GATE
0.050	STEP	EXIT	MAKERAY	UTILITY	STEP
	EXIT	LEFT	RIGHT	TOP	EXIT
PLANT: FARLEY		3/14/00		CIRC. POS.: 90 & 270	
SYSTEM: MAIN STEAM		15:12		ANALYST: DR CORDES L/III	
COMPONENT: ALA2-4101-12BC				CAL. SHEET: S00F1U047	

SHARED

FNP-0-NDE-100.11

MT-F-Form 002

Farley Nuclear Plant

Magnetic Particle Examination Record

Southern Nuclear Operating Company

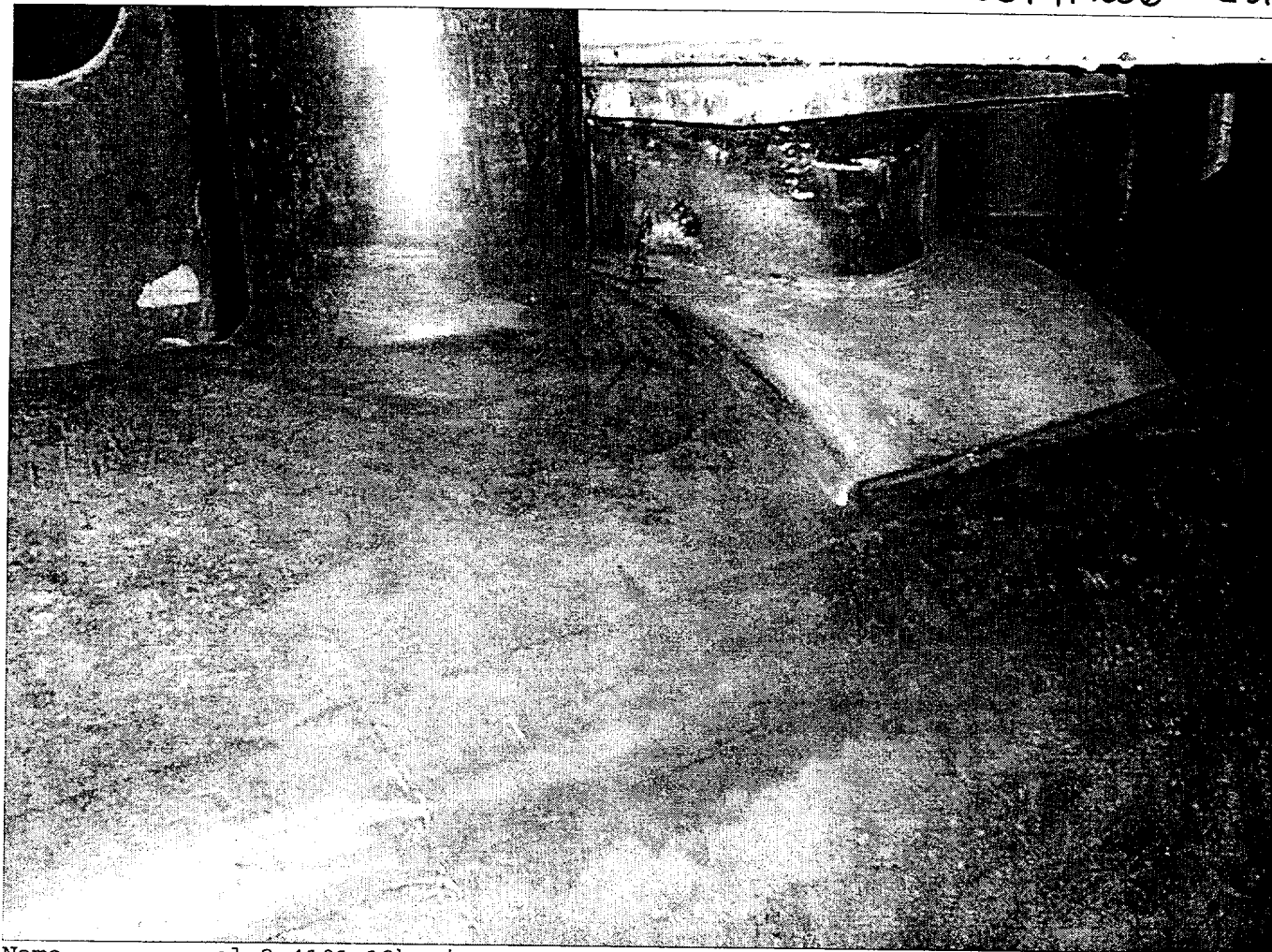
Unit 1	Component No. ALA2-4101-12BC	Procedure/Rev./TCN FNP-0-NDE-100.34 / 7 / N/A	Sheet No. S00F1M006	Page 1 of 2
<u>Thermometer</u> Mfg./Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 62 ° F		<u>Magnetizing Yoke</u> Mfg.: MAGNAFLUX Power AC Serial No: W13577 Pole Spacing: 8" Field Indicator S/N: N/A Field Indicator Acceptable [Y/N] N/A		<u>MT Materials</u> Mfg.: MAGNAFLUX Batch Number: 98C020 Color: 8A RED Type: N/A
Component Configuration BRANCH CONNECTION			% of Length Coverage (1)	Date 3/21/00
			% of Area Coverage (1)	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. (1) EXAMINED 42" OF 60" DUE TO WELDED SUPPORT. (100% OF ACCESSIBLE AREA), SEE ATTACHED PICTURE.	Remarks NONE	

Remarks: **NONE**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JOE</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Danny D. [Signature]</i>	Date 3-22-00
SNC NDE Level II/III Review <i>Danny Conder L/TU</i>			Date 3-23-00	Percentage of Code Coverage 70 %	ANII Review <i>CGWand</i>		Date 3/25/00

Figure 3

Revision 4



Name: ala2-4101-12bc.jpg
Dimensions: 1024 x 768 pixels

70% TOTAL WELD / 100% ACCESSIBLE SURFACE

JRC L/III 3-23-00

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-13BC	Date 3/13/00	Sheet No. S00F1U048	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"	1T	80	3.0	2.25	1T	80	3.0	2.25
Ax. dB		Size	.50 X 1.0	Cal. Temp.	70	2T	35	6.0	4.5	2T	35	6.0	4.5
Ref.	41.8	Frequency/Mode	2.25 / S	Cal. In	0830	3T	20	9.0	6.75	3T	20	9.0	6.75
Scan	53.8	"A" Dimension	.75	Cal. Chk.	1113	Calibration Remarks: NONE							
Reject	OFF	Nominal Angle	45	Cal. Out	1300								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	60% / 1.1								

Comp. Temp.: **57** °F Configuration: **BRANCH CONNECTION** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2				N/A													(1)	
5				N/A														
7				N/A														
8				N/A														

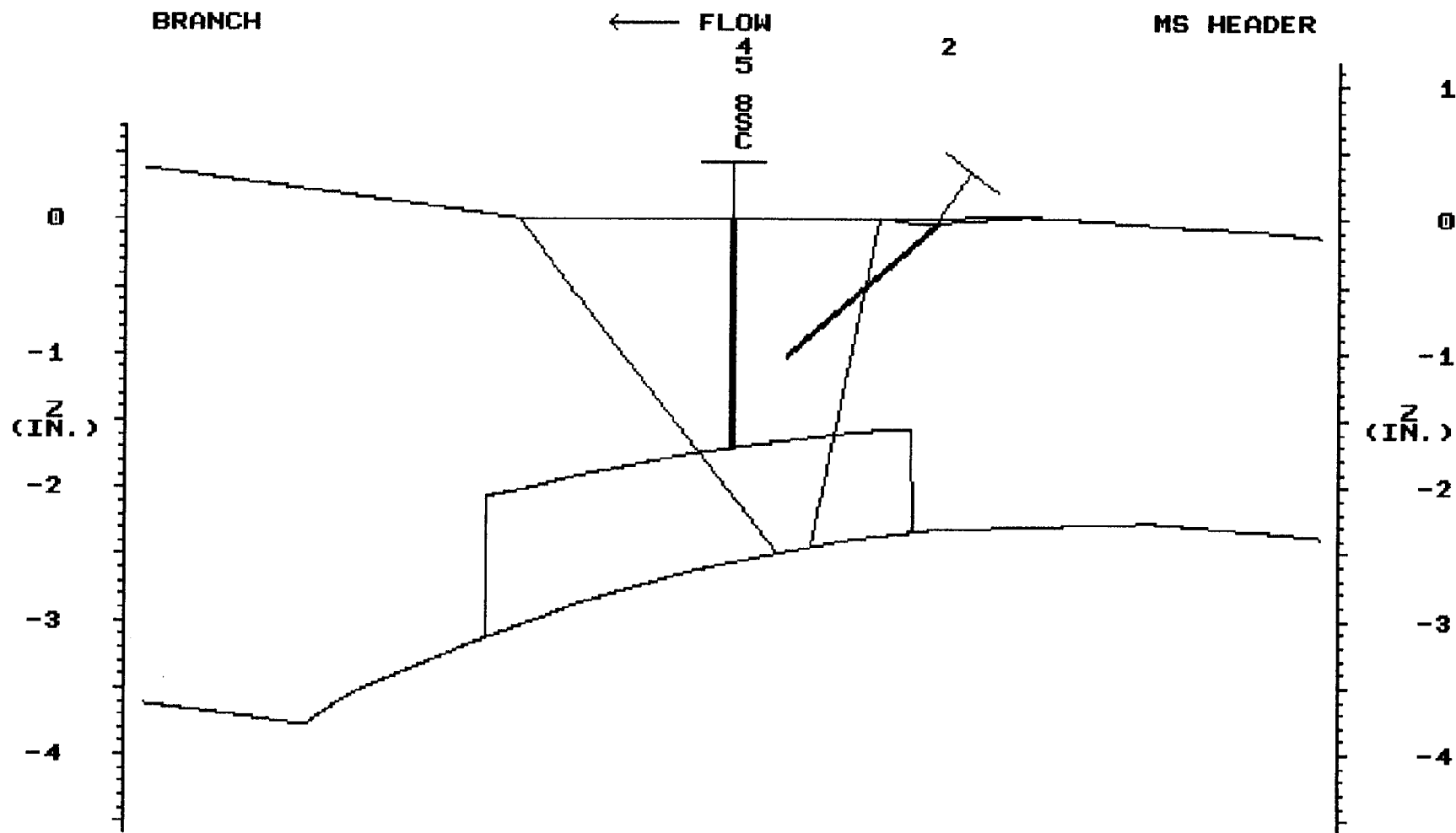
Examination/Limitation Remarks: (1) PREVIOUS INDICATION (1988) OBSERVED AT LOWER AMPLITUDE

WELDED ATTACHMENT RESTRICTS ALL SCANS FOR 18"

Total Length of Weld		Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
60"		1.2"	5 (L) 42"	2 (L) 42"	7 & 8 (W) 42"	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI			Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>Lynda Duke</i>		Date 3-17-00	
SNC NDE Level II/III Review <i>Don Corda L III</i>				Date 3-17-00	Percentage of Code Coverage N/A %			ANII Review <i>Lynda Duke</i>		Date 3/21/00	

Figure 1

Revision 7



Y(IN.) -4 -3 -2 -1 0 1 2 3 4 Y(IN.)

45 8SC	SET	1R16002.DAT	1R16002A.SCR	2	SET
1.73	DEP			1.15	DEP
1.73	MP			1.63	MP
23.20	TOF			34.09	TOF
	ARC				ARC
	GATE				GATE
0.050	STEP			0.050	STEP
	EXIT				EXIT

INDICATIONS OBSERVED FROM PREVIOUS 1988 DATA. SPOT
INDICATIONS OUTSIDE OF ASME EXAM ZONE. NO
MEASURABLE THRUWALL OR LENGTH DIMENSIONS. SHOWN
HERE IN DEPTH (CIRC SCAN) AND MP (AX SCAN). ASME
STEP ACCEPTABLE. SEE IER 1R16003. DR CORDES L/III. JEC
EXIT MAKERAY/UTILITY LEFT RIGHT TOP PRINT EXIT
PLANT: FARLEY 3/14/00 CIRC. POS.: 90 & 270
SYSTEM: MAIN STEAM ANALYST: DR CORDES L/III
COMPONENT: ALA2-4101-13BC 15:33 CAL. SHEET: S00F1U048

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-14BC	Date 3/13/00	Sheet No. S00F1U049	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	41.8		41.8	Frequency/Mode	2.25 / S								
Scan	53.8		53.8	"A" Dimension	.75								
Reject	OFF			Nominal Angle	45								
Frequency	2.25			Measured Angle	45								
Mode	P/E			Cable Type	RG174								
Damping	500 OHMS			Cable Length	12'								
						Calibration Remarks: NONE							

Comp. Temp.: **57** °F Configuration: **BRANCH CONNECTION** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														(1)
5			●	N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

(1) PREVIOUS INDICATIONS (1988) OBSERVED AT LOWER AMPLITUDE

IER 1R16004 **REFERENCE D-175302 FOR WELD PREP DESIGN, JPL 3-14-00**

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)	Extent of Parallel Scans (L)
60"	1"	5 (L) <u>NL</u> 2 (L) <u>NL</u> 7 & 8 (W) <u>NL</u> 5 - from <u>NL</u> to <u>NL</u> 2 - from <u>NL</u> to <u>NL</u> From (5) <u>NL</u> to (2) <u>NL</u>		

Primary Examiner GEORGE A. MORINI	Level II	Assistant Examiner N/A	Level N/A	Non-Technical Review <i>Lynda Duke</i>	Date 3-17-00
SNC NDE Level II/III Review <i>Wayne Carda</i>		Date 3-17-00	Percentage of Code Coverage N/A %	ANII Review <i>Wayne Carda</i>	Date 3/21/00

Figure 1

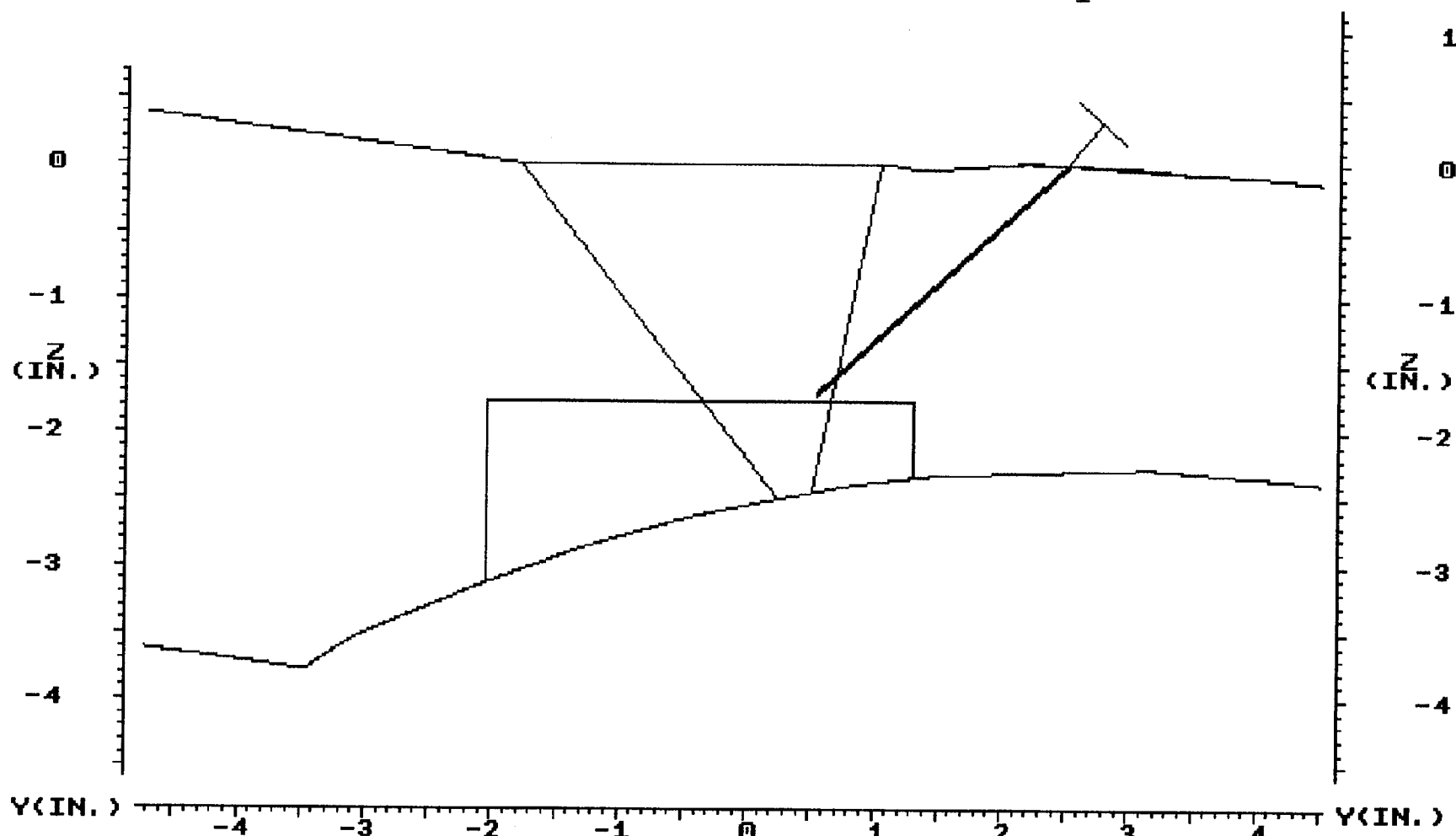
Revision 7

BRANCH

← FLOW

MS HEADER

1



1	SET	1R16007.DAT	1R16007A.SCR		SET
1.84	DEP	INDICATION OBSERVED FROM PREVIOUS 1988 DATA. SPOT INDICATION OUTSIDE OF ASME EXAM ZONE. NO MEASURABLE THRUWALL OR LENGTH DIMENSIONS. ASME ACCEPTABLE. SEE IER 1R16004. DR CORDES L/III. JLC			SET
2.61	MP				DEP
49.73	TOF				MP
	ARC				TOF
	GATE				FAN
0.050	STEP				GATE
	EXIT				STEP
	MAKERAY/UTILITY	LEFT	RIGHT	TOP	EXIT
PLANT: FARLEY		3/15/00		CIRC. POS.: 90 & 270	
SYSTEM: MAIN STEAM		6:56		ANALYST: DR CORDES L/III	
COMPONENT: ALA2-4101-14BC				CAL. SHEET: SOOF1U049	

2 OF 2

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-15BC	Date 3/13/00	Sheet No. S00F1U050	Page (of)
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"	1T	80	3.0	2.25	1T	80	3.0	2.25
Ax. dB		Size	.50 X 1.0	Cal. Temp.	70	2T	35	6.0	4.5	2T	35	6.0	4.5
Ref.	41.8	Frequency/Mode	2.25 / S	Cal. In	0830	3T	20	9.0	6.75	3T	20	9.0	6.75
Scan	53.8	"A" Dimension	.75	Cal. Chk.	1126	Calibration Remarks: NONE							
Reject	OFF	Nominal Angle	45	Cal. Out	1300								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	60% / 1.1								

Comp. Temp.: **57** °F Configuration: **BRANCH CONNECTION** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

REFERENCE D-175302 FOR WELD PREP DESIGN. JPC

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
60"	1.1"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL	to NL	2 - from NL	to NL	From (5) NL	to (2) NL	

Primary Examiner GEORGE A. MORINI	Level II	Assistant Examiner N/A	Level N/A	Non-Technical Review <i>Lynda Duke</i>	Date 3-14-00
SNC NDE Level II/III Review <i>Dan Carbo LIII</i>		Date 3-14-00	Percentage of Code Coverage N/A %	ANII Review <i>lgward</i>	Date 3/16/00

Figure 1

Revision 7

MAIN STEAM SAFETY VALVE
APPROX. WT. 1207 LBS.

6" 1500# FLANGE

12-1/2" HOLES FOR
18" STUD BOLTS 11 1/2" LG.
WITH 2 HEX. NUTS EACH
(FURNISHED BY FIELD)

ANSI-6" 1500#
R.F.FLG. W/ DRILLING
& B.C. STANDARD
HOLES TO STRADDLE
C₁.

R. (BY PIPING FABRICATOR)

WELD END PREPARATION
SHALL BE DETAILED AND
PERFORMED BY THE PIPING
FABRICATOR. NON-DESTRUCTIVE
EXAMINATION OF THESE
WELDS SHALL BE IN
ACCORDANCE WITH
NC-5000 OF ASME
CODE SECT. III.

1/4" THK. X 8 1/2" O.D. X 6 1/4" I.D.
GASKET FLEXITALLIC TYPE "CG"
FOR 6"-1500# A.N.S.I. R.F. FLG.
WITH BLUE AFRICAN ASBESTOS
FILLER (FURNISHED BY FIELD)

QINIIV014

W.P. EL. 195'-5 1/2"

SLOPE



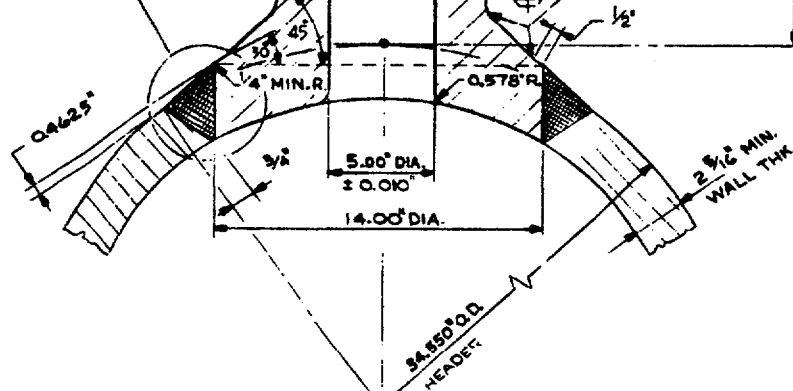
HEADER
550" HEADER

3/4" 3000# SOCKET
WELDING HALF
CPLG. (TYR)

SECTION "D-D"

INSTRUMENT CONN'S

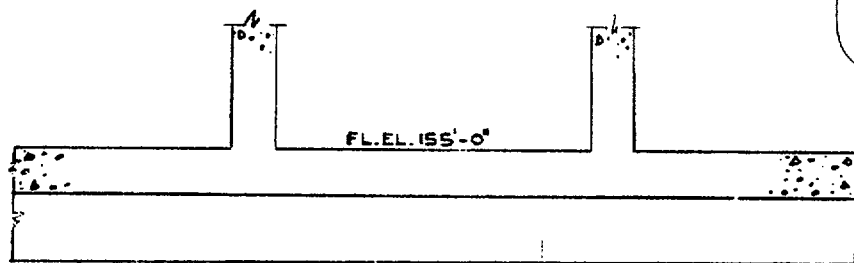
SCALE: 3"=1'-0"



DETAIL "A"

MAIN STEAM SAFETY VALVE
HEADER ASSEMBLY (TYR)
SCALE: 3"=1'-0"

D-175302



W.P. EL. 147'-0"

45° TYP.

CAP THE EXISTING 3"
VALVE BY PASS CONN.
(-YP - 3 PLS)

QINIIV003F
QINIIV002C
- 32" EBD-3
3" EBD-3

QINIIV003C

SEE DETAIL "A"

QINIIV001C

6" EBD-1
BRANCH CONN.
SCH. 80

2'-10.275"

CONTAINMENT
WALL

W.P. EL. 149'-3"

32" EBD-1
FROM STEAM
GENERATOR
QIB21-H001A

EL

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-16	Date 3/13/00	Sheet No. S00F1U034	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	009XBK	Thickness	2.0"									
	Ax. dB	Circ. dB	Size	.50 X 1.0	Cal. Temp.	70								
Ref.	N/A	44.8	Frequency/Mode	2.25 / S	Cal. In	0730	N/A	N/A	N/A	N/A	1T	80	4.0	2.0
Scan	N/A	56.6	"A" Dimension	.65	Cal. Chk.	1045	N/A	N/A	N/A	N/A	2T	20	8.0	4.2
Reject	OFF		Nominal Angle	32	Cal. Out	1302								
Frequency	2.25		Measured Angle	32	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	12'	Amplitude/Sweep	40% / 2.8								

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length	Lmax	L2	Reference Measurement	W1	Wmax	W2	Sweep Position	S1	Smax	S2	Thickness	1" < -- C/L -- > 1"	Notes:
7	● ○ ○ ○ ○	N/A																
8	● ○ ○ ○ ○	N/A																

Examination/Limitation Remarks:

(1) REFERENCE S00F1U035 FOR 2/5 SCANS. 32° USED TO PRODUCE 45 AT I.D.

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
29.5"	1.8"	5 (L) <u>N/A</u>	2 (L) <u>N/A</u>	7 & 8 (W) <u>N/A</u>	5 - from (1) to (1)	2 - from (1) to (1)	From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI <i>gymorini</i>		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>Lynnda Duke</i>		Date 3-14-00	
SNC NDE Level II/III Review <i>Danny Cado</i>			Date 3-14-00	Percentage of Code Coverage <u>N/A</u> 100% 21C			ANII Review <i>cfwood</i>		Date 3/18/00	

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-16	Date 3/13/00	Sheet No. S00F1U035	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument				Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument		STAVELEY		Transducer Mfg.		KBA		Cal. Blk. No.		ALA-30					
Serial No.		136-911K		Serial No.		009KTR		Thickness		2.0"					
Ax. dB		33.0		Circ. dB		N/A		Cal. Temp.		70					
Ref.		33.0		Size		.50		Cal. In		0735					
Scan		44.4		Frequency/Mode		2.25 / S		Cal. Chk.		1007					
Reject		OFF		"A" Dimension		.5		Cal. Out		1305					
Frequency		2.25		Nominal Angle		45		Cal. Blk. No.		796484					
Mode		P/E		Measured Angle		45		Reflector		HOLE					
Damping		500 OHMS		Cable Type		RG174		Amplitude/Sweep		30% / 1.2					
				Cable Length		15'									
Calibration Remarks: NONE															

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														

Examination/Limitation Remarks:

(1) REFERENCE S00F1U034 FOR 7/8 SCANS.

Total Length of Weld 29.5"	Crown Width 1.8"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NA	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	(1)	to	(2)	(1)
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Linda Duke</i>				Date 3-14-00						
SNC NDE Level II/III Review <i>Way Cards L/TH</i>				Date 3-14-00		Percentage of Code Coverage 100%				ANII Review <i>CFK</i>				Date 3/18/00						

Figure 1

Revision 7

SHARED

FNP-0-NDE-100.11

Farley Nuclear Plant

MT-F-Form 002

Magnetic Particle Examination Record

Southern Nuclear Operating Company

Unit 1	Component No. ALA2-4101-16	Procedure/Rev./TCN FNP-0-NDE-100.11 / 4 / N/A	Sheet No. S00F1M005	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg./Ser. No. PTC / 38102 Cal. Due Date 8/27/2000 Surface Temp. 72 ° F		<u>Magnetizing Yoke</u> Mfg.: MAGNAFLUX Power AC Serial No: A999048 Pole Spacing: 6" Field Indicator S/N: N/A Field Indicator Acceptable [Y/N] N/A	<u>MT Materials</u> Mfg.: MAGNAFLUX Batch Number: 98C020 Color: 8A RED Type: N/A	
Component Configuration PIPE TO FLANGE		% of Length Coverage 100	Date 3/11/00	
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.		Remarks
N/A	NI	N/A		

Remarks: **N/A**

Primary Examiner VICTOR DITTRICH	ASNT Level II	Initials <i>[Signature]</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>[Signature]</i>	Date 3-17-00
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-17-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/18/00

Figure 3

Revision 4

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page \ of \
1	ALA2-4101-17	3/13/00	S00F1U036	
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONATRACE 40 / 94243	38081 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009XBK	Thickness	2.0"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	N/A	Size	.50 X 1.0	Cal. In	0730								
Scan	N/A	Frequency/Mode	2.25 / S	Cal. Chk.	1041								
Reject	OFF	"A" Dimension	.65	Cal. Out	1302								
Frequency	2.25	Nominal Angle	32	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E	Measured Angle	32	Reflector	HOLE								
Damping	500 OHMS	Cable Type	RG174	Amplitude/Sweep	40% / 2.8								
		Cable Length	12'										

Comp. Temp.: 57 °F Configuration: PIPE TO FLANGE Wo Location C/L Lo Location DWNSTREAM

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- >1"	
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

(1) REFERENCE S00F1U037 FOR 2/5 SCANS. 32° USED TO PRODUCE 45 AT I.D.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
29.5"	1.75"	5 (L)	N/A	2 (L)	N/A	7 & 8 (W)	NL	5 - from	(1)	to	(1)	2 - from	(1)	to	(1)	From (5)	NL	to	(2)	NL
Primary Examiner		Level		Assistant Examiner				Level		Non-Technical Review				Date						
GEORGE A. MORINI		II		N/A				N/A		Lynda Duke				3-14-00						
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review				Date						
				3-14-00		N/A %				cgh				3/16/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-17	Date 3/13/00	Sheet No. S00F1U037	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	2.0"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	33.0	N/A		Cal. In	0735								
Scan	44.4	N/A		Cal. Chk.	1006	1T	80	3.0	2.0	N/A	N/A	N/A	N/A
Reject	OFF			Cal. Out	1305	2T	30	6.0	4.0	N/A	N/A	N/A	N/A
Frequency	2.25			Ref. Blk. No.	796484	3T	15	9.0	6.0	N/A	N/A	N/A	N/A
Mode	P/E			Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS			Amplitude/Sweep	30% / 1.2								

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														

Examination/Limitation Remarks:

REFERENCE S00F1U036 FOR 7/8 SCANS.

Total Length of Weld 29.5"	Crown Width 1.75"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	N/A	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	(1)	to	(2)	(1)
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynda Duke</i>				Date 3-14-00						
SNC/NDE Level II/III Review <i>Wayne Cardo</i>		Date 3-14-00		Percentage of Code Coverage N/A %				ANII Review <i>CGW</i>				Date 3/16/00								

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNFP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-18	Date 3/13/00	Sheet No. S00F1U038	Page 1 of 1
Procedure/Rev./TCN FNFP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	009XBK	Thickness	2.0"									
	Ax. dB	Circ. dB	Size	.50 X 1.0	Cal. Temp.	70	N/A	N/A	N/A	N/A	1T	80	4.0	2.0
Ref.	N/A	44.8	Frequency/Mode	2.25 / S	Cal. In	0730	N/A	N/A	N/A	2T	20	8.0	4.2	
Scan	N/A	56.6	"A" Dimension	.65	Cal. Chk.	1037								
Reject	OFF		Nominal Angle	32	Cal. Out	1302								
Frequency	2.25		Measured Angle	32	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	12'	Amplitude/Sweep	40% / 2.8								

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

(1) REFERENCE S00F1U039 FOR 2/5 SCANS. 32" USED TO PRODUCE 45 AT I.D

Total Length of Weld 29.5"	Crown Width 2.0"	Total Length of Weld Examined 5 (L) N/A 2 (L) N/A 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from (1) to (1)				Extent of Parallel Scans (L) 2 - from (1) to (1)				From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI <i>[Signature]</i>		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>				Date 3-14-00					
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-14-00	Percentage of Code Coverage ~14 %				ANII Review <i>[Signature]</i>				Date 3/16/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-18	Date 3/13/00	Sheet No. S00F1U039	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	2.0"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	33.0	N/A	Size	.50	Cal. In								
Scan	44.4	N/A	Frequency/Mode	2.25 / S	Cal. Chk.	1013							
Reject	OFF		"A" Dimension	.5	Cal. Out	1305							
Frequency	2.25		Nominal Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE						
Mode	P/E		Measured Angle	45	Reflector	HOLE							
Damping	500 OHMS		Cable Type	RG174	Amplitude/Sweep	30% / 1.2							
			Cable Length	15'									

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
5	●	○	○	N/A														

Examination/Limitation Remarks:

(1) REFERENCE S00F1U038 FOR 7/8 SCANS.

Total Length of Weld 29.5"	Crown Width 2"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) N/A				Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL				Extent of Parallel Scans (L) From (5) N/A to (2) N/A			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>Lynnda Duke</i>				Date 3-14-00	
SNC NDE Level II/III Review <i>Wayne C. Duke</i>		Date 3-14-00	Percentage of Code Coverage ~14 %				ANII Review <i>Wayne C. Duke</i>				Date 3/14/00		

Figure 1

Revision 7

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-19** Date **3/13/00** Sheet No. **S00F1U040**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONATRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L005**
 Page **1** of **1**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009XBK	Thickness	2.0"								
Ax. dB	N/A	Circ. dB	44.8	Size	.50 X 1.0								
Ref.	N/A	Frequency/Mode	2.25 / S	Cal. Temp.	70	N/A	N/A	N/A	N/A	1T	80	4.0	2.0
Scan	N/A	"A" Dimension	.65	Cal. In	0730	N/A	N/A	N/A	N/A	2T	20	8.0	4.2
Reject	OFF	Nominal Angle	32	Cal. Chk.	1033								
Frequency	2.25	Measured Angle	32	Cal. Out	1302								
Mode	P/E	Cable Type	RG174	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	12'	Reflector	HOLE								
				Amplitude/Sweep	40% / 2.8								

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results	Ind. No.	% DAC	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI			L1 Lmax L2	W1 Wmax W2	S1 Smax S2	1" < -- C/L -- > 1"	
7	● ○ ○	N/A						
8	● ○ ○	N/A						

Examination/Limitation Remarks:

(1) REFERENCE S00F1U041 FOR 2/5 SCANS. 32° USED TO PRODUCE 45 AT I.D.

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
29.5"	1.8"	5 (L) N/A	2 (L) N/A	7 & 8 (W) NL	5 - from (1) to (1)	2 - from (1) to (1)	From (5) NL to (2) NL			
Primary Examiner	Level	Assistant Examiner	Level	Non-Technical Review	Date					
GEORGE A. MORINI	II	N/A	N/A	Lynda Duke	3-14-00					
SNC NDE Level II/III Review	Date	Percentage of Code Coverage	ANII Review	Date						
3-14-00	3-14-00	N/A	cgw	3/16/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page	of \
1	ALA2-4101-19	3/13/00	S00F1U041		
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.		
FNP-0-NDE-100.31 / 7 / N/A	SONATRACE 40 / 94243	38081 / 8/27/2000	S00F1L005		

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	2.0"								
Ax. dB		Circ. dB		Cal. Temp.	70								
Ref.	33.0	N/A		Cal. In	0735								
Scan	44.4	N/A		Cal. Chk.	1018	1T	80	3.0	2.0	N/A	N/A	N/A	N/A
Reject	OFF			Cal. Out	1305	2T	30	6.0	4.0	N/A	N/A	N/A	N/A
Frequency	2.25			Ref. Blk. No.	796484	3T	15	9.0	6.0	N/A	N/A	N/A	N/A
Mode	P/E			Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS			Amplitude/Sweep	30% / 1.2								

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														

Examination/Limitation Remarks:

(1) REFERENCE S00F1U040 FOR 7/8 SCANS.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
29.5"	1.8"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	N/A	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	(1)	to	(2)	(1)
Primary Examiner		Level		Assistant Examiner				Level		Non-Technical Review				Date						
GEORGE A. MORINI		II		N/A				N/A		<i>Lynda Duke</i>				3-14-00						
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review				Date						
<i>[Signature]</i>				3-14-00		N/A %				<i>[Signature]</i>				3/16/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-20	Date 3/13/00	Sheet No. S00F1U042	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009XBK	Thickness	2.0"								
	Ax. dB Circ. dB	Size	.50 X 1.0	Cal. Temp.	70	N/A	N/A	N/A	N/A	1T	80	4.0	2.0
Ref.	N/A 44.8	Frequency/Mode	2.25 / S	Cal. In	0730	N/A	N/A	N/A	N/A	2T	20	8.0	4.2
Scan	N/A 56.6	"A" Dimension	.65	Cal. Chk.	1030								
Reject	OFF	Nominal Angle	32	Cal. Out	1302								
Frequency	2.25	Measured Angle	32	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	40% / 2.8								

Comp. Temp.: **57** °F Configuration: **PIPE TO FLANGE** Wo Location **C/L** Lo Location **DWNSTREAM**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

(1) REFERENCE S00F1U043 FOR 2/5 SCANS. 32° USED TO PRODUCE 45 AT I.D.

Total Length of Weld 22.5"	Crown Width 1.9"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)			
		5 (L) N/A	2 (L) N/A	7 & 8 (W) NL	5 - from N/A	to N/A	2 - from N/A	to N/A	From (5) NL	to (2) NL	
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>Lynda Duke</i>			Date 3-14-00
SNC NDE Level II/III Review <i>Wang Cards</i>		Date 3-14-00	Percentage of Code Coverage N/A %				ANII Review <i>CGW</i>			Date 3/16/00	

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-20	Date 3/13/00	Sheet No. S00F1U043	Page \ of \
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A		Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-30	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	009KTR	Thickness	2.0"									
Ax. dB		Circ. dB		Cal. Temp.	70									
Ref.	33.0	N/A	Size	.50	Cal. In									0735
Scan	44.4	N/A	Frequency/Mode	2.25 / S	Cal. Chk.	1024	1T	80	3.0	2.0	N/A	N/A	N/A	N/A
Reject	OFF		"A" Dimension	.5	Cal. Out	1305	2T	30	6.0	4.0	N/A	N/A	N/A	N/A
Frequency	2.25		Nominal Angle	45	Ref. Blk. No.	796484	3T	15	9.0	6.0	N/A	N/A	N/A	N/A
Mode	P/E		Measured Angle	45	Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS		Cable Type	RG174	Amplitude/Sweep	30% / 1.2								
			Cable Length	15'										

Comp. Temp.: °F		Configuration: PIPE TO FLANGE										Wo Location						Lo Location	
Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:	
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"		
2	●	○	○	N/A															
5	●	○	○	N/A															

Examination/Limitation Remarks:

(1) REFERENCE S00F1U042 FOR 7/8 SCANS.

Total Length of Weld 29.5"	Crown Width 1.9"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) N/A				Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL				Extent of Parallel Scans (L) From (5) (1) to (2) (1)			
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A		Level N/A		Non-Technical Review <i>Kynda Duke</i>		Date 3-14-00			
SNC NDE Level II/III Review <i>Dan Cardo</i>				Date 3-14-00		Percentage of Code Coverage 24 %		ANII Review <i>lgw</i>		Date 3/16/00			

Figure 1

Revision 7

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-21BC	Date 3/24/00	Sheet No. S00F1U162	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument			Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY		Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K		Serial No.	00B2J2	Thickness	.500"	1T	80	2.0	0.5	1T	80	2.0	0.55
	Ax. dB	Circ. dB	Size	.25	Cal. Temp.	68°	2T	40	4.0	1.0	2T	40	4.2	1.1
Ref.	32.6	38.0	Frequency/Mode	5 / S	Cal. In	0900	3T	20	6.0	1.5				
Scan	44.6	44.0	"A" Dimension	0.2"	Cal. Chk.	1030	4T	10	8.0	2.0				
Reject	OFF		Nominal Angle	45	Cal. Out	1130	Calibration Remarks: NONE							
Frequency	5.0		Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	15'	Amplitude/Sweep	20%/2.8								

Comp. Temp.: **68°** °F Configuration: **BRANCH CONNECTION** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: (1) ²⁶SCAN PERFORMED FROM PIPE SIDE (2 SCAN) WITH ALA-27 REFERENCE S00F1U163 FOR SCAN FROM HEADER (5 SCAN).
2NL 3-27-00

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
27.5"	0.75"	5 (L)	(1)	2 (L)	NL	7 & 8 (W)	NL	5 - from	(1)	to	(1)	2 - from	NL	to	NL	From (5)	.4"	to	(2)	NL
Primary Examiner		Level		Assistant Examiner		Level		Non-Technical Review		Date		ANII Review		Date						
GEORGE A. MORINI		II		N/A		N/A		J. Eric Dyck		3-25-00		C. G. Wood		3/27/00						
SNC NDE Level II/III Review				Date		Percentage of Code Coverage														
Nancy Cordes				3-27-00		N/A														

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-21BC	Date 3/24/00	Sheet No. S00F1U163	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	0098JL	Thickness	2.31"	1T	80	3.0	2.25	1T	80	3.0	2.25
Ax. dB	41.8	Size	.50 X 1.0	Cal. Temp.	70°	2T	35	6.0	4.50	2T	35	6.0	4.50
Circ. dB	41.8	Frequency/Mode	2.25 / S	Cal. In	0830	3T	20	9.0	6.75	3T	20	9.0	6.75
Ref.	41.8	"A" Dimension	0.75"	Cal. Chk.	N/A	Calibration Remarks: NONE							
Scan	53.8	Nominal Angle	45	Cal. Out	1110								
Reject	OFF	Measured Angle	45	Ref. Blk. No.	796484								
Frequency	2.25	Cable Type	RG174	Reflector	HOLE								
Mode	P/E	Cable Length	12'	Amplitude/Sweep	60%/1.1								
Damping	500 OHMS												

Comp. Temp.: **68°** °F Configuration: **BRANCH CONNECTION** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI			L1 Lmax L2	W1 Wmax W2	S1 Smax S2	1" < -- C/L -- > 1"	
5	● ○ ○	N/A						

Examination/Limitation Remarks: (1) SCAN PERFORMED FROM HEADER (5 SCAN) WITH ALA-23. REFERENCE S00F1U162 FOR SCAN FROM PIPE SIDE (2 SCAN). RESTRAINT LIMITS 5 SCAN.
 (2) NO COVERAGE OBTAINABLE FROM 7/8 SIDE DUE TO BRANCH CONFIGURATION.

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)		Extent of Parallel Scans (L)			
27.5"	0.75"	5 (L) NL	2 (L) (1)	7 & 8 (W) (2)	5 - from NL to .75"	2 - from (1) to (1)	From (5) (2)	to (2) (2)	
Primary Examiner	Level	Assistant Examiner		Level	Non-Technical Review		Date		
GEORGE A. MORINI	II	N/A		N/A	<i>[Signature]</i>		3-25-00		
SNC NDE Level II/III Review	Date	Percentage of Code Coverage		ANII Review		Date			
<i>[Signature]</i>	3-27-00	N/A %		<i>[Signature]</i>		3/27/00			

Figure 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-22	Date 3/25/00	Sheet No. S00F1U192	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.500"								
Ax. dB		Size	.25	Cal. Temp.	68°								
Ref.	32	Frequency/Mode	5 / S	Cal. In	0900								
Scan	44	"A" Dimension	0.2"	Cal. Chk.	N/A								
Reject	OFF	Nominal Angle	45	Cal. Out	1005								
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	N/A	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Reflector	N/A								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	N/A								

Comp. Temp.: **68°** °F Configuration: **PIPE TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld 27.5"	Crown Width 1.0"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
		5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL	to NL	2 - from NL	to NL	From (5) NL	to (2) NL
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A		Level N/A	Non-Technical Review <i>J. Eric Aycock</i>		Date 3-25-00		
SNC NDE Level II/III Review <i>Danny Carls</i>		Date 3-27-00	Percentage of Code Coverage N/A %		ANII Review <i>EGH</i>		Date 3/27/00			

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-22	Sheet Number S00F1U196	Date 3/25/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO TEE		
Location LMAX	TDC	WMAX	WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081

Branch WELD EDGE WELD EDGE *TEE*

COMPONENT **1.0** WELD Q COMPONENT

T. MEASUREMENTS

O.D. PROFILE

.52 .52 .53 .52 .52

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Danny Carden</i>	Level III	Date 3-27-00	Non-Technical Review <i>J. Eric Ouyack</i>	Date 3-25-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page \ of \
1	ALA2-4101-23	3/24/00	S00F1U164	
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38180 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.500"	1T	80	2.0	0.5	1T	80	2.0	0.55
Ax. dB		Size	.25	Cal. Temp.	68°	2T	40	4.0	1.0	2T	40	4.2	1.1
Ref.	32.6	Frequency/Mode	5 /	Cal. In	0900	3T	20	6.0	1.5				
Scan	44.6	"A" Dimension	0.2"	Cal. Chk.	1021	4T	10	8.0	2.0				
Reject	OFF	Nominal Angle	45	Cal. Out	1130	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	20%/2.8								

Comp. Temp.: 68° °F Configuration: PIPE TO CAP Wo Location WELD CL Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI						W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: NONE

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
27.5"		1.1"		5 (L) NL		2 (L) NL		7 & 8 (W) NL		5 - from NL to NL		2 - from NL to NL		From (5) NL to (2) NL	
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review		Date	
GEORGE A. MORINI				II		N/A				N/A		J. Eric Aycock		3-25-00	
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review		Date			
Nancy Corda				3-27-00		N/A %				C. G. Ward		3/27/00			

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-23	Sheet Number S00F1U169	Date 3/24/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO CAP		
Location LMAX TDC WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	

FLOW

T. MEASUREMENTS

O.D. PROFILE

.55" .55" .58" .52" .52"

T. MEASUREMENT EACH IN.

REMARKS:

NDE I/II/III Review <i>John W. Bell</i>	Level III	Date 3-27-00	Non-Technical Review <i>John W. Bell</i>	Date 3-25-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-24	Date 3/24/00	Sheet No. S00F1U166
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																									
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>0.5</td> <td>1T</td> <td>80</td> <td>2.0</td> <td>0.55</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.0</td> <td>1.0</td> <td>2T</td> <td>40</td> <td>4.2</td> <td>1.1</td> </tr> <tr> <td>3T</td> <td>20</td> <td>6.0</td> <td>1.5</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>10</td> <td>8.0</td> <td>2.0</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	0.5	1T	80	2.0	0.55	2T	40	4.0	1.0	2T	40	4.2	1.1	3T	20	6.0	1.5					4T	10	8.0	2.0									
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																											
1T	80	2.0	0.5	1T	80		2.0	0.55																																											
2T	40	4.0	1.0	2T	40		4.2	1.1																																											
3T	20	6.0	1.5																																																
4T	10	8.0	2.0																																																
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.500"																																														
Ax. dB		Size	.25	Cal. Temp.	68°																																														
Circ. dB		Frequency/Mode	5 / S	Cal. In	0900																																														
Ref.	32.6	"A" Dimension	0.2"	Cal. Chk.	1010	Calibration Remarks: NONE																																													
Scan	44.6	Nominal Angle	45	Cal. Out	1130																																														
Reject	OFF	Measured Angle	45	Ref. Blk. No.	796484																																														
Frequency	5.0	Cable Type	RG174	Reflector	HOLE																																														
Mode	P/E	Cable Length	15'	Amplitude/Sweep	20%/2.8																																														
Damping	500 OHMS																																																		

Comp. Temp.: **68** °F Configuration: **TEE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld 27.5"	Crown Width 1.1"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL		
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>J. Eric Lopez</i>			Date 3-27-00
SNC NDE Level II/III Review <i>Don Carlos</i>		Date 3-27-00	Percentage of Code Coverage 100 %			ANII Review <i>CGH</i>			Date 3/27/00	

Figure 1

Revision 7

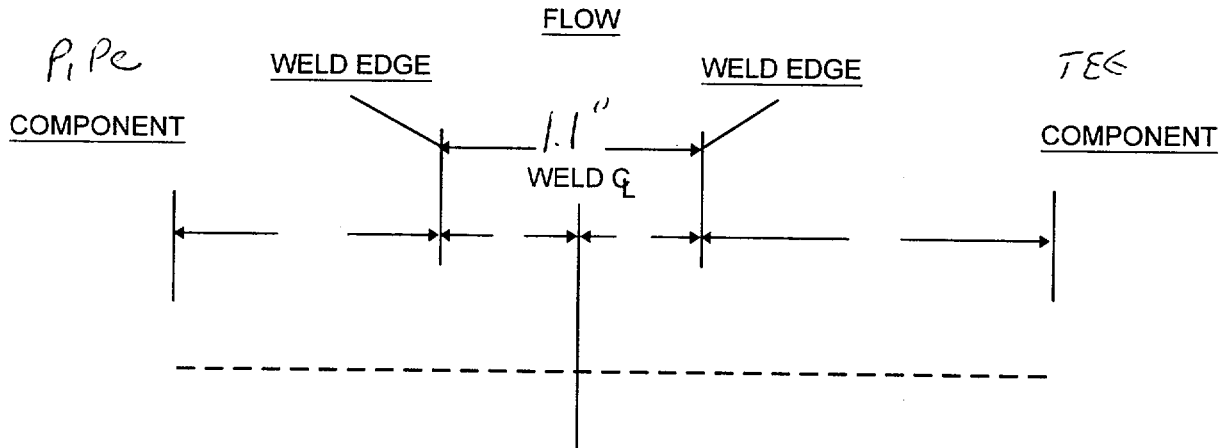
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-24	Sheet Number S00F1U167	Date 3/24/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K
Examiner JOHN W. BELL	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	
Component Configuration/Flow TEE TO PIPE			
Location LMAX TDC WMAX WELD CL		Component Temp °F 68°	Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Danny Cordes</i>	Level III	Date 3-27-00	Non-Technical Review <i>J. Eric Olycott</i>	Date 3-25-00

Revision 1

SHARED

FNP-0-NDE-100.11

Farley Nuclear Plant

MT-F-Form 002

Magnetic Particle Examination Record

Southern Nuclear Operating Company

Unit 1	Component No. ALA2-4101-24	Procedure/Rev./TCN FNP-0-NDE-100.11 / 4 / N/A	Sheet No. S00F1M027	Page 1 of 2
<u>Thermometer</u> Mfg./Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 65 ° F		<u>Magnetizing Yoke</u> Mfg.: MAGNAFLUX Power AC Serial No: W13577 Pole Spacing: 8" Field Indicator S/N: N/A Field Indicator Acceptable [Y/N] N/A	<u>MT Materials</u> Mfg.: MAGNAFLUX Batch Number: 98C020 Color: 8A RED Type: N/A	
Component Configuration TEE TO PIPE		% of Length Coverage (1) % of Area Coverage (1)	Date 3/24/00	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. (1) EXAMINED 20" OF 27.5" DUE TO 3" LINE OBSTRUCTION.		Remarks NONE

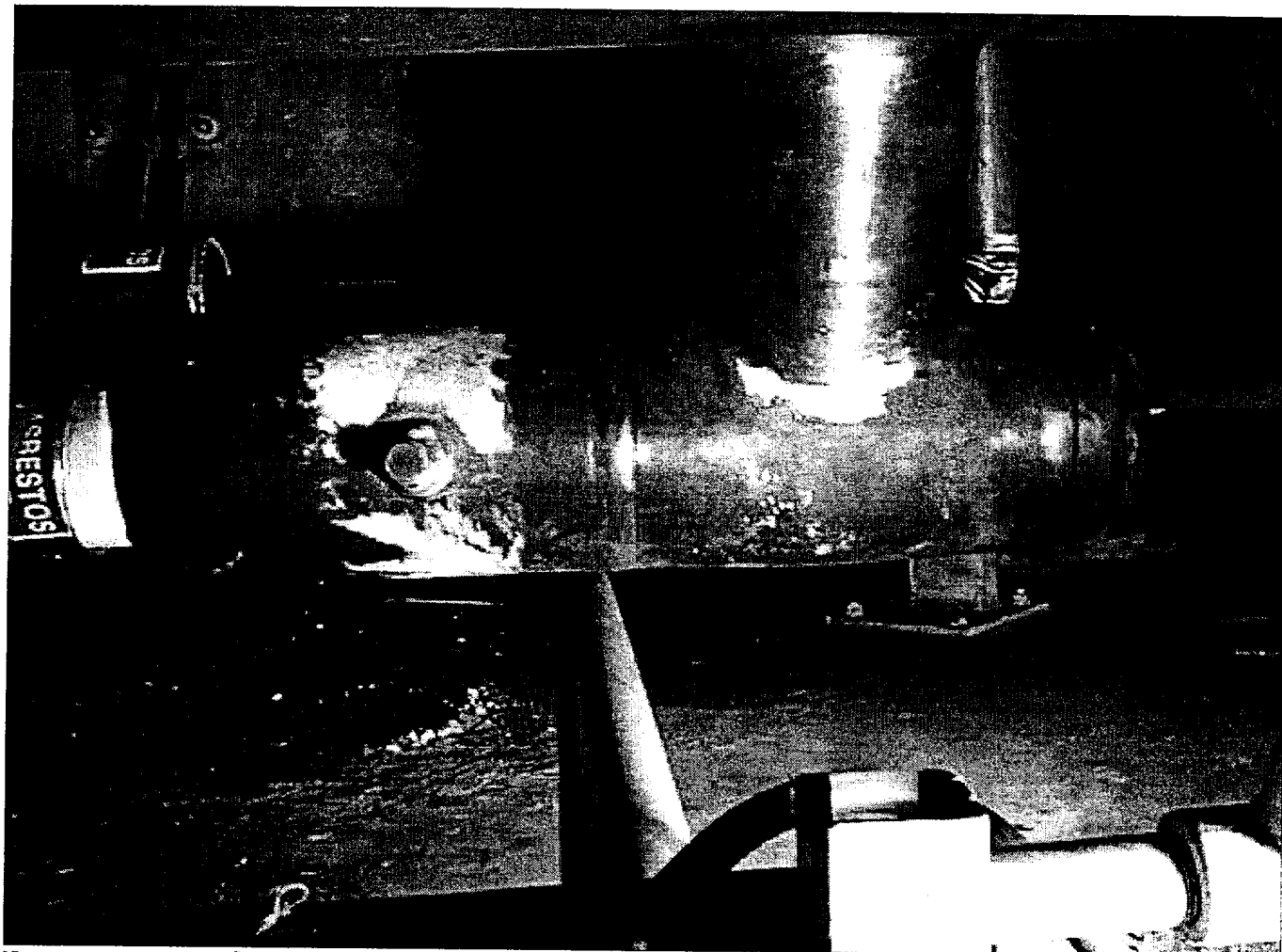
JRL
3-25-00

Remarks: **NONE**

Primary Examiner GEORGE A. MORINI	ASNT Level II	Initials <i>AM</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. Eric Ryeck</i>	Date 3-25-00
SNC NDE Level II/III Review <i>Van Corda L/III</i>			Date 3-25-00	Percentage of Code Coverage 73 %	ANII Review <i>CF Ward</i>		Date 3/27/00

Figure 3

Revision 4



Name: ala2-4101-24.jpg
Dimensions: 640 x 480 pixels

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page
1	ALA2-4101-25	3/24/00	S00F1U165	1 of 1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38180 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.500"	1T	80	2.0	0.5	1T	80	2.0	0.55
Ax. dB		Size	.25	Cal. Temp.	68°	2T	40	4.0	1.0	2T	40	4.2	1.1
Ref.	32.6	Frequency/Mode	5 /	Cal. In	0900	3T	20	6.0	1.5				
Scan	44.6	"A" Dimension	0.2"	Cal. Chk.	1015	4T	10	8.0	2.0				
Reject	OFF	Nominal Angle	45	Cal. Out	1130	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	20%/2.8								

Comp. Temp.: 68° °F Configuration: TEE TO CAP

Wo Location WELD CL Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: NONE

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)								
27.5"	1.2"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review				Date				
GEORGE A. MORINI				II		N/A				N/A		J. Eric Ryceck				3-25-00				
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review		Date								
Dan Carls L/III				3-27-00		N/A %				C. Ward				3/27/00						

Figure 1

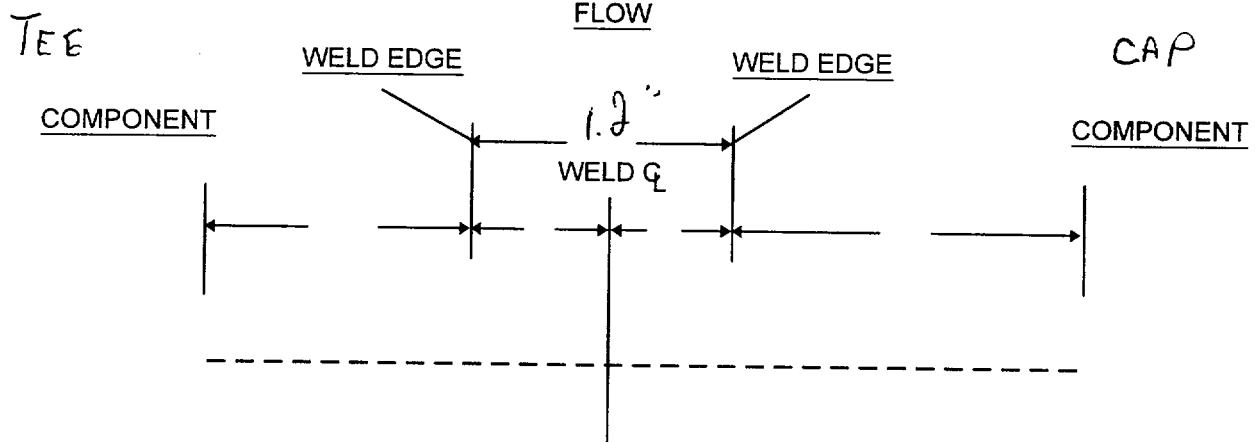
Revision 7

SHARED

Ultrasonic Weld Profile Record Southern Nuclear Operating Company

FNP-0-NDE-100.35

Unit 1	Weld Number ALA2-4101-25	Sheet Number S00F1U168	Date 3/24/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-911K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow TEE TO CAP	
Location LMAX TDC	WMAX WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE I/II/III Review <i>Dan Cordes</i>	Level III	Date 3-27-00	Non-Technical Review <i>John E. Olyock</i>	Date 3-25-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-26BC	Date 3/20/00	Sheet No. S00F1U132	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 / S	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1344	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **BRANCH CONNECTION** Wo Location **WELD CL** Lo Location **DS APEX**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: (1) SCAN PERFORMED FROM PIPE SIDE (2 SCAN) WITH ALA-27. REFERENCE S00F1U131 FOR SCAN FROM HEADER (5 SCAN).

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
21"	0.8"	5 (L)	(1)	2 (L)	NL	7 & 8 (W)	NL	5 - from	(1)	to	(1)	2 - from	NL	to	NL	From (5)	.4"	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-23-00						
SNC NDE Level II/III Review <i>[Signature]</i>		III		Date 3-23-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/25/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNFP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-26BC	Date 3/20/00	Sheet No. S00F1U131	Page / of /
Procedure/Rev./TCN FNFP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-23	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTL	Thickness	2.31"								
Ax. dB		Size	.50	Cal. Temp.	68°								
Ref.	40	Frequency/Mode	2.25 / S	Cal. In	1250								
Scan	52	"A" Dimension	.5"	Cal. Chk.	N/A	1T	80	3.0	2.25	1T	80	3.0	2.25
Reject	OFF	Nominal Angle	45	Cal. Out	1632	2T	40	6.0	4.50	2T	40	6.0	4.50
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	3T	20	9.0	6.75	3T	20	9.0	6.75
Mode	P/E	Cable Type	RG174	Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	12'	Amplitude/Sweep	60%/1.1								

Comp. Temp.: **68°** °F Configuration: **BRANCH CONNECTION** Wo Location **WELD CL** Lo Location **DS APEX**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: (1) SCAN PERFORMED FROM HEADER (5 SCAN) WITH ALA-23. REFERENCE S00F1U132 FOR SCAN FROM PIPE SIDE (2 SCAN). RESTRAINT LIMITS 5 SCAN.
(2) NO COVERAGE OBTAINABLE FROM 5 SIDE DUE TO BRANCH CONFIGURATION.

Total Length of Weld 21"	Crown Width 0.8"	Total Length of Weld Examined 5 (L) 15" 2 (L) (1) 7 & 8 (W) (2)				Extent of Perpendicular Scans (W) 5 - from .9" to NL				Extent of Parallel Scans (L) 2 - from (1) to (1) From (5) (2) to (2) (2)			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>Danny Cordes</i>				Date 3-23-00	
SNC NDE Level II/III Review <i>Danny A. Poths</i>		Date 3-23-00	Percentage of Code Coverage N/A %				ANII Review <i>C. G. Ward</i>				Date 3/25/00		

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-28	Date 3/20/00	Sheet No. S00F1U133	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 / S	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1347	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **OR ELBOW**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
21"	0.7"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>Dany Cordia</i>		Date 3-23-00	
SNC NDE Level II/III Review <i>David J. Lofth</i>		III	Date 3-23-00	Percentage of Code Coverage N/A %		ANII Review <i>cgward</i>		Date 3/25/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-28	Sheet Number S00F1U121	Date 3/21/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884		Model Number SONIC 136	Serial Number 136-898K	
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW		
Location LMAX OR EL WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	
<u>FLOW</u>					
<u>T. MEASUREMENTS</u> <u>O.D. PROFILE</u> .42 .42 .41 .42 .42"					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Darryl D. Lofgren</i>		Level III	Date 3-22-00	Non-Technical Review <i>Darryl Corda</i>	
				Date 3-23-00	

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-29	Date 3/20/00	Sheet No. S00F1U134	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 / S	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1353	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **ELBOW TO ELBOW** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)											
21.0"	0.65"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL	
Primary Examiner		Level		Assistant Examiner				Level		Non-Technical Review						Date					
GEORGE A. MORINI		II		N/A				N/A		Dany Cordis						3-23-00					
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review						Date					
Dany A. Lefebvre				III		3-23-00				100 %				CGWand						3/25/00	

Figure 1

Revision 7

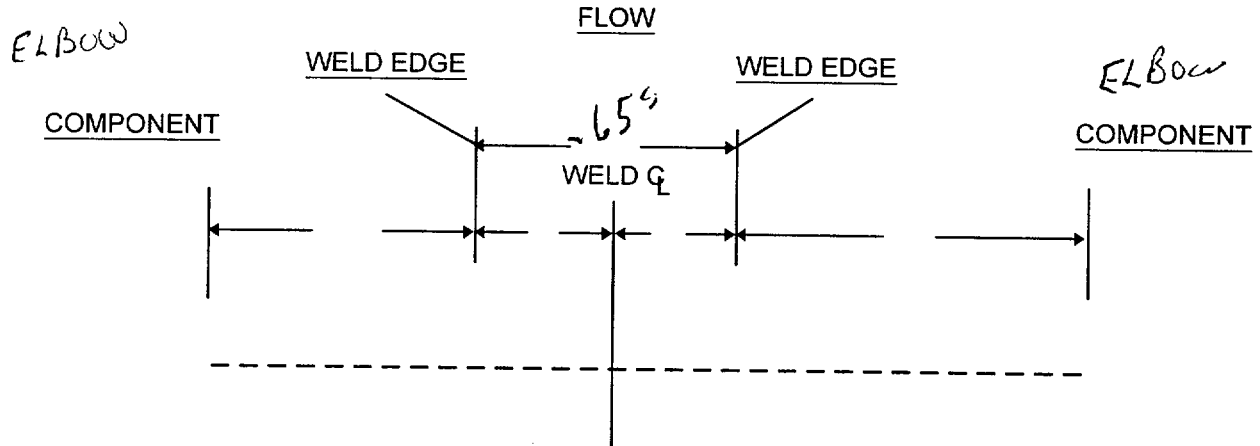
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

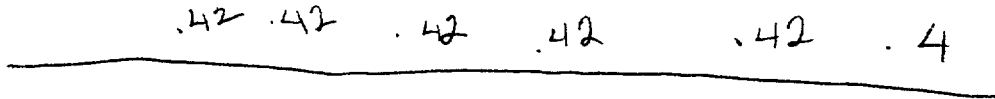
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-29	Sheet Number S00F1U122	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	
Component Configuration/Flow ELBOW TO ELBOW			
Location LMAX TDC WMAX WELD CL		Component Temp °F 68°	Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Darryl A. Loftis</i>	Level III	Date 3-22-00	Non-Technical Review <i>Darryl Corda</i>	Date 3-23-00

Revision 1

SHARED

FNP-0-NDE-100.11

MT-F-Form 002

Farley Nuclear Plant

Magnetic Particle Examination Record

Southern Nuclear Operating Company

Unit 1	Component No. ALA2-4101-29	Procedure/Rev./TCN FNP-0-NDE-100.11 / 4 / N/A	Sheet No. S00F1M007	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg./Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 67 ° F		<u>Magnetizing Yoke</u> Mfg.: MAGNAFLUX Power AC Serial No: W13577 Pole Spacing: 8" Field Indicator S/N: N/A Field Indicator Acceptable [Y/N] N/A		<u>MT Materials</u> Mfg.: MAGNAFLUX Batch Number: 98C020 Color: 8A RED Type: N/A
Component Configuration ELBOW TO PIPE			% of Length Coverage 100%	Date 3/21/00
			% of Area Coverage 100%	
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.	Remarks	
N/A	NI	N/A	NONE	

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Darryl Cordis</i>	Date 3-23-00
SNC NDE Level II/III Review <i>Darryl A. Loftis</i>			Date 3-22-00	Percentage of Code Coverage <u>100</u> %	ANII Review <i>cyward</i>		Date 3/25/00

Figure 3

Revision 4

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-30	Date 3/20/00	Sheet No. S00F1U135	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 / S	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1359	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
21.0"	0.9"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL	to NL	2 - from NL	to NL	From (5) NL	to (2) NL		
Primary Examiner GEORGE A. MORINI <i>[Signature]</i>		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-23-00	
SNC NDE Level II/III Review <i>[Signature]</i>		III	Date 3-23-00	Percentage of Code Coverage N/A %			ANII Review <i>[Signature]</i>			Date 3/25/00		

Figure 1

Revision 7

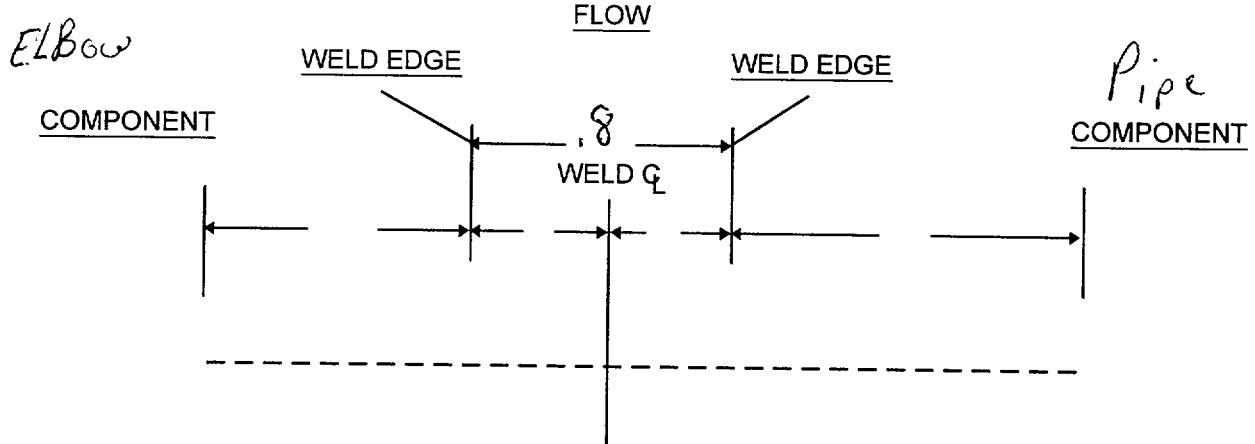
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Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-30	Sheet Number S00F1U123	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow ELBOW TO PIPE	
Location LMAX TDC WMAX WELD CL	Component Temp °F 68°		Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE

.42 .42 .42 .43 .41 .41 .41

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Dan P. S. [Signature]</i>	Level III	Date 3-22-00	Non-Technical Review <i>Dan Cordo</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-31	Date 3/20/00	Sheet No. S00F1U136	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"								
Ax. dB		Size	.25	Cal. Temp.	68°								
Ref.	32.0	Frequency/Mode	5 / S	Cal. In	1300								
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1405								
Reject	OFF	Nominal Angle	45	Cal. Out	1630	4T	22	8.0	1.65				
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **PIPE TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **(1) VALVE RESTRICTS 2 SCAN**

Total Length of Weld 21.0"	Crown Width 0.9"	Total Length of Weld Examined 5 (L) NL 2 (L) (1) 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from (1) to (1)				Extent of Parallel Scans (L) From (5) NL to (2) 0.5"			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>				Date 3-23-00	
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00	Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/25/00		

Figure 1

Revision 7

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-31** Date **3/20/00** Sheet No. **S00F1U137** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009R2K	Thickness	.432"	1T	80	4.0	0.67				
Ax. dB		Size	.25	Cal. Temp.	68°	2T	20	8.0	1.27				
Ref.	49.6	Frequency/Mode	5 / S	Cal. In	1255	Calibration Remarks: SUPPLEMENTAL ONE SIDED EXAM.							
Scan	61.6	"A" Dimension	0.4"	Cal. Chk.	1320								
Reject	OFF	Nominal Angle	60	Cal. Out	1631								
Frequency	5.0	Measured Angle	60	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	70%/7.7								

Comp. Temp.: **68°** °F Configuration: **PIPE TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax L2	Reference Measurement W1 Wmax W2	Sweep Position S1 Smax S2	Thickness 1" < -- C/L -- > 1"	Notes:
5	●	N/A							

Examination/Limitation Remarks: **(1) VALVE RESTRICTS 2 SCAN.**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)					
21.0"	0.9"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	N/A	5 - from	NL	to	NL	2 - from	(1)	to	N/A
Primary Examiner		Level		Assistant Examiner		Level		Non-Technical Review		Date		ANII Review		Date	
GEORGE A. MORINI		II		N/A		N/A		Dany Cordes		3-23-00		ANII Review		3/25/00	
SNC NDE Level II/III Review		Date		Percentage of Code Coverage											
Harold Soffner		3-23-00		III		N/A		%							

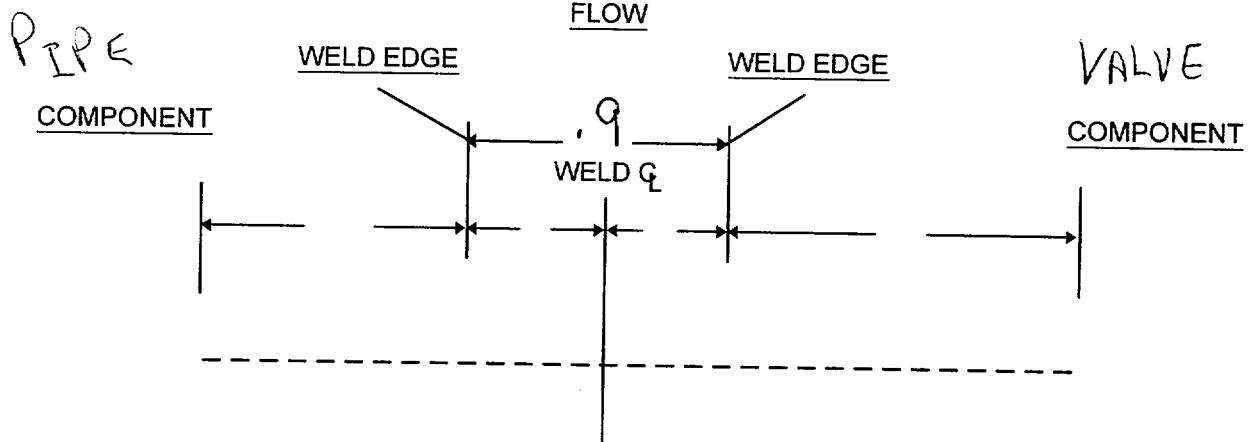
Figure 1

SHARED

Ultrasonic Weld Profile Record Southern Nuclear Operating Company

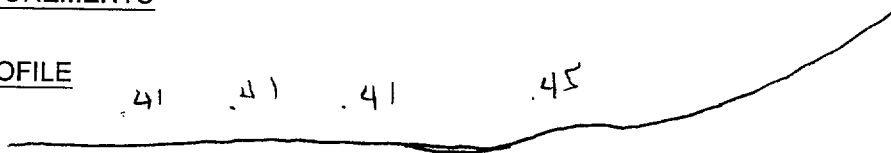
FNP-0-NDE-100.35

Unit 1	Weld Number ALA2-4101-31	Sheet Number S00F1U124	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow PIPE TO VALVE	
Location LMAX TDC WMAX WELD CL	Component Temp °F 68°		Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Danny A. Gofels</i>	Level III	Date 3-22-00	Non-Technical Review <i>Danny Cordis</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-32	Date 3/20/00	Sheet No. S00F1U138	Page / of /
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"								
Ax. dB		Size	.25	Cal. Temp.	68°								
Ref.	32.0	Frequency/Mode	5 / S	Cal. In	1300								
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1410								
Reject	OFF	Nominal Angle	45	Cal. Out	1630	1T	80	2.0	0.41	1T	80	2.1	0.45
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484	2T	45	4.0	0.82	2T	50	4.2	0.95
Mode	P/E	Cable Type	RG174	Reflector	HOLE	3T	34	6.0	1.22				
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5	4T	22	8.0	1.65				
						Calibration Remarks: NONE							

Comp. Temp.: **68°** °F Configuration: **VALVE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **(1) VALVE RESTRICTS 5 SCAN**

Total Length of Weld 21.0"	Crown Width 0.7"	Total Length of Weld Examined 5 (L) (1) 2 (L) NL 7 & 8 (W) NL		Extent of Perpendicular Scans (W) 5 - from (1) to (1) 2 - from NL to NL		Extent of Parallel Scans (L) From (5) 0.5" to (2) NL	
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A		Level N/A	
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00		Percentage of Code Coverage N/A %		Non-Technical Review <i>[Signature]</i>	
						ANII Review <i>[Signature]</i>	
						Date 3-23-00	
						Date 3/25/00	

Figure 1

Revision 7

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-32** Date **3/20/00** Sheet No. **S00F1U139** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009R2K	Thickness	.432"	1T	80	4.0	0.67				
Ax. dB		Size	.25	Cal. Temp.	68°	2T	20	8.0	1.27				
Ref.	49.6	Frequency/Mode	5 / S	Cal. In	1255	Calibration Remarks: SUPPLEMENTAL ONE SIDED EXAM.							
Scan	61.6	"A" Dimension	0.4"	Cal. Chk.	1324								
Reject	OFF	Nominal Angle	60	Cal. Out	1631								
Frequency	5.0	Measured Angle	60	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	70%/7.6								

Comp. Temp.: **68°** °F Configuration: **VALVE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI				Lmax L2	W1 Wmax W2	S1 Smax S2	1" < -- C/L -- > 1"	
2				N/A					

Examination/Limitation Remarks: **(1) VALVE RESTRICTS 5 SCAN**

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)	Extent of Parallel Scans (L)
21"	0.7"	5 (L) (1) 2 (L) NL 7 & 8 (W) N/A	5 - from (1) to (1) 2 - from NL to NL	From (5) N/A to (2) N/A
Primary Examiner	Level	Assistant Examiner	Level	Non-Technical Review
GEORGE A. MORINI	II	N/A	N/A	Darryl Corda
SNC NDE Level II/III Review	Date	Percentage of Code Coverage	ANII Review	Date
Darryl Corda	3-23-00	N/A %	C. G. Ward	3-23-00 3/25/00

Figure 1

Revision 7

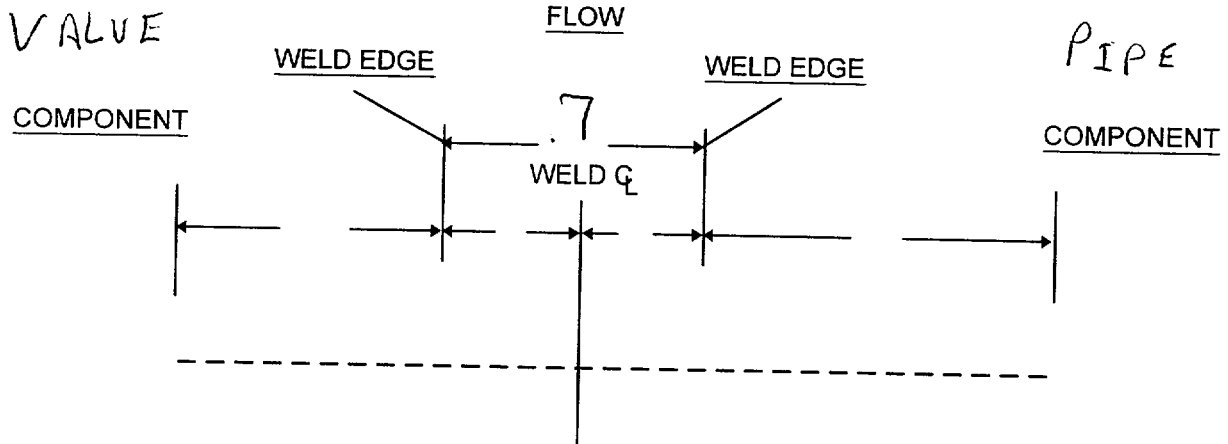
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

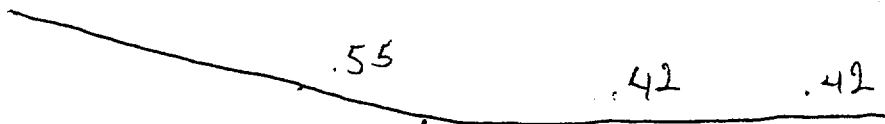
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-32	Sheet Number S00F1U125	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow VALVE TO PIPE	
Location LMAX TDC	WMAX WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Don A. Lopez</i>	Level III	Date 3-22-00	Non-Technical Review <i>Ray Cordo</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-33	Date 3/20/00	Sheet No. S00F1U140	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument				Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument		STAVELEY		Transducer Mfg.		KBA		Cal. Blk. No.		ALA-27					
Serial No.		136-898K		Serial No.		00B2J2		Thickness		.432"					
Ax. dB		32.0		Circ. dB		39.4		Cal. Temp.		68°					
Ref.		32.0		Size		.25		Cal. In		1300					
Scan		45.0		Frequency/Mode		5 / S		Cal. Chk.		1417					
Reject		OFF		"A" Dimension		0.2"		Cal. Out		1630					
Frequency		5.0		Nominal Angle		45		Cal. Blk. No.		796484					
Mode		P/E		Measured Angle		45		Reflector		HOLE					
Damping		500 OHMS		Cable Type		RG174		Amplitude/Sweep		40%/3.5					
				Cable Length		15'									

Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
1T	80	2.0	0.41	1T	80	2.1	0.45
2T	45	4.0	0.82	2T	50	4.2	0.95
3T	34	6.0	1.22				
4T	22	8.0	1.65				

Calibration Remarks:
NONE

Comp. Temp.: **68°** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld 21.0"	Crown Width 0.65"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL		
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-23-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00	Percentage of Code Coverage N/A %			ANII Review <i>[Signature]</i>			Date 3/23/00	

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-33	Sheet Number S00F1U126	Date 3/21/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884		Model Number SONIC 136	Serial Number 136-898K	
Examiner JOHN W. BELL <i>John W. Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW		
Location LMAX TDC WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	
ELBOW <u>FLOW</u> PIPE <u>COMPONENT</u> <u>WELD EDGE</u> .65 <u>WELD EDGE</u> <u>COMPONENT</u> WELD CL					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u> <i>.44 .44 .42 .42 .42</i>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Darryl D. Loftis</i>		Level III	Date 3-22-00	Non-Technical Review <i>Darryl Cordo</i>	
				Date 3-23-00	
Revision 1					

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-34	Date 3/20/00	Sheet No. S00F1U141	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 <i>15</i>	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1424	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
21.0"	0.8"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI <i>[Signature]</i>	Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-23-00	
SNC NDE Level II/III Review <i>[Signature]</i>	Date 3-23-00	Percentage of Code Coverage N/A %			ANII Review <i>[Signature]</i>			Date 3/25/00		

Figure 1

Revision 7

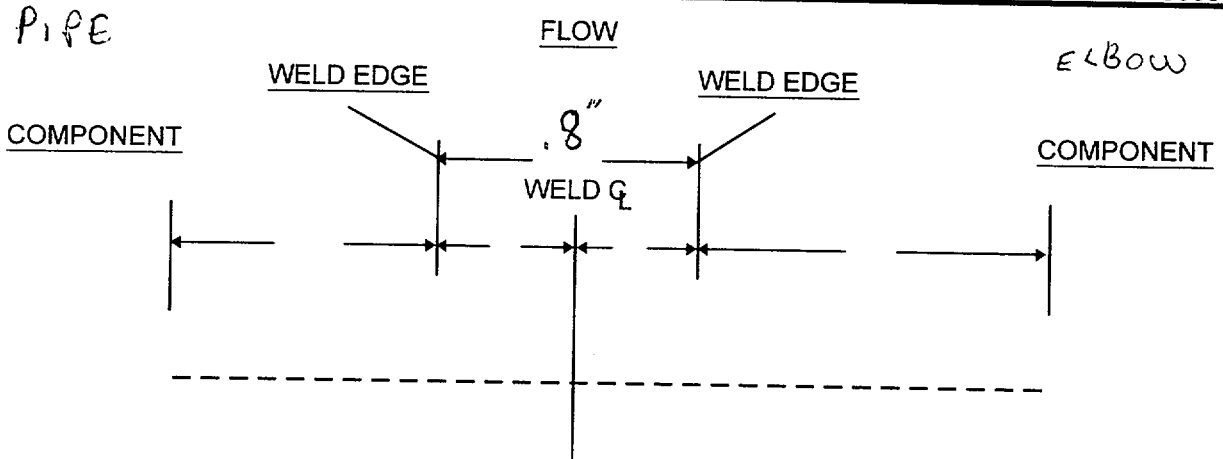
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

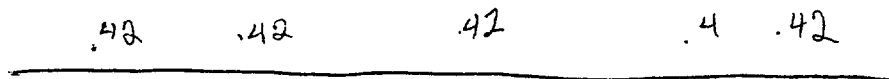
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-34	Sheet Number S00F1U127	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	
Component Configuration/Flow ELBOW TO PIPE			
Location LMAX TDC WMAX WELD CL		Component Temp °F 68°	Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Darryl A. Joffe</i>	Level III	Date 3-22-00	Non-Technical Review <i>Darryl Cordie</i>	Date 3-23-00

Revision 1

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-35** Date **3/20/00** Sheet No. **S00F1U143**
Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**
Page **1** of **1**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"								
Ax. dB	32.0	Circ. dB	39.4	Cal. Temp.	68°								
Ref.	32.0	Size	.25	Cal. In	1300								
Scan	45.0	Frequency/Mode	5 / 5	Cal. Chk.	1429								
Reject	OFF	"A" Dimension	0.2"	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Nominal Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Measured Angle	45	Reflector	HOLE								
Damping	500 OHMS	Cable Type	RG174	Amplitude/Sweep	40%/3.5								
		Cable Length	15'										

Comp. Temp.: **68°** °F Configuration: **PIPE TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: (1) VALVE RESTRICTS 2 SCAN.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
21.0"	0.8"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	(1)	to	(1)	From (5)	NL	to	(2)	0.5"
Primary Examiner		Assistant Examiner				Level				Non-Technical Review				Date						
GEORGE A. MORINI		N/A				II				N/A				3-23-00						
SNC NDE Level II/III Review		Date				Percentage of Code Coverage				ANII Review				Date						
<i>George A. Morini</i>		3-23-00				N/A %				<i>Dany Cordes</i>				3/25/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page	of
1	ALA2-4101-35	3/20/00	S00F1U144	1	1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.		
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38081 / 8/27/2000	S00F1L003		

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009R2K	Thickness	.432"	1T	80	4.0	0.67				
Ax. dB		Size	.25	Cal. Temp.	68°	2T	20	8.0	1.27				
Ref.	49.6	Frequency/Mode	5 / S	Cal. In	1255								
Scan	61.6	"A" Dimension	0.4"	Cal. Chk.	1328								
Reject	OFF	Nominal Angle	60	Cal. Out	1631								
Frequency	5.0	Measured Angle	60	Ref. Blk. No.	796484	Calibration Remarks: SUPPLEMENTAL ONE SIDED EXAM.							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	70%/7.6								

Comp. Temp.: 68° °F Configuration: PIPE TO VALVE Wo Location WELD CL Lo Location TDC

Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement W1 Wmax W2	Sweep Position S1 Smax S2	Thickness 1" < C/L > 1"	Notes:
5			N/A							

Examination/Limitation Remarks: (1) VALVE RESTRICTS 2 SCAN.

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
21.0"	0.8"	5 (L) NL	2 (L) (1)	7 & 8 (W) N/A	5 - from NL	to NL	2 - from (1)	to (1)	From (5) N/A	to (2) N/A	
Primary Examiner	Level	Assistant Examiner				Level	Non-Technical Review		Date		
GEORGE A. MORINI	II	N/A				N/A			3-23-00		
SNC NDE Level II/III Review	Date	Percentage of Code Coverage		ANII Review				Date			
	3-23-00	N/A %						3/23/00			

Figure 1

Revision 7

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Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-35		Sheet Number S00F1U128		Date 3/21/00
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884		Model Number SONIC 136		Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO VALVE		
Location LMAX	TDC	WMAX	WELD CL	Component Temp °F 68°	Thermometer S/N PTC 38081

PIPE WELD EDGE FLOW WELD EDGE VALVE

COMPONENT **6"** WELD Q COMPONENT

T. MEASUREMENTS

O.D. PROFILE

42" 42" 42" 45"

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Darryl A. Lofgren</i>	Level III	Date 3-22-00	Non-Technical Review <i>Darryl Cordes</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNPN-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page	of
1	ALA2-4101-36	3/20/00	S00F1U145	1	1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.		
FNPN-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38081 / 8/27/2000	S00F1L003		

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 / 5	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1434	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **VALVE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: (1) VALVE RESTRICTS 5 SCAN. RESTRAINT LIMITS 2 SCAN.

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)				
21.0"	0.70"	5 (L) (1)	2 (L) 12.0	7 & 8 (W)	NL	5 - from (1)	to (1)	2 - from NL	to NL	From (5)	0.5"	to (2) NL
Primary Examiner	Level	Assistant Examiner				Level	Non-Technical Review				Date	
GEORGE A. MORINI	II	N/A				N/A	Dany Cordes				3-23-00	
SNC NDE Level II/III Review	Date	Percentage of Code Coverage				ANII Review				Date		
Dany Cordes	3-23-00	N/A %				C. G. Ward				3/25/00		

Figure 1

Revision 7

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4101-36** Date **3/20/00** Sheet No. **S00F1U146** Page **1** of **1**
Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009R2K	Thickness	.432"	1T	80	4.0	0.67				
Ax. dB		Size	.25	Cal. Temp.	68°	2T	20	8.0	1.27				
Ref.	49.6	Frequency/Mode	5 / S	Cal. In	1255								
Scan	61.6	"A" Dimension	0.4"	Cal. Chk.	1333								
Reject	OFF	Nominal Angle	60	Cal. Out	1631								
Frequency	5.0	Measured Angle	60	Ref. Blk. No.	796484	Calibration Remarks: SUPPLEMENTAL ONE SIDED EXAM.							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	70%/7.6								

Comp. Temp.: **68°** °F Configuration: **VALVE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax L2	Reference Measurement W1 Wmax W2	Sweep Position S1 Smax S2	Thickness 1" < -- C/L -- > 1"	Notes:
2	●	N/A							

Examination/Limitation Remarks: (1) VALVE RESTRICTS 5 SCAN. RESTRAINT LIMITS 2 SCAN.

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)	Extent of Parallel Scans (L)
21.0"	0.7"	5 (L) (1) 2 (L) 12.0" 7 & 8 (W) N/A	5 - from (1) to (1) 2 - from NL to NL	From (5) N/A to (2) N/A
Primary Examiner GEORGE A. MORINI	Level II	Assistant Examiner N/A	Level N/A	Non-Technical Review Dany Cordes
SNC NDE Level II/III Review Dany D. Lefebvre	Date 3-23-00	Percentage of Code Coverage N/A %	ANII Review CGWand	Date 3-23-00 Date 3/25/00

Figure 1

Revision 7

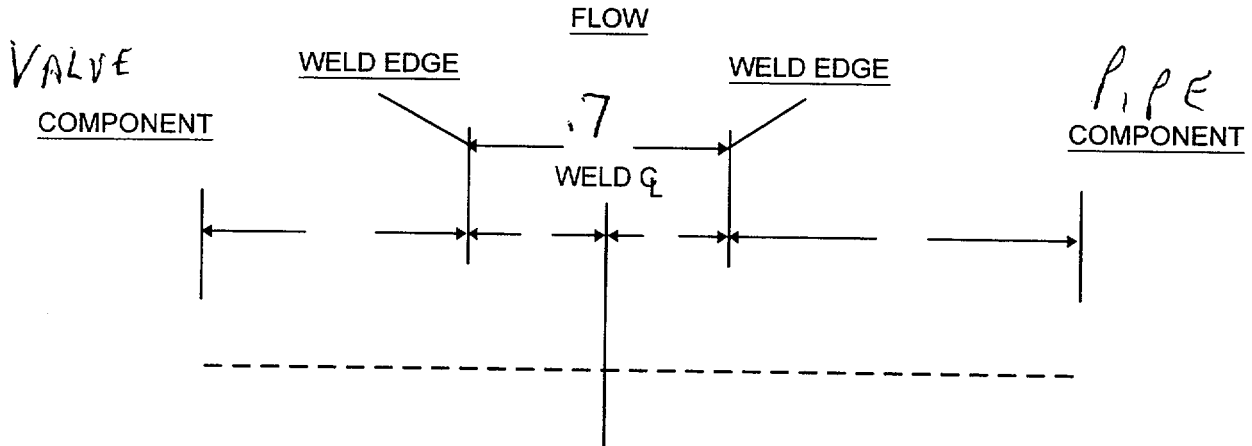
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

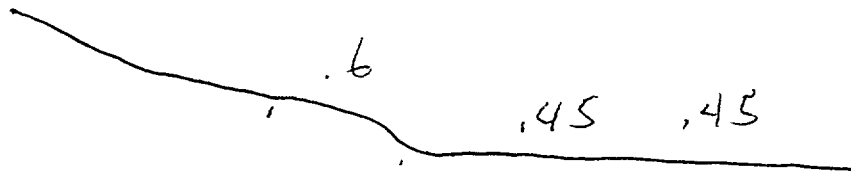
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4101-36	Sheet Number S00F1U129	Date 3/21/00
ISO/Drawing Number ALA2-4101	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	
		Component Configuration/Flow VALVE TO PIPE	
Location LMAX	TDC	WMAX	WELD CL
		Component Temp °F 68°	Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LI/III Review <i>Darryl D. Lofgren</i>	Level III	Date 3-22-00	Non-Technical Review <i>Darryl Card</i>	Date 3-23-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-37	Date 3/20/00	Sheet No. S00F1U147	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	00B2J2	Thickness	.432"	1T	80	2.0	0.41	1T	80	2.1	0.45
Ax. dB		Size	.25	Cal. Temp.	68°	2T	45	4.0	0.82	2T	50	4.2	0.95
Ref.	32.0	Frequency/Mode	5 / 6	Cal. In	1300	3T	34	6.0	1.22				
Scan	45.0	"A" Dimension	0.2"	Cal. Chk.	1440	4T	22	8.0	1.65				
Reject	OFF	Nominal Angle	45	Cal. Out	1630	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/3.5								

Comp. Temp.: **68°** °F Configuration: **PIPE TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **(1) VALVE RESTRICTS 2 SCAN.**

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)					
21.0"		0.8"		5 (L) NL		2 (L) (1)		7 & 8 (W) NL		5 - from NL to NL		2 - from (1) to (1)		From (5) NL to (2) 0.5"			
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review				Date	
GEORGE A. MORINI				II		N/A				N/A		Dany Cards				3-23-00	
SNC NDE Level II/III Review						Date		Percentage of Code Coverage				ANII Review				Date	
Harry A. Roberts III						3-23-00		N/A %				cg Wand				3/25/00	

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4101-37	Date 3/20/00	Sheet No. S00F1U148	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-27	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009R2K	Thickness	.432"	1T	80	4.0	0.67				
						2T	20	8.0	1.27				
Ax. dB	49.6	Circ. dB	N/A	Cal. Temp.	68°								
Size	.25	Frequency/Mode	5 / S	Cal. In	1255								
"A" Dimension	0.4"	Cal. Chk.	1338										
Nominal Angle	60	Cal. Out	1631										
Measured Angle	60	Ref. Blk. No.	796484										
Cable Type	RG174	Reflector	HOLE										
Cable Length	15'	Amplitude/Sweep	70%/7.6										
Calibration Remarks: SUPPLEMENTAL ONE SIDED EXAM.													

Comp. Temp.: **68°** °F Configuration: **PIPE TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI			L1 Lmax L2	W1 Wmax W2	S1 Smax S2	1"<-- C/L -->1"	
5		N/A						

Examination/Limitation Remarks: **(1) VALVE RESTRICTS 2 SCAN.**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
21.0"	0.8"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	N/A	5 - from	NL	to	NL	2 - from	(1)	to	(1)	From (5)	N/A	to	(2)	N/A
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-23-00						
SNC NDE Level I/III Review <i>[Signature]</i>		Date 3-23-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/25/00								

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4101-37	Sheet Number S00F1U130	Date 3/21/00		
ISO/Drawing Number ALA2-4101		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 800884	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO VALVE		
Location LMAX TDC WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	
<u>PIPE</u> COMPONENT <u>WELD EDGE</u> <u>VALVE</u> COMPONENT					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u> 					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Henry A. Joffe</i>		Level III	Date 3-22-00	Non-Technical Review <i>Dan Corda</i>	
				Date 3-23-00	

Revision 1

DRAWING ALA2-4150

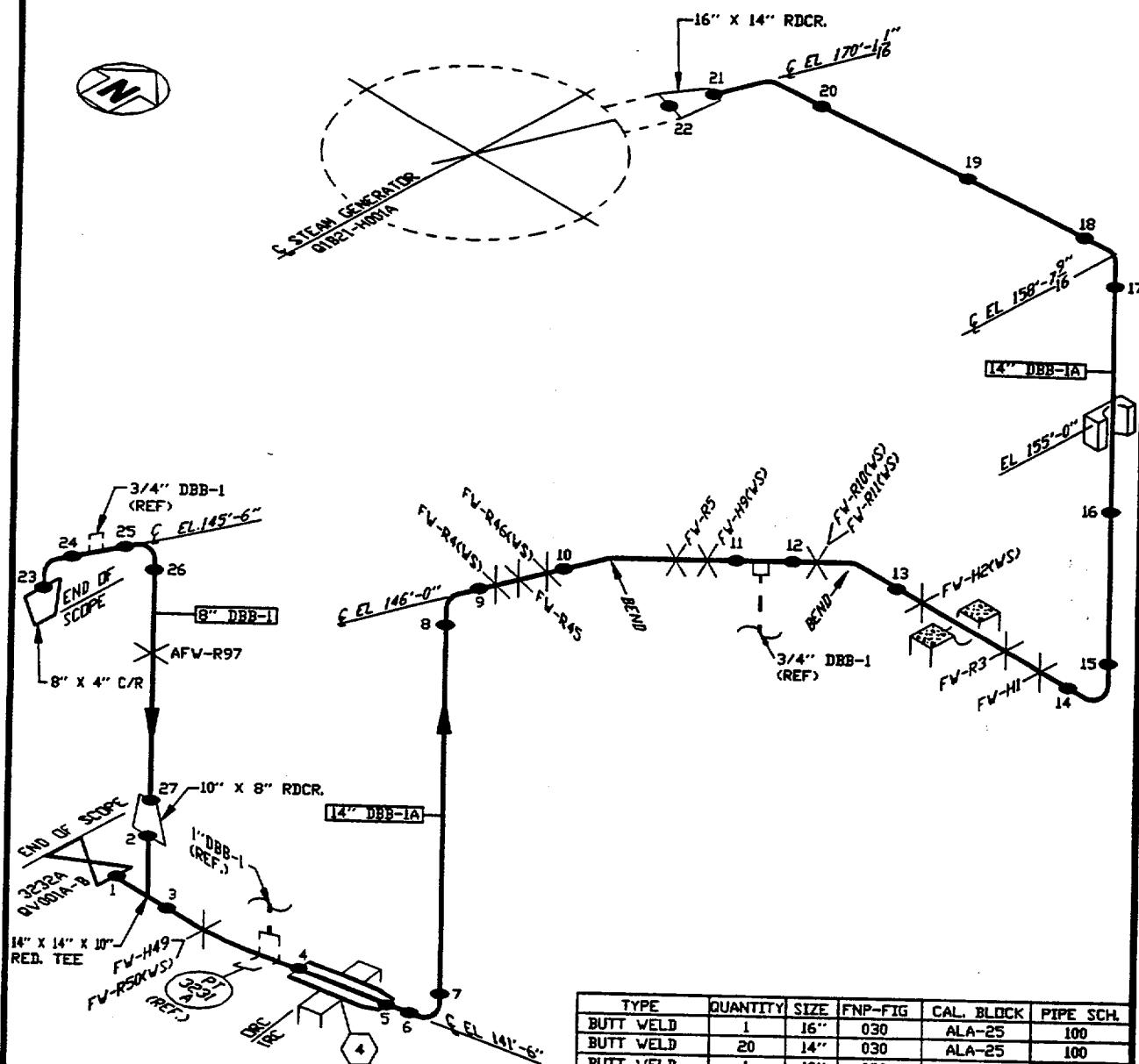
LOOP 1 FEEDWATER

[illegible]

CONTAINMENT/AUX. BUILDING

FEEDWATER
LOOP 1

ALA2-4150



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK	PIPE SCH.
BUTT WELD	1	16"	030	ALA-25	100
BUTT WELD	20	14"	030	ALA-25	100
BUTT WELD	1	10"	030	ALA-28	80
BUTT WELD	5	8"	030	N/A	80
SOCKET WELD	0	N/A	N/A	N/A	N/A
WELDED SUPP.	7	N/A	028	N/A	N/A
COMP. SUPPORT	13	N/A	037	N/A	N/A

LINE NUMBER: Q-1-N21-DBB-1, 1A

BOUNDARY DIAGRAM D-351123 SH. 1

REFERENCE ISO'S D-514186 SH. 1

LINE SIZE: 16" DBB-1A, 14" DBB-1A,
10" DBB-1, 8" DBB-1

D-514264 SH. 1

D-514499 SH. 1

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.

LDT

DLG

REV

CCM

for

WRH

REV.	DATE	BY	CHK'D	DESCRIPTION

CAB

APPR.1

APPR.2

APPR.3

APPR.4

AH

DML

Southern Company Services, Inc. for N21 - FEEDWATER

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

91

1

CAD ALA24150
AUTOCAD RAV-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4150-2	Date 3/11/00	Sheet No. S00F1U021	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A		Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-28	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	.594"								
Ax. dB		Size	.50	Cal. Temp.	72								
Ref.	33.6	Frequency/Mode	2.25 / S	Cal. In	1225								
Scan	39.6	"A" Dimension	.5	Cal. Chk.	N/A								
Reject	OFF	Nominal Angle	45	Cal. Out	1408	1T	80	2.0	.6	1T	80	21	.65
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	N/A	2T	40	4.0	1.2	2T	80	43	1.3
Mode	P/E	Cable Type	RG174	Reflector	N/A	3T	40	6.0	1.8				
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	N/A	4T	30	8.0	2.4				
Calibration Remarks: NONE													

Comp. Temp.: **72** °F Configuration: **REDUCER TO TEE** Wo Location **C/L** Lo Location **DOWNSTREA**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld 33.25"	Crown Width .75"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)						Extent of Parallel Scans (L)									
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynda Duke</i>				Date 3-14-00						
SNC/NDE Level II/III Review <i>Jan Cordes L/III</i>				Date 3-14-00		Percentage of Code Coverage 100 %				ANII Review <i>cyward</i>				Date 3/16/00						

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4150-2	Sheet Number S00F1U022	Date 3/11/00 <i>3-18-2000</i>		
ISO/Drawing Number ALA2-4150		Couplant/Batch Number SONATRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 796492		Model Number SONIC 136	Serial Number 136-911K	
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 009YWT	Frequency 2.25 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow REDUCER TO TEE		
Location LMAX DOWNSTREAM WMAX C/L			Component Temp °F 72	Thermometer S/N PTC 38081	

FLOW

COMPONENT **REDUCER** **WELD Q** COMPONENT **TEE**

Dimensions: .75" (Reducer to weld start), .375" (Weld start to C/L), .375" (C/L to weld end), .75" (Weld end to Tee)

T. MEASUREMENTS

O.D. PROFILE

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>[Signature]</i>	Level III	Date 3-14-00	Non-Technical Review <i>[Signature]</i>	Date 3-13-00

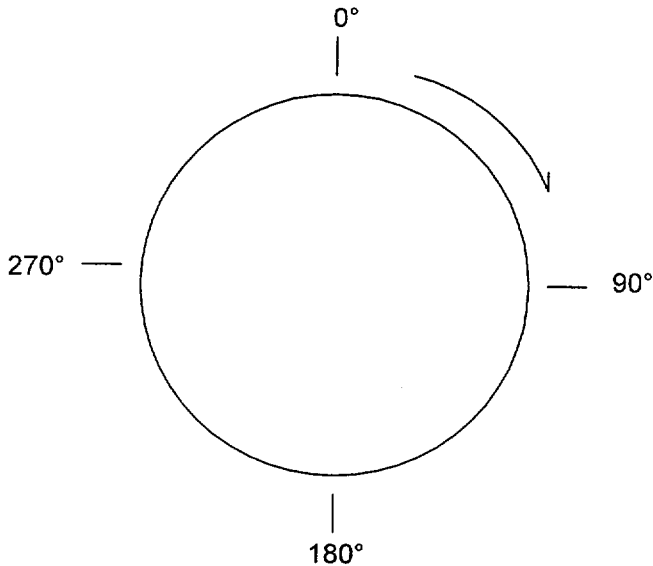
Revision 1

Ultrasonic Thickness and Contour Examination Record

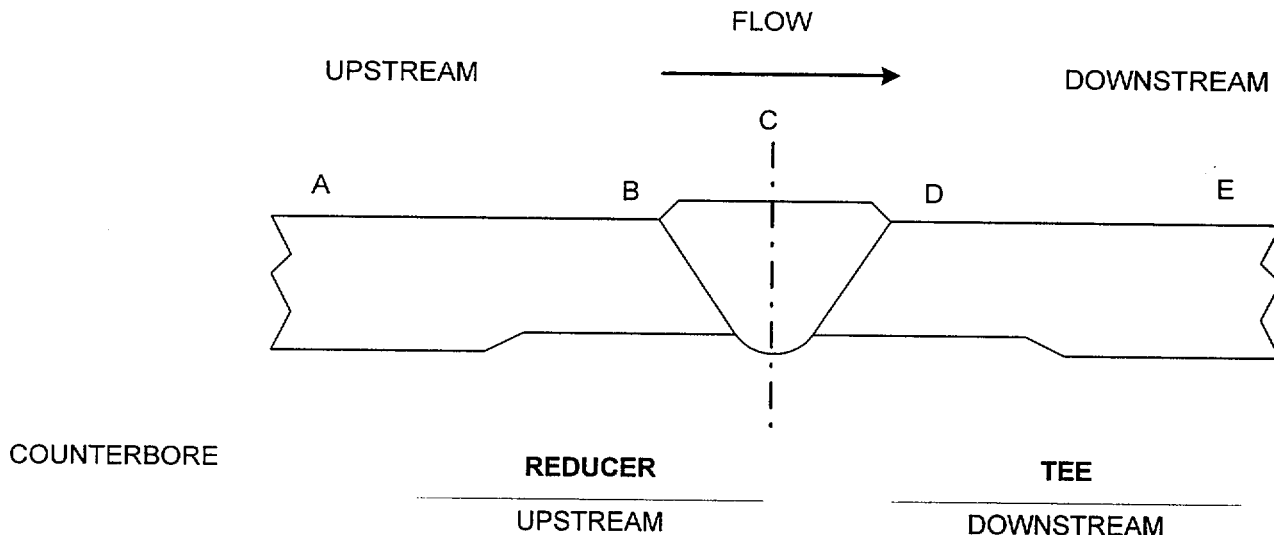
FNP-0-NDE-100.35

Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4150-2	Sheet No. S00F1U023	Date 3/13/2000
Drawing Number ALA2-4150	Couplant/Batch Number SONATRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type ☐ C/S ☐ S/S Other	Calibration Standard/ Serial No. CS STEP / 796492	Model Number SONIC 136	Serial Number 136-911K
Examiner GEORGE A. MORINI <i>[Signature]</i>	SNT Level II	Transducer Manufacturer KBA	Type N/A
Examiner N/A	SNT Level N/A	Serial Number 009YWT	Frequency 2.25 MHz



Location	0°	90 °	180°	270°
A	.65	.65	.65	.65
B	.5	.5	.5	.55
C	.55	.55	.55	.55
D	.55	.55	.55	.55
E	.6	.6	.6	.6



REMARKS:

JE Level II/III Review <i>[Signature]</i>	Level III	Date 3-14-00	Non-Technical Review <i>[Signature]</i>	Date 3-13-00

Revision 1

SHARED

FNP-0-NDE-100.11

MT-F-Form 002

Farley Nuclear Plant

Magnetic Particle Examination Record

Southern Nuclear Operating Company

Unit 1	Component No. ALA2-4150-2	Procedure/Rev./TCN FNP-0-NDE-100.11 / 4 / N/A	Sheet No. S00F1M003	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg./Ser. No. PTC / 38102 Cal. Due Date 8/27/2000 Surface Temp. 71 ° F		<u>Magnetizing Yoke</u> Mfg.: MAGNAFLUX Power AC Serial No: A999048 Pole Spacing: Field Indicator S/N: N/A Field Indicator Acceptable [Y/N] N/A		<u>MT Materials</u> Mfg.: MAGNAFLUX Batch Number: 98C020 Color: 8A RED Type: N/A
Component Configuration REDUCER TO TEE			% of Length Coverage 100	Date 3/11/00
			% of Area Coverage 100	
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.		Remarks
N/A	NRI	N/A		N/A

Remarks:

Primary Examiner VICTOR DITTRICH	ASNT Level II	Initials <i>AWD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynda Duke</i>	Date 3-13-00
SNC NDE Level II/III Review <i>Danny Cordes L/III</i>			Date 3-14-00	Percentage of Code Coverage 100 %	ANII Review <i>CGH</i>		Date 3/16/00

Figure 3

Revision 4

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4150-27	Date 3/11/00	Sheet No. S00F1U024	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																								
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>.5</td> <td>1T</td> <td>80</td> <td>2.2</td> <td>.55</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.0</td> <td>1.0</td> <td>2T</td> <td>75</td> <td>43</td> <td>1.2</td> </tr> <tr> <td>3T</td> <td>40</td> <td>6.0</td> <td>1.5</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>30</td> <td>8.0</td> <td>2.0</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	.5	1T	80	2.2	.55	2T	40	4.0	1.0	2T	75	43	1.2	3T	40	6.0	1.5					4T	30	8.0	2.0					Calibration Remarks: NONE			
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																										
1T	80	2.0	.5	1T	80		2.2	.55																																										
2T	40	4.0	1.0	2T	75		43	1.2																																										
3T	40	6.0	1.5																																															
4T	30	8.0	2.0																																															
Serial No.	136-911K	Serial No.	009R2W	Thickness	.500"																																													
Ax. dB		Circ. dB		Cal. Temp.	72																																													
Ref.	33.6	43.6	Size	.375	Cal. In	1225																																												
Scan	45	49.6	Frequency/Mode	2.25 /	Cal. Chk.	N/A																																												
Reject	OFF		"A" Dimension	.3	Cal. Out	1410																																												
Frequency	2.25		Nominal Angle	45	Ref. Blk. No.	N/A																																												
Mode	P/E		Measured Angle	45	Reflector	N/A																																												
Damping	500 OHMS		Cable Type	RG174	Amplitude/Sweep	N/A																																												
			Cable Length	15'																																														

Comp. Temp.: **72** °F Configuration: **PIPE TO REDUCER** Wo Location **C/L** Lo Location **DOWNSTREA**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

RESTRAINT LIMITS 5 SCAN

Total Length of Weld 33.25"	Crown Width .75"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	0	to	2.0"	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynda Duke</i>				Date 3-13-00						
SNC NDE Level II/III Review <i>Dan Cordes</i>		Date 3-14-00		Percentage of Code Coverage 100 %				ANII Review <i>CGH</i>				Date 3/16/00								

Figure 1

Revision 7

8" PIPE

FLOW →

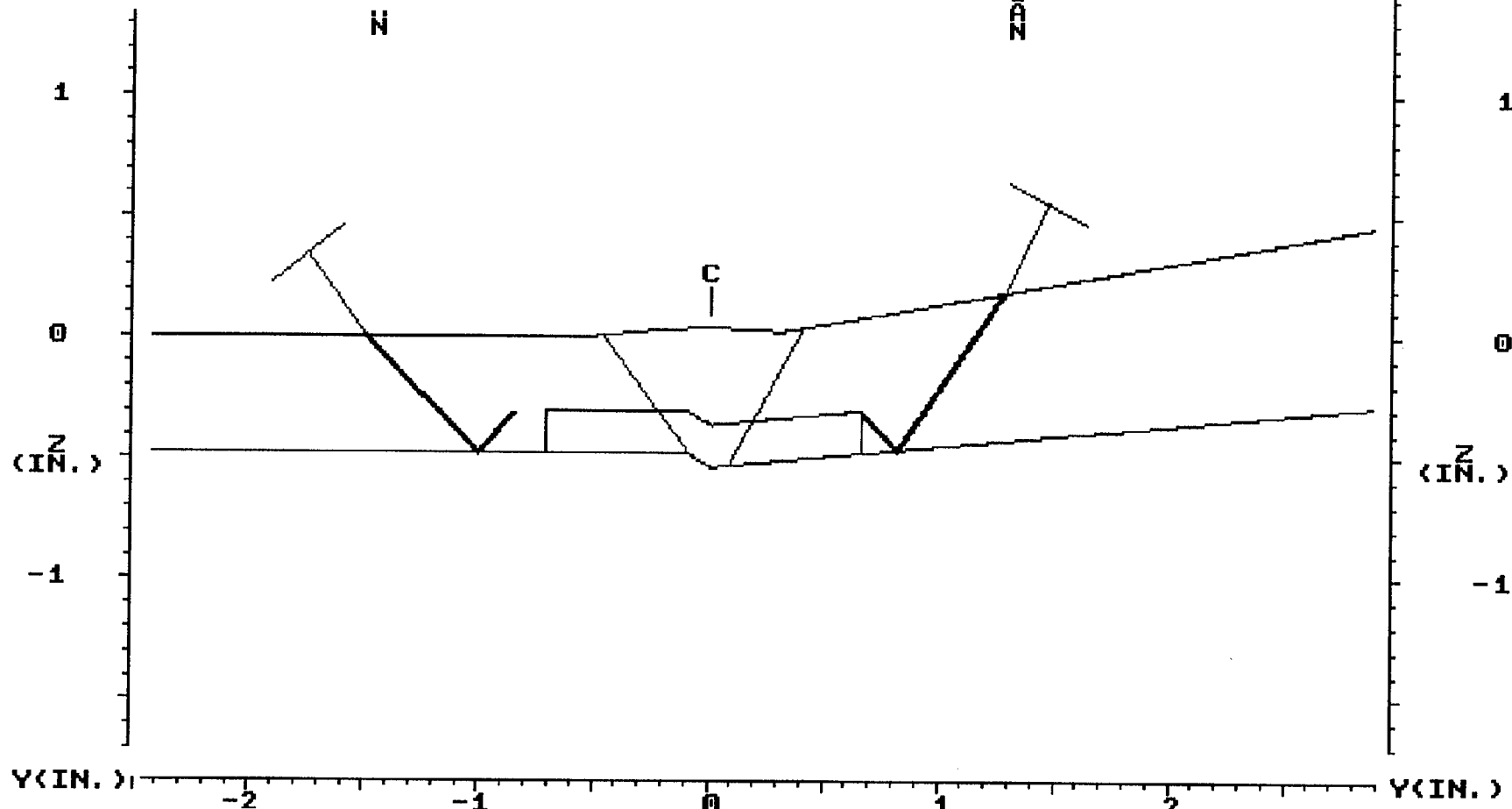
REDUCER

5

2

SCANN

N



5 SCAN	SET	1R16003.DAT	1R16003A.SCR	2 SCAN	SET
0.64	DEP	45 DEGREE CODE COVERAGE - 100% OBTAINED		0.71	DEP
0.91	MP			1.00	MP
22.55	TOF			24.00	TOF
	ARC				ARC
	GATE				GATE
0.050	STEP	DR CORDES L/III		0.050	STEP
	EXIT	MAKERAY/UTILITY LEFT RIGHT TOP PRINT EXIT			EXIT
PLANT: FARLEY 1		3/14/00		CIRC. POS.: TYP	
SYSTEM: FEEDWATER		7:18		ANALYST: DR CORDES L/III	
COMPONENT: ALA2-4150-27				CAL. SHEET: SQ00F1U024	

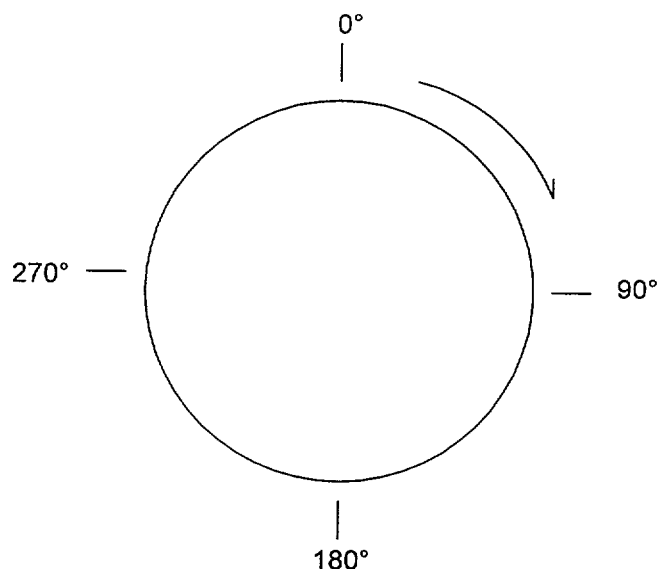
2 OF 2

Ultrasonic Thickness and Contour Examination Record

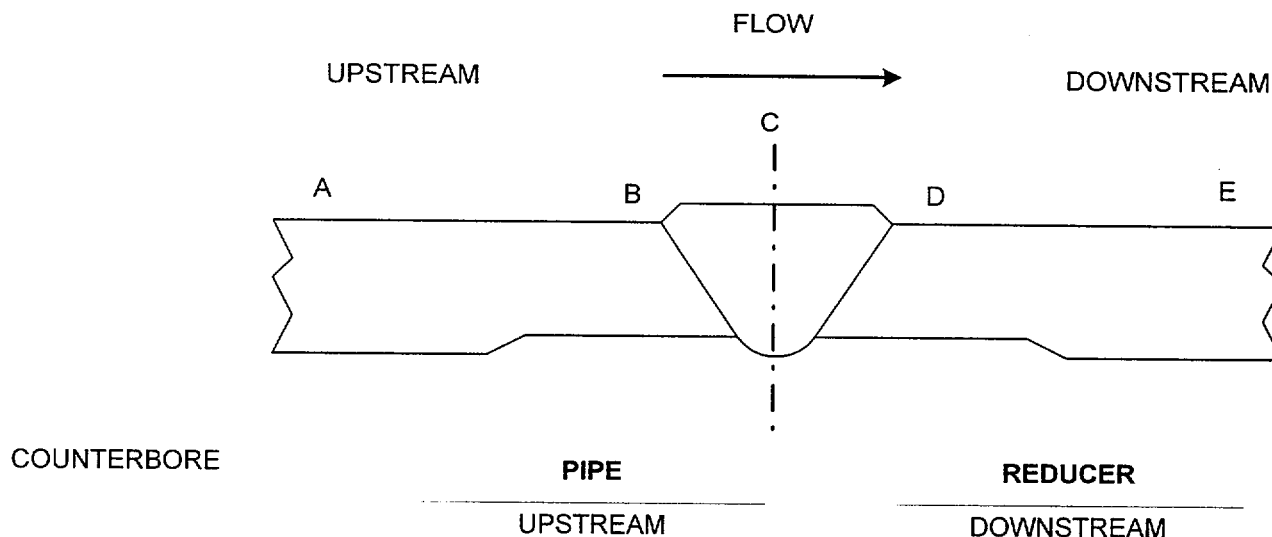
FNP-0-NDE-100.35

Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4150-27	Sheet No. S00F1U026	Date 3/13/2000
Drawing Number ALA2-4150	Couplant/Batch Number SONATRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type ☐ C/S ☐ S/S Other	Calibration Standard/ Serial No. CS STEP / 796492	Model Number SONIC 136	Serial Number 136-911K
Examiner GEORGE A. MORINI <i>[Signature]</i>	SNT Level II	Transducer Manufacturer KBA	Type N/A
Examiner N/A	SNT Level N/A	Serial Number 009YWT	Frequency 2.25 MHz



Location	0°	90 °	180°	270°
A	.48	.48	.48	.48
B	.48	.48	.48	.48
C	.65	.65	.65	.65
D	.55	.55	.55	.55
E	.75	.75	.75	.75



REMARKS: E LOCATION @ 1" OF CENTERLINE

E Level II/III Review

Level

Date

Non-Technical Review

Date

Dan Cordis *L III**III**3-14-00**Lynda Duke**3-13-00*

Revision 1

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4150-27		Sheet Number S00F1U025		Date 3/11/00
ISO/Drawing Number ALA2-4150		Couplant/Batch Number SONATRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number CS STEP / 796492		Model Number SONIC 136	Serial Number 136-911K	
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 009YWT	Frequency 2.25 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO REDUCER		
Location LMAX DOWNSTREAM WMAX C/L			Component Temp °F 72 Thermometer S/N PTC 38081		
<u>FLOW</u>					
<u>T. MEASUREMENTS</u> <u>O.D. PROFILE</u> .48" .48" .65" .55" .75"					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Dan Cordo</i>		Level III	Date 3-14-00	Non-Technical Review <i>Lynda Duke</i>	
				Date 3-13-00	

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

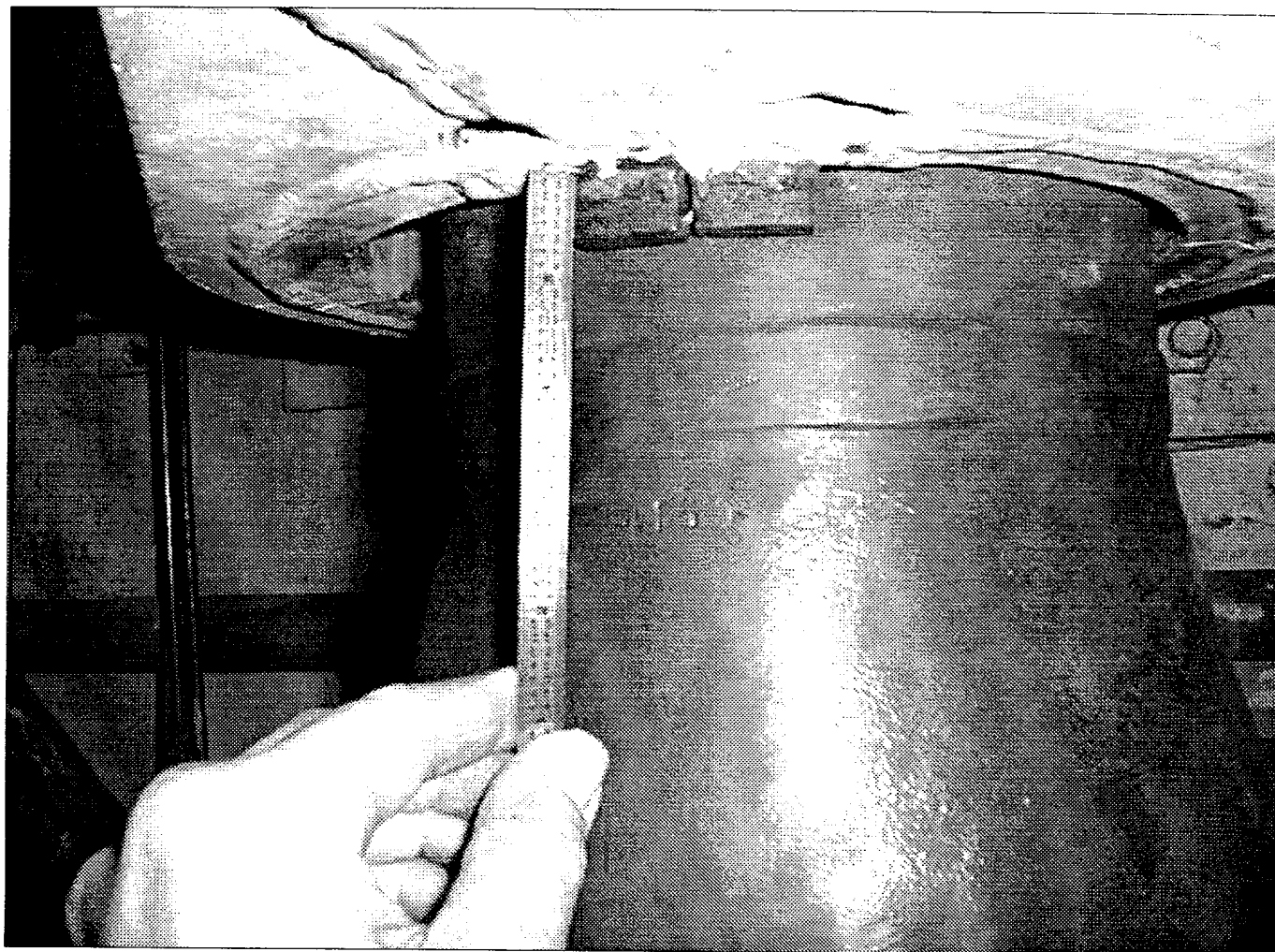
Unit 1	Component Number ALA2-4150-27	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P001	Page 1 of 2
Thermometer Mfg. / Ser. No. PTC / 38102 Cal. Due Date 8/27/2000 Surface Temp. 71 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 96C09K 93D12K 93J02P		
Component Configuration PIPE TO REDUCER		% of Length Coverage 100	Date 3/11/00	
% of Area Coverage 100				
Ind. No. N/A	Results NRI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks:

Primary Examiner VICTOR DITTRICH	ASNT Level II	Initials <i>AMD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynda Duke</i>	Date 3-13-00
SNC NDE Level II/III Review <i>Jay Cordes L/TU</i>		Date 3-14-00	Percentage of Code Coverage 100 %	ANII Review <i>CSK</i>		Date 3/16/00	

Figure 1

Revision 6



Name: ala2-4150-27.jpg
Dimensions: 1024 x 768 pixels

PT IN LIEU OF MT TO OBTAIN ASME CODE COVERAGE.

JRL L/III 3-14-00

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4150-FW-R50	WO/WA/STP N/A	Sheet No. S00F1V008
Hanger Type ONE DIRECTIONAL RESTRAINT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/10/00
Examiner / Initial PAUL D'VALERIO Sig. <i>Paul D'Valerio</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable/Unacceptable Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments: PLANT IN MODE 6 AT EXAM TIME			
<i>Danny Cordes LIII 3-11-2000</i>		<i>ANNT REVIEW: Cg Ward 3/15/00</i>	

DRAWING ALA2-4500

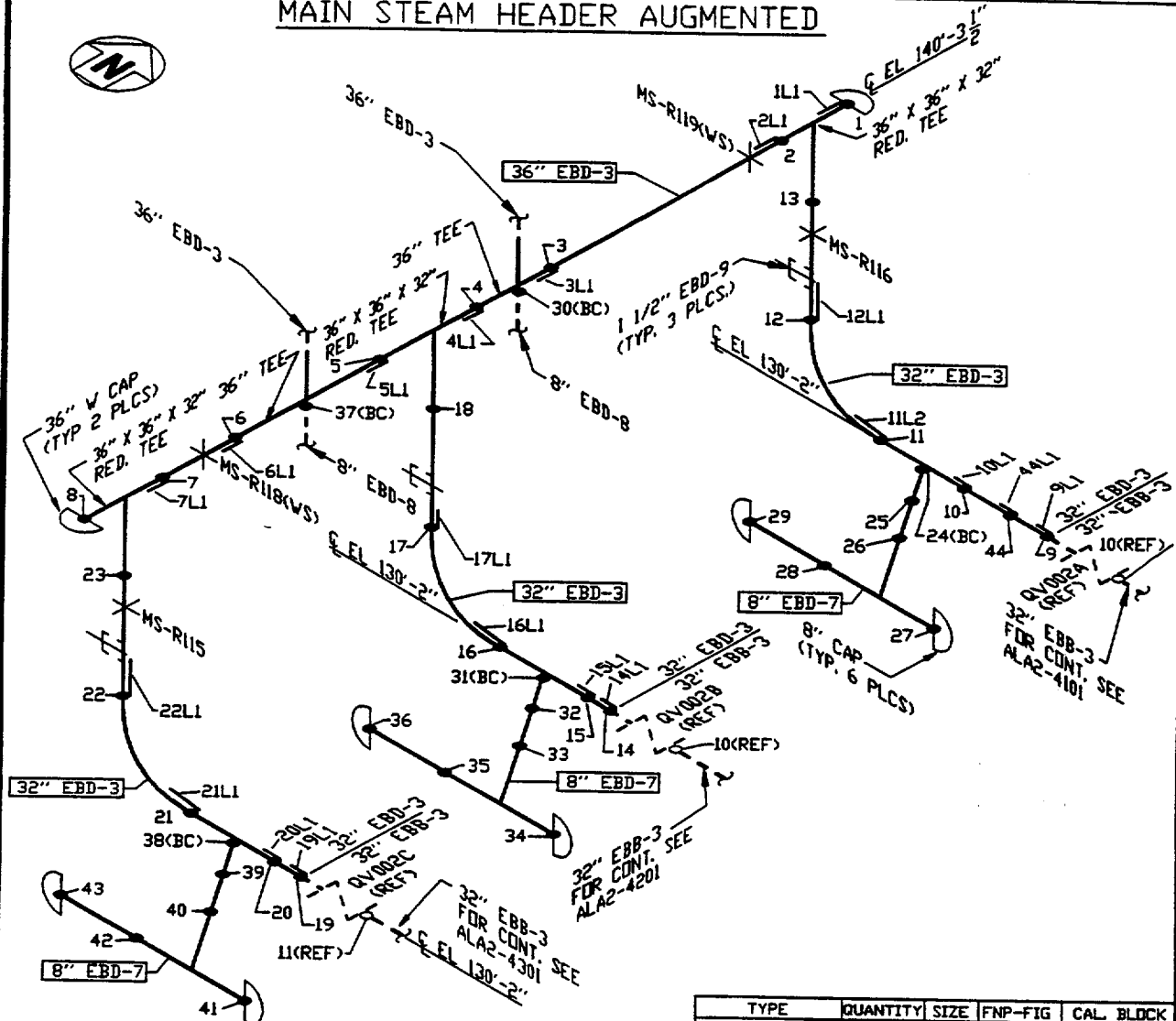
MAIN STEAM HEADER

[illegible]

MAIN STEAM ROOM 241

ALA2-4500

MAIN STEAM HEADER AUGMENTED



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLDCK
BUTT WELD	8	36"	036	APR-4
BUTT WELD	16	32"	036	ALA-24
BUTT WELD	15	8"	036	ALA-26
LONG SEAM WELD	7	36"	036	ALA-24
LONG SEAM WELD	5	36"	036	APR-4
LONG SEAM WELD	13	32"	036	ALA-24
SOCKET WELD	0	N/A	N/A	N/A
BRANCH CONN.	5	8"	036	ALA-24
				ALA-26
WELDED SUPP.	2	N/A	028	N/A
COMP. SUPPORT	4	N/A	037	N/A

LINE NUMBER: Q-1-N11-EBD-3

Q-1-N11-EBD-7

BOUNDARY DIAGRAM D-351114 SH. 2

REFERENCE ISO'S D-514304 SH. 1

LINE SIZE: 36" EBD-3; 32" EBD-3

D-514303 SH. 1 & 2

8" EBD-7

D-514305 SH. 1

2	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG	DEFV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCH	For WRH	AH	DML
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for E11 - MAIN STEAM

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

98

2

CAD ALA2-4500
AUTOCAD RAV-03

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-1	Date 3/21/00	Sheet No. S00F1U103	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24 APR-4									
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20" / 1.81"	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Ax. dB		Circ. dB		Size	.50	Cal. Temp.								
Ref.	29.2	31.0	Frequency/Mode	2.25 / S	Cal. In	0819	1T	80	3.0	1.81	1T	80	3.2	2.15
Scan	39.2	41.0	"A" Dimension	.5"	Cal. Chk.	1025	2T	30	6.0	3.62	2T	20	6.4	4.29
Reject	OFF		Nominal Angle	45	Cal. Out	1220	3T	12	9.0	5.40				
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	15'	Amplitude/Sweep	22%/1.4								

Comp. Temp.: **62** °F Configuration: **CAP TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2			●	1	178%	113.05	0.00	0.20	4.7	5.0	5.3	8.1	8.3	8.4	1.88	1.24	1.22	
7	●		○	N/A														
8	●		○	N/A														

Examination/Limitation Remarks: (1) REFERENCE S00F1U104 FOR 5 SCAN (ALA-24). TAPER LIMITS 2 SCAN FROM 0" TO 1.9".

Total Length of Weld 113.25	Crown Width 1.6"	Total Length of Weld Examined 5 (L) N/A 2 (L) NL 7 & 8 (W) NL	Extent of Perpendicular Scans (W) 5 - from (1) to (1)		Extent of Parallel Scans (L) 2 - from 1.9" to NL	
Primary Examiner JOSEPH D. FUNYAK		Level II	Assistant Examiner N/A		Level N/A	Non-Technical Review <i>[Signature]</i>
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-24-00	Percentage of Code Coverage NA %		ANII Review <i>[Signature]</i>	Date 3-22-00 Date 3/28/00

Figure 1

Revision 7

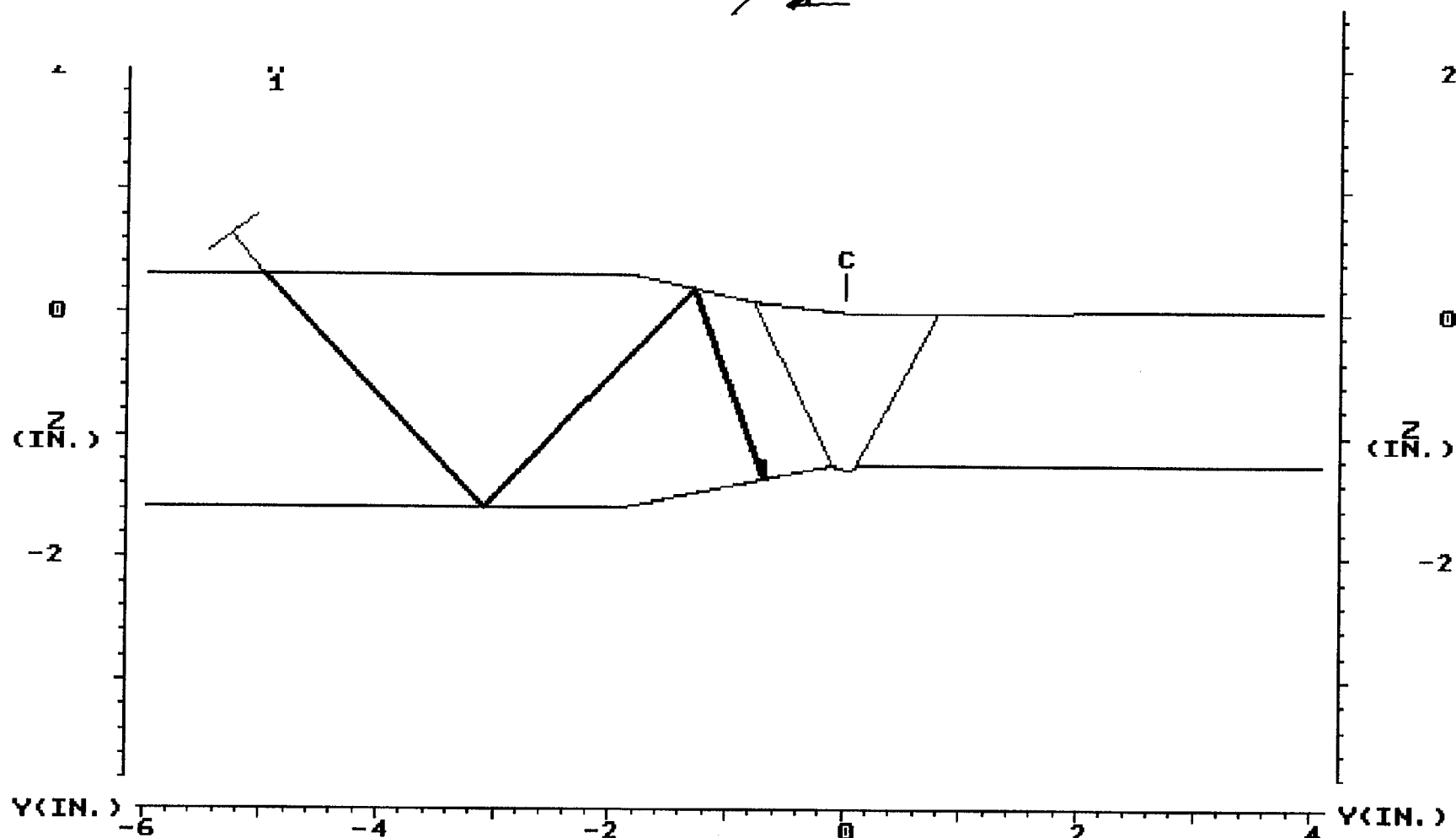
TEE

4

FLOW

DrC
3-24-00

CAP



45 IN1	SET	1R16018.DAT 1R16018A.SCR						45 IN1	SET
4.99	DEP							0.00	DEP
7.05	MP	45 DEG IND # 1 - ID GEOMETRY						0.00	MP
120.80	TOF	COMPARES WITH 1988 DATA						8.00	TOF
	ARC								FAN
	GATE								GATE
0.050	STEP	DR CORDES L/III						1.000	STEP
	EXIT	MAKERAY/UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT		EXIT
PLANT: FARLEY 1		3/24/00		CIRC. POS.: TYP					
SYSTEM: MAIN STEAM				ANALYST: DR CORDES L/III					
COMPONENT: ALA2-4500-1		11:49		CAL. SHEET: S00F1U103					

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-1	Date 3/21/00	Sheet No. S00F1U104	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument			Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY		Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K		Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.20	1T	80	2.1	1.30
Ax. dB	Circ. dB	Size	.50	Cal. Temp.	68°	2T	40	4.0	2.30	2T	40	4.2	2.60	
Ref.	28.2	30.8	Frequency/Mode	2.25 / S	Cal. In	0810	3T	20	6.0	3.50				
Scan	38.2	40.8	"A" Dimension	.5"	Cal. Chk.	1010	4T	15	8.0	4.60				
Reject	OFF		Nominal Angle	45	Cal. Out	1215	Calibration Remarks: NONE							
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	15'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **62** °F Configuration: **CAP TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: (1) REFERENCE S00F1U103 FOR 2 SCAN (APR-4).

Total Length of Weld 113.25	Crown Width 1.6"	Total Length of Weld Examined 5 (L) NL 2 (L) N/A 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL				Extent of Parallel Scans (L) 2 - from (1) to (1) From (5) NL to (2) NL			
Primary Examiner JOSEPH D. FUNYAK		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>				Date 3-22-00	
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-24-00	Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/28/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4500-1	Sheet Number S00F1U116	Date 3/21/00		
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA	Size .50	
Examiner N/A		SNT Level N/A	Serial Number E10603	Frequency 5.0	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow CAP TO TEE		
Location LMAX	TDC	WMAX	WELD CL	Component Temp °F 62°	Thermometer S/N PTC 38180

← **FLOW**

WELD EDGE **WELD CL** **WELD EDGE**

COMPONENT **TEE** **CAP** **COMPONENT**

T. MEASUREMENTS

O.D. PROFILE

1.90	1.90	1.90	1.88	1.28	1.25	1.24	1.23	1.23	1.22	1.22	1.23	1.24	1.24	1.25	1.25	1.26	1.30	1.32

T. MEASUREMENT EACH .25 IN.

REMARKS:

NDE-LII/III Review <i>James Carver</i>	Level III	Date 3-23-00	Non-Technical Review <i>Barry P. Hoffman</i>	Date 3-22-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-1L1	Date 3/21/00	Sheet No. S00F1U105	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-4	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.810"	1T	80	3.0	1.81	1T	80	3.2	2.15
Ax. dB		Size	.50	Cal. Temp.	68°	2T	30	6.0	3.62	2T	20	6.4	4.29
Ref.	29.2	Frequency/Mode	2.25 / S	Cal. In	0819	3T	12	9.0	5.40				
Scan	39.2	"A" Dimension	.5"	Cal. Chk.	1045	Calibration Remarks: NONE							
Reject	OFF	Nominal Angle	45	Cal. Out	1220								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	22%/1.4								

Comp. Temp.: **62 °F** Configuration: **TEE LONG SEAM** Wo Location **WELD CL** Lo Location **CIRC WELD 1**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld 51.5"	Crown Width 2.0"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)					Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner JOSEPH D. FUNYAK		Level II		Assistant Examiner N/A					Level N/A		Non-Technical Review <i>[Signature]</i>					Date 3-22-00				
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-24-00		Percentage of Code Coverage N/A %					ANII Review <i>[Signature]</i>					Date 3/27/00				

Figure 1

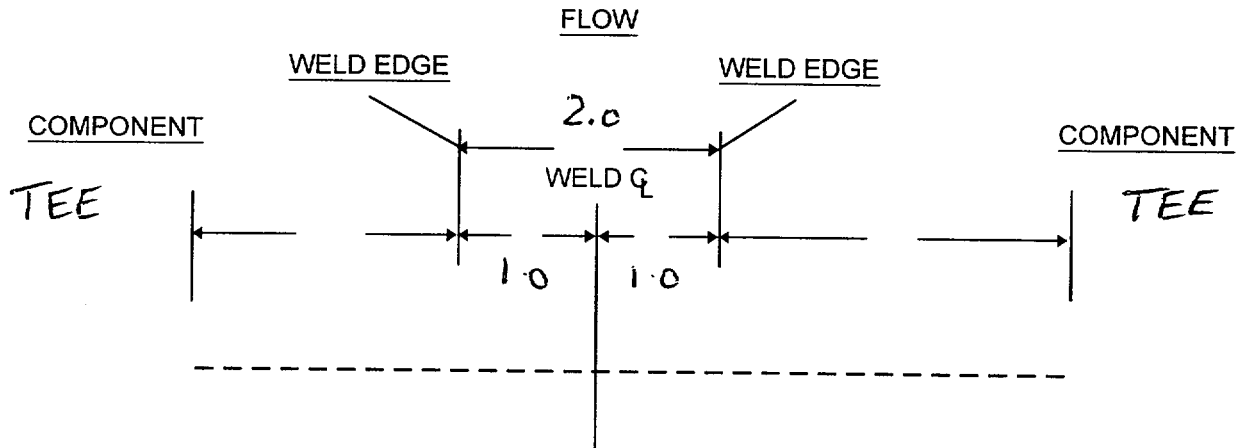
Revision 7

SHARED

Ultrasonic Weld Profile Record Southern Nuclear Operating Company

FNP-0-NDE-100.35

Unit 1	Weld Number ALA2-4500-1L1	Sheet Number S00F1U117	Date 3/21/00
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA
Examiner N/A		SNT Level N/A	Size .50
Weld Examination Record No. N/A		Indication No. N/A	Frequency 5.0 MHz
		Component Configuration/Flow TEE LONG SEAM	
Location LMAX	TDC	WMAX	WELD CL
		Component Temp °F 62°	Thermometer S/N PTC 38180



T. MEASUREMENTS

O.D. PROFILE

1.90 1.89 1.89 1.87 1.87 1.86 1.90 1.92 1.93 1.94 1.94 1.93 1.91 1.90 1.85 1.85 1.86 1.87 1.88 1.88

T. MEASUREMENT EACH .25" IN.

REMARKS:

NDE LII/III Review <i>Dan Cordis</i>	Level III	Date 3-23-00	Non-Technical Review <i>Dan A. Hopkins</i>	Date 3-22-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-2	Date 3/21/00	Sheet No. S00F1U107	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-4	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.810"	1T	80	3.0	1.81	1T	80	3.2	2.15
Ax. dB		Size	.50	Cal. Temp.	68°	2T	30	6.0	3.62	2T	20	6.4	4.29
Ref.	29.2	Frequency/Mode	2.25 /	Cal. In	0819	3T	12	9.0	5.40				
Scan	39.2	"A" Dimension	.5"	Cal. Chk.	1110								
Reject	OFF	Nominal Angle	45	Cal. Out	1220								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	22%/1.4								

Comp. Temp.: **62** °F Configuration: **TEE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
5			●	1	70		113.25			5.0			8.5		1.84	1.20	1.30	SPOT IND
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: (1) REFERENCE S00F1U106 FOR 2 SCAN (ALA-24). TAPER LIMITS 5 SCAN FROM 0" TO 1.6".

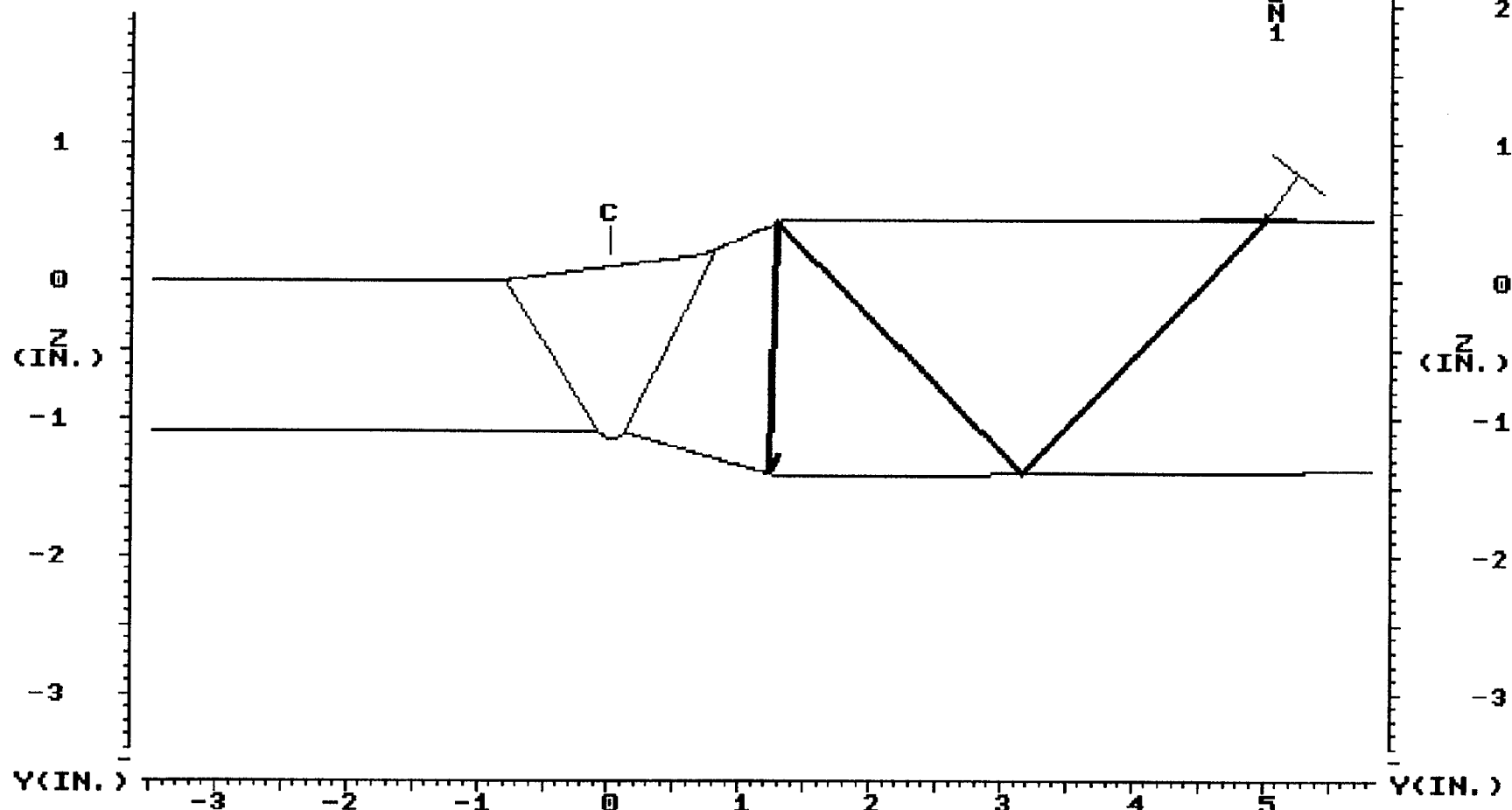
Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
113.25	1.6"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	NL	5 - from	1.6	to	NL	2 - from	(1)	to	(1)	From (5)	NL	to	(2)	NL
Primary Examiner JOSEPH D. FUNYAK		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-28-00						
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-24-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/28/00								

Figure 1

Revision 7

PIPE

45 IN 1



45 IN1	SET	1R16019.DAT 1R16019A.SCR						SET
5.10	DEP							DEP
7.22	MP	45 DEG IND 1 - ID GEOMETRY						MP
123.45	TOF							TOF
	ARC	COMPARES WITH 1988 DATA						ARC
	GATE							GATE
0.050	STEP	DR CORDES L/III						STEP
	EXIT	MAKERAY	UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT
PLANT: FARLEY 1		3/24/00		CIRC. POS.: TYP				
SYSTEM: MAIN STEAM				ANALYST: DR CORDES L/III				
COMPONENT: ALA2-4500-2		12:40		CAL. SHEET: 500511103				

APC 3.24.00

500F1U107

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-2	Date 3/21/00	Sheet No. S00F1U106	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"								
Ax. dB		Size	.50	Cal. Temp.	68°								
Ref.	28.2	Frequency/Mode	2.25 / 5	Cal. In	0810								
Scan	38.2	"A" Dimension	.5"	Cal. Chk.	1135								
Reject	OFF	Nominal Angle	45	Cal. Out	1215	4T	15	8.0	4.60				
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: NONE							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **62** °F Configuration: **TEE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: (1) REFERENCE S00F1U107 FOR 5 SCAN (APR-4).
(2) MS-R119 (WS) LIMITS 2 SCAN IN 2 PLACES FROM CL TO 1.5" FOR A TOTAL OF 28" OF 113.25".

Total Length of Weld 113.25	Crown Width 1.6"	Total Length of Weld Examined 5 (L) (1) 2 (L) (2) 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from (1) to (1) 2 - from (2) to (2)				Extent of Parallel Scans (L) From (5) NL to (2) NL			
Primary Examiner JOSEPH D. FUNYAK		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Darryl D. Bopkas</i>			
SNC NDE Level II/III Review <i>Darryl D. Bopkas</i>		Date 3-24-00		Percentage of Code Coverage N/A %				ANII Review <i>C. G. W. W.</i>		Date 3-22-00			

Figure 1

Revision 7

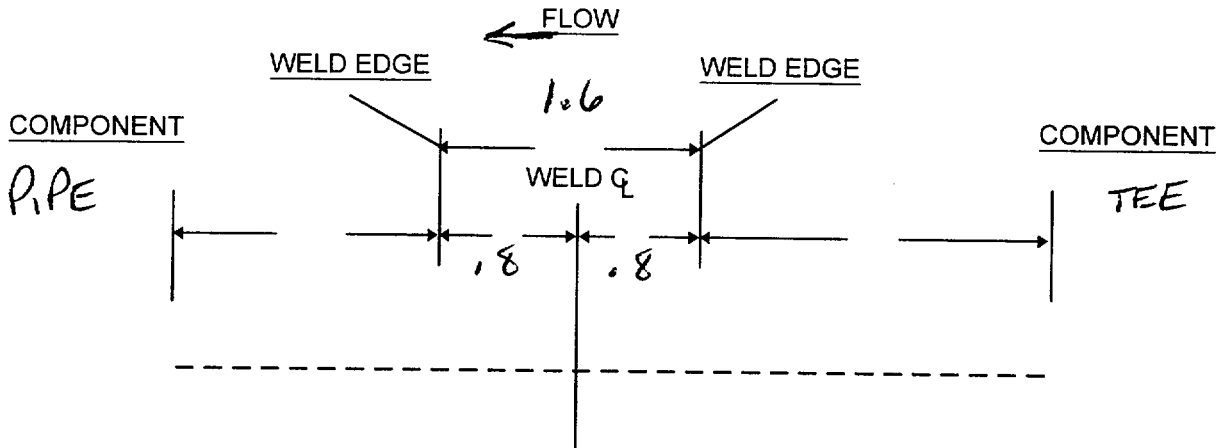
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

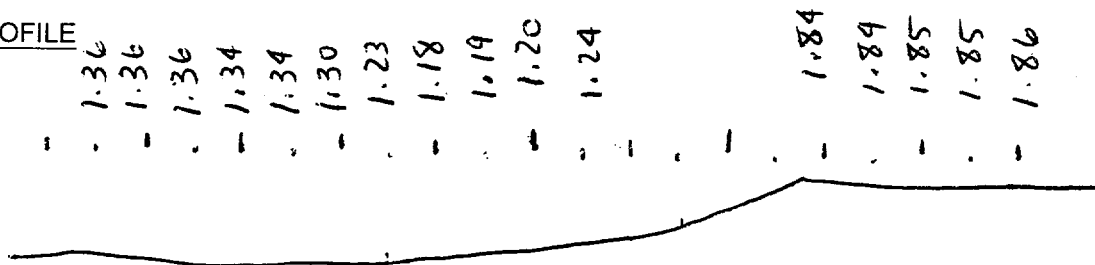
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4500-2	Sheet Number S00F1U118	Date 3/21/00
ISO/Drawing Number ALA2-4500	Couplant/Batch Number SONOTRACE 40 / 94243		
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484		Instrument Manufacturer STAVELEY
Examiner JOSEPH D. FUNYAK	SNT Level II	Model Number SONIC 136	Serial Number 136-911K
Examiner N/A	SNT Level N/A	Search Unit Manufacturer KBA	Size .50
Weld Examination Record No. N/A	Indication No. N/A	Serial Number E10603	Frequency 5.0 MHz
Location LMAX TDC WMAX WELD CL		Component Configuration/Flow TEE TO PIPE	
		Component Temp °F 62°	Thermometer S/N PTC 38180



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH .25 IN.

REMARKS:

NDE II/III Review <i>Danny Cordes</i>	Level III	Date 3-23-00	Non-Technical Review <i>J. Eric Aycock</i>	Date 3-23-00
Revision 1				

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4500-2L1** Date **3/25/00** Sheet No. **S00F1U197** Page **1** of **2**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	67°	2T	40	4.0	2.3	2T	40	4.2	2.6
Ref.	28.6	Frequency/Mode	2.25 / S	Cal. In	0840	3T	20	6.0	3.5				
Scan	38.6	"A" Dimension	0.5"	Cal. Chk.	0950	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1110	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	25%/1.2								

Comp. Temp.: 60° °F			Configuration: PIPE LONG SEAM					Wo Location WELD CL						Lo Location INT WELD 3				
Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"< --	C/L	-- >1"	
2			●	1	58%	82.5	83.0	83.5	1.25			2.5			1.32	1.62	1.32	
5	●		○	N/A														
7	●		○	N/A														
8	●		○	N/A														

Examination/Limitation Remarks: **MS-R119 (WS) LIMITS SCAN AREA**

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
109.25"	2.1"	5 (L) 91.25"	2 (L) 91.25"	7 & 8 (W) 91.25"	5 - from 1.25" to NL	2 - from 1.25" to NL	From (5) NL to (2) NL				
Primary Examiner	Level		Assistant Examiner		Level	Non-Technical Review		Date			
JOSEPH D. FUNYAK	II		N/A		N/A	J. Eric Aycock		3-29-00			
SNC NDE Level II/III Review	Date		Percentage of Code Coverage			ANIR Review		Date			
J. C. Cade	3-29-00		N/A %			19/00		3/30/00			

Figure 1

Revision 7

1

1	SET	1R16021.DAT 1R16021A.SCR							SET
1.50	DEP								DEP
2.12	MP	45 IN # 1 - ID GEOMETRY / SEE IER 1R16 012							MP
41.90	TOF								TOF
	ARC	COMPARES WITH 1988 DATA							ARC
	GATE								GATE
0.050	STEP	DR CORDES L/III <i>Doc</i>							STEP
	EXIT	MAKERAY	UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT	EXIT
PLANT: FARLEY 1		3/29/00		CIRC. POS.: 83" ALONG		LS			
SYSTEM: MAIN STEAM				ANALYST: DR CORDES		L/III			
COMPONENT: ALA2-4500-2L1		9:16		CAL. SHEET: S00E10197					

2 OF 2

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4500-2L1	Sheet Number S00F1U200	Date 3/25/00		
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOSEPH D. FUNYAK <i>Joe Funyak</i>		SNT Level II	Search Unit Manufacturer KBA	Size .50	
Examiner N/A		SNT Level N/A	Serial Number E10603	Frequency 5.0	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE LONG SEAM		
Location LMAX INT WELD 3 WMAX WELD CL			Component Temp °F 60°	Thermometer S/N PTC 38081	
<u>FLOW</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
1.32 1.32 1.32 1.32 1.32 1.40 1.48 1.52 1.62 1.50 1.43 1.38 1.32 1.31 1.32 1.32 1.32 1.32					
<u>T. MEASUREMENT EACH</u> .25 IN.					
REMARKS:					
NDE LII/III Review <i>Danny Cordis</i>		Level III	Date 3-29-00	Non-Technical Review <i>J. E. W. [Signature]</i>	Date 3-29-00
Revision 1					

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-3	Date 3/25/00	Sheet No. S00F1U198	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L003	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-4	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTR	Thickness	1.810"								
Ax. dB		Size	.50	Cal. Temp.	67°								
Ref.	29.6	Frequency/Mode	2.25 / S	Cal. In	0850								
Scan	39.6	"A" Dimension	0.5"	Cal. Chk.	1035	1T	80	3.0	1.81	1T	80	3.2	2.15
Reject	OFF	Nominal Angle	45	Cal. Out	1112	2T	20	6.0	3.62	2T	20	6.4	4.29
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	3T	12	9.0	5.40				
Mode	P/E	Cable Type	RG174	Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	25%/1.4								

Comp. Temp.: **60 °F** Configuration: **PIPE TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI						W1 Wmax W2	S1 Smax S2	1"<-- C/L -->1"	
2	●									
7	●									
8	●									

Examination/Limitation Remarks: **EXAMS PERFORMED FROM 2 SIDE WITH APR-4. REFER TO S00F1U199 FOR SCANS FROM 5 SIDE.**

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
113.5"	1.65"	5 (L) (1) 2 (L) NL	7 & 8 (W) NL	5 - from (1) to (1)	2 - from 1.3" to NL	From (5) NL to (2) NL					
Primary Examiner JOSEPH D. FUNYAK	Level II		Assistant Examiner N/A	Level N/A	Non-Technical Review <i>[Signature]</i>		Date 3-29-00				
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-29-00	Percentage of Code Coverage N/A %		ANN Review <i>[Signature]</i>		Date 3/30/00			

Figure 1

Revision 7

FARLEY NUCLEAR PLANT **Ultrasonic Calibration and Examination Record**

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4500-3** Date **3/25/00** Sheet No. **S00F1U199**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**
 Page **1** of **1**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	67°	2T	40	4.0	2.3	2T	40	4.2	2.6
Ref.	28.6	Frequency/Mode	2.25 / S	Cal. In	0840	3T	20	6.0	3.5				
Scan	38.6	"A" Dimension	0.5"	Cal. Chk.	1015	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1110	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	25%/1.2								

Comp. Temp.: **60°** °F Configuration: **PIPE TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results	Ind. No.	% DAC	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI			L1 Lmax L2	W1 Wmax W2	S1 Smax S2	1"<-- C/L -->1"	
5	●	N/A						
7	●	N/A						
8	●	N/A						

Examination/Limitation Remarks: **(1) EXAMS PERFORMED FROM 5 SIDE WITH ALA-24. REFER TO S00F1U198 FOR SCANS FROM 2 SIDE. PREVIOUS GEOMETRIC INDICATIONS OBSERVED < 50% DAC.**

Total Length of Weld	Crown Width	Total Length of Weld Examined					Extent of Perpendicular Scans (W)					Extent of Parallel Scans (L)								
113.5"	1.65"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	(1)	to	(1)	From (5)	NL	to	(2)	NL
Primary Examiner		Assistant Examiner					Level		Non-Technical Review			Level		ANII Review			Date			
JOSEPH D. FUNYAK		N/A					II		J. Eric Aycock			N/A		PGH and			3-29-00			
SNC NDE Level II/III Review		Date					Percentage of Code Coverage		ANII Review			Date		Date						
Don Corde		3-29-00					N/A		%			PGH and		3/30/00						

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4500-3		Sheet Number S00F1U201		Date 3/25/00
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484		Model Number SONIC 136	Serial Number 136-898K	
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA		Size .50
Examiner N/A		SNT Level N/A	Serial Number E10603		Frequency 5.0 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow PIPE TO TEE	
Location LMAX TDC WMAX WELD CL			Component Temp °F 60°		Thermometer S/N PTC 38081

FLOW

T. MEASUREMENTS

O.D. PROFILE

1.32	1.31	1.31	1.31	1.30	1.30	1.21	1.22	1.23	1.25	1.27	1.5	1.55	1.60	1.70	1.71	1.72	1.72

T. MEASUREMENT EACH .25 IN.

REMARKS: **N/A**

NDE LII/III Review <i>Jan Cade</i>	Level III	Date 3-29-00	Non-Technical Review <i>J. Eric Ryback</i>	Date 3-29-00

Revision 1

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4500-3L1** Date **3/28/00** Sheet No. **S00F1U202** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L003**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-4	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-898K	Serial No.	009KTR	Thickness	1.810"	1T	80	3.0	1.81	1T	80	3.2	2.15
Ax. dB		Size	.50	Cal. Temp.	66°	2T	30	6.0	3.62	2T	20	6.4	4.29
Ref.	29.6	Frequency/Mode	2.25 / S	Cal. In	1115	3T	12	9.0	5.40				
Scan	39.6	"A" Dimension	0.5"	Cal. Chk.	1125	Calibration Remarks:							
Reject	OFF	Nominal Angle	45	Cal. Out	1202								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	25%/1.4								

Comp. Temp.: **65°** °F Configuration: **TEE LONG SEAM** Wo Location **WELD CL** Lo Location **BOT OF TEE**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI				Lmax L2	W1 Wmax W2	S1 Smax S2	1" <-- C/L --> 1"	
2	●	N/A							
5	●	N/A							
7	●	N/A							
8	●	N/A							

Examination/Limitation Remarks: **30BC LIMITS EXAMINATION FOR ALL SCANS**

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
52"	2.25"	5 (L) 29"	2 (L) 29"	7 & 8 (W) 29"	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner	Level	Assistant Examiner	Level	Non-Technical Review		Date				
JOSEPH D. FUNYAK	II	N/A	N/A	<i>[Signature]</i>		3-29-00				
SNC NDE Level II/III Review	Date	Percentage of Code Coverage	Date		Date					
<i>[Signature]</i>	3-29-00	N/A %	3-29-00		3/30/00					

Figure 1

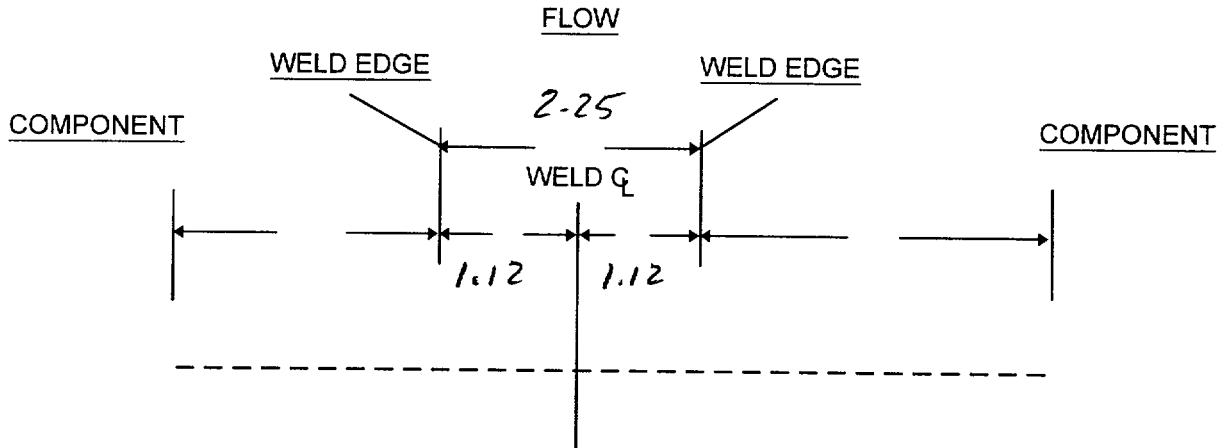
Revision 7

SHARED

Ultrasonic Weld Profile Record Southern Nuclear Operating Company

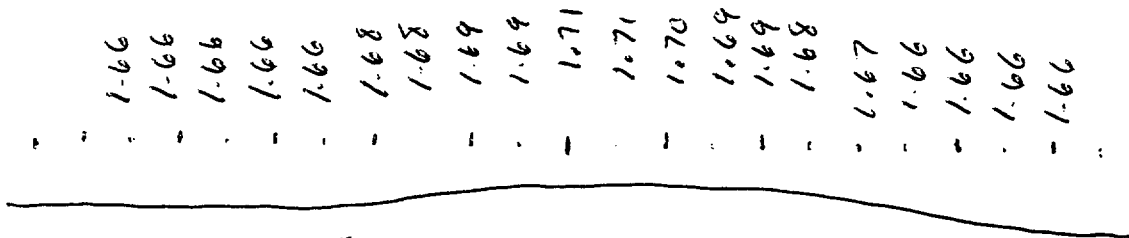
FNP-0-NDE-100.35

Unit 1	Weld Number ALA2-4500-3L1	Sheet Number S00F1U203	Date 3/28/00
ISO/Drawing Number ALA2-4500	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K
Examiner JOSEPH D. FUNYAK	SNT Level II	Search Unit Manufacturer KBA	Size .50
Examiner N/A	SNT Level N/A	Serial Number E10603	Frequency 5.0 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow TEE LONG SEAM	
Location LMAX BOTTOM OF TEE WMAX WELD CL	Component Temp °F 65°		Thermometer S/N PTC 38081



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH .25 IN.

REMARKS:

NDE LII/III Review <i>Danny Cordes</i>	Level III	Date 3-29-00	Non-Technical Review <i>Joe Edwards</i>	Date 3-29-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-9	Date 3/9/00	Sheet No. S00F1U006	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	72	2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150	3T	20	6.0	3.5				
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1247	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1515	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: 70 °F Configuration: VALVE TO PIPE

Wo Location C/L Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 5 SCAN

Total Length of Weld 101"	Crown Width 1.4"	Total Length of Weld Examined 5 (L) 0 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from N/A to N/A				Extent of Parallel Scans (L) 2 - from NL to NL From (5) .7" to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>Lynnda Duke</i>				Date 3-13-00	
SNC NDE Level II/III Review <i>Raymond L. Tull</i>			Date 3-13-00	Percentage of Code Coverage N/A %				ANII Review <i>CP</i>				Date 3/15/00	

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-9	Date 3/9/00	Sheet No. S00F1U007	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R2Y	Thickness	1.20"	1T	80	4.0	1.97				
	Ax. dB Circ. dB	Size	.50	Cal. Temp.	72	2T	35	8.0	3.84				
Ref.	45.0 N/A	Frequency/Mode	2.25 / S	Cal. In	1130	Calibration Remarks: N/A							
Scan	51.0 N/A	"A" Dimension	.6	Cal. Chk.	N/A								
Reject	OFF	Nominal Angle	60	Cal. Out	1415								
Frequency	2.25	Measured Angle	60	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	85% / 3.0								

Comp. Temp.: **70** °F Configuration: **VALVE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan	Results			Ind.	%	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
Dir.	NI	NRI	RI	No.	DAC		Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 5 SCAN

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
101"	1.4"	5 (L)	0	2 (L)	NL	7 & 8 (W)	N/A	5 - from	N/A	to	N/A	2 - from	NL	to	NL	From (5)	N/A	to	(2)	N/A
Primary Examiner		Level		Assistant Examiner		Level		Non-Technical Review		Date										
GEORGE A. MORINI		II		N/A		N/A		<i>Lynda Duke</i>		3-13-00										
SNC NDE Level II/III Review		Date		Percentage of Code Coverage		ANII Review		Date												
<i>Lynda Duke</i> L/III		3-13-00		N/A %		<i>Lynda Duke</i>		3/15/00												

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-9L1	Date 3/9/00	Sheet No. S00F1U008	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument			Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY		Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24		Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K		Serial No.	009KTR	Thickness	1.20"		1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB	Circ. dB		Size	.50	Cal. Temp.	72		2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	29.6	Frequency/Mode	2.25 / S	Cal. In	1150		3T	20	6.0	3.5				
Scan	35.4	37.6	"A" Dimension	.5	Cal. Chk.	1230		4T	15	8.0	4.6				
Reject	OFF		Nominal Angle	45	Cal. Out	1515		Calibration Remarks: N/A							
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484									
Mode	P/E		Cable Type	RG174	Reflector	HOLE									
Damping	500 OHM		Cable Length	15'	Amplitude/Sweep	20 / 1.2									

Comp. Temp.: 70 °F Configuration: **PIPE LONG SEAM** Wo Location **C/L** Lo Location **CIRC WELD 9**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld 4.75"		Crown Width 1.65"		Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL				Extent of Parallel Scans (L) 2 - from NL to NL From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI				Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynnda Duke</i>			
SNC NDE Level II/III Review <i>Ray Cordes L/III</i>				Date 3-13-00		Percentage of Code Coverage N/A %				ANII Review <i>Cy Ward</i>		Date 3-13-00			

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-10	Date 3/9/00	Sheet No. S00F1U009	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"								
Ax. dB		Circ. dB		Cal. Temp.	72								
Ref.	27.4		29.6	Frequency/Mode	2.25 / S								
Scan	35.4		37.6	"A" Dimension	.5								
Reject	OFF	Nominal Angle	45	Cal. Out	1515	1T	80	2.0	1.2	1T	80	2.1	1.3
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	2T	40	4.0	2.3	2T	35	4.2	2.6
Mode	P/E	Cable Type	RG174	Reflector	HOLE	3T	20	6.0	3.5				
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2	4T	15	8.0	4.6				
						Calibration Remarks: N/A							

Comp. Temp.: **70** °F Configuration: **PIPE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

STANCHION (WELD ATTACHMENT) LIMITS 2 SCAN

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)											
101"		1.6"		5 (L)	NL	2 (L)	93	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	0	to	1	From (5)	NL	to	(2)	NL	
Primary Examiner						Level		Assistant Examiner						Level		Non-Technical Review						Date	
GEORGE A. MORINI						II		N/A						N/A		Lynda Duke						3-13-00	
SNC NDE Level II/III Review								Date		Percentage of Code Coverage				ANII Review						Date			
Don Carter L III								3-13-00		N/A %				EGW						3/15/00			

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-10L1	Date 3/9/00	Sheet No. S00F1U010	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"								
Ax. dB		Size	.50	Cal. Temp.	72								
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150								
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1222								
Reject	OFF	Nominal Angle	45	Cal. Out	1515	1T	80	2.0	1.2	1T	80	2.1	1.3
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	2T	40	4.0	2.3	2T	35	4.2	2.6
Mode	P/E	Cable Type	RG174	Reflector	HOLE	3T	20	6.0	3.5				
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2	4T	15	8.0	4.6				
						Calibration Remarks: N/A							

Comp. Temp.: 70 °F Configuration: PIPE LONG SEAM Wo Location C/L Lo Location CIRC WELD 10

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

WELD STANCHION (WELD SUPPORT) LIMITS 2 SCAN

Total Length of Weld 23 5/8"	Crown Width 1.8"	Total Length of Weld Examined 5 (L) NL 2 (L) 13.625 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from 0 to 1.0"				Extent of Parallel Scans (L) From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A		Level N/A		Non-Technical Review <i>[Signature]</i>		Date 3-13-00			
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-13-00		Percentage of Code Coverage N/A %		ANII Review <i>[Signature]</i>		Date 3/15/00					

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-11	Date 3/9/00	Sheet No. S00F1U011	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	72	2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150	3T	20	6.0	3.5				
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1222	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1515 <i>6th 5-5-00</i>	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	797484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: **70** °F Configuration: **PIPE TO ELBOW** Wo Location C/L Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld 101"	Crown Width 1.5"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from NL to NL				Extent of Parallel Scans (L) 2 - from NL to NL				From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI <i>[Signature]</i>		Level II		Assistant Examiner N/A		Level N/A		Non-Technical Review <i>[Signature]</i>		Date 3-13-00		ANII Review <i>[Signature]</i>		Date 3/15/00			
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-13-00		Percentage of Code Coverage N/A %											

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-11L1	Date 3/9/00	Sheet No. S00F1U012	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"								
Ax. dB		Size	.50	Cal. Temp.	72								
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150								
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1405								
Reject	OFF	Nominal Angle	45	Cal. Out	1515	1T	80	2.0	1.2	1T	80	2.1	1.3
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	2T	40	4.0	2.3	2T	35	4.2	2.6
Mode	P/E	Cable Type	RG174	Reflector	HOLE	3T	20	6.0	3.5				
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2	4T	15	8.0	4.6				
						Calibration Remarks: N/A							

Comp. Temp.: **70** °F Configuration: **ELBOW LONG SEAM** Wo Location **C/L** Lo Location **CIRC WELD 11**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld 97"	Crown Width 2"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)						Extent of Parallel Scans (L)									
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-13-00						
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-13-00		Percentage of Code Coverage N/A %				ANII Review <i>[Signature]</i>				Date 3/15/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page of
1	ALA2-4500-11L2	3/9/00	S00F1U013	
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONATRACE 40 / 94243	38081 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	72	2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1150	3T	20	6.0	3.5				
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1215	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1515	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: 70 °F Configuration: PIPE LONG SEAM Wo Location C/L Lo Location CIRC WELD 11

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)								
49"	2"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review				Date				
GEORGE A. MORINI				II		N/A				N/A		Lynnda Duke				3-13-00				
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review		Date								
[Signature]				3-13-00		N/A %				[Signature]		3/15/00								

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-12	Date 3/20/00	Sheet No. S00F1U089	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1UL005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.0	2.3	2T	40	4.2	2.6
Ref.	28.2	Frequency/Mode	2.25 / S	Cal. In	1000	3T	20	6.0	3.5				
Scan	38.2	"A" Dimension	.50	Cal. Chk.	1445	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1555	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **67** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **OR EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

Total Length of Weld 100.5"		Crown Width 1.95"	Total Length of Weld Examined 5 (L) <u>NL</u> 2 (L) <u>NL</u> 7 & 8 (W) <u>NL</u>			Extent of Perpendicular Scans (W) 5 - from <u>NL</u> to <u>NL</u>			Extent of Parallel Scans (L) 2 - from <u>NL</u> to <u>NL</u> From (5) <u>NL</u> to (2) <u>NL</u>		
Primary Examiner JOSEPH D. FUNYAK <i>J.D. Funyak</i>		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>J. E. ...</i>			Date 3-21-00	
SNC NDE Level II/III Review <i>Sanj ...</i>			Date 3-21-00	Percentage of Code Coverage N/A %			Date 3/23/00				

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4500-12	Sheet Number S00F1U091	Date 3/20/00		
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RW	Frequency 5	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow ELBOW TO PIPE		
Location LMAX	OR EL	WMAX	WELD CL	Component Temp °F 67°	Thermometer S/N PTC 38180

FLOW →

T. MEASUREMENTS

O.D. PROFILE

1.19"	1.19"	1.18"	1.16"	1.15"	1.12"	1.13"	1.14"	1.15"	1.15"	1.14"	1.13"	1.12"	1.12"	1.13"	1.13"	1.14"	1.14"	1.14"	1.14"

T. MEASUREMENT EACH **.25** IN.

REMARKS:

NDE LII/III Review <i>Dany Corda</i>	Level III	Date 3-21-00	Non-Technical Review <i>J. Edward Aycock</i>	Date 3-21-00

Revision 1

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page
1	ALA2-4500-12L1	3/21/00	S00F1U108	1 of 1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38180 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																					
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>1.20</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.0</td> <td>2.30</td> </tr> <tr> <td>3T</td> <td>20</td> <td>6.0</td> <td>3.50</td> </tr> <tr> <td>4T</td> <td>15</td> <td>8.0</td> <td>4.60</td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	1.20	2T	40	4.0	2.30	3T	20	6.0	3.50	4T	15	8.0	4.60	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.1</td> <td>1.30</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.2</td> <td>2.60</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.1	1.30	2T	40	4.2	2.60								
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax																																												
1T	80	2.0	1.20																																												
2T	40	4.0	2.30																																												
3T	20	6.0	3.50																																												
4T	15	8.0	4.60																																												
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax																																												
1T	80	2.1	1.30																																												
2T	40	4.2	2.60																																												
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"																																										
Ax. dB		Circ. dB		Cal. Temp.	68°																																										
Ref.	28.2	30.8	Size	.50	Cal. In	0810																																									
Scan	38.2	40.8	Frequency/Mode	2.25 / 5	Cal. Chk.	0930																																									
Reject	OFF		"A" Dimension	.5"	Cal. Out	1215																																									
Frequency	2.25		Nominal Angle	45	Ref. Blk. No.	796484																																									
Mode	P/E		Measured Angle	45	Reflector	HOLE																																									
Damping	500 OHMS		Cable Type	RG174	Amplitude/Sweep	20%/1.2																																									
			Cable Length	15'																																											

Calibration Remarks:
NONE

Comp. Temp.: 62 °F Configuration: PIPE LONG SEAM

Wo Location WELD CL

Lo Location OR ELBOW

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: RESTRAINT MSR-116 LIMITS COVERAGE

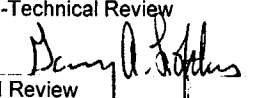
Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)				
43.50	1.9"	5 (L) 14.5"	2 (L) 14.5"	7 & 8 (W) 14.5"	5 - from	NL	to	NL	2 - from	NL	to	NL
Primary Examiner		Level	Assistant Examiner		Level	Non-Technical Review		Date				
JOSEPH D. FUNYAK		II	N/A		N/A			3-22-00				
SNC NDE Level II/III Review		Date	Percentage of Code Coverage		ANII Review		Date					
		3-23-00	N/A %				3/25/00					

Figure 1

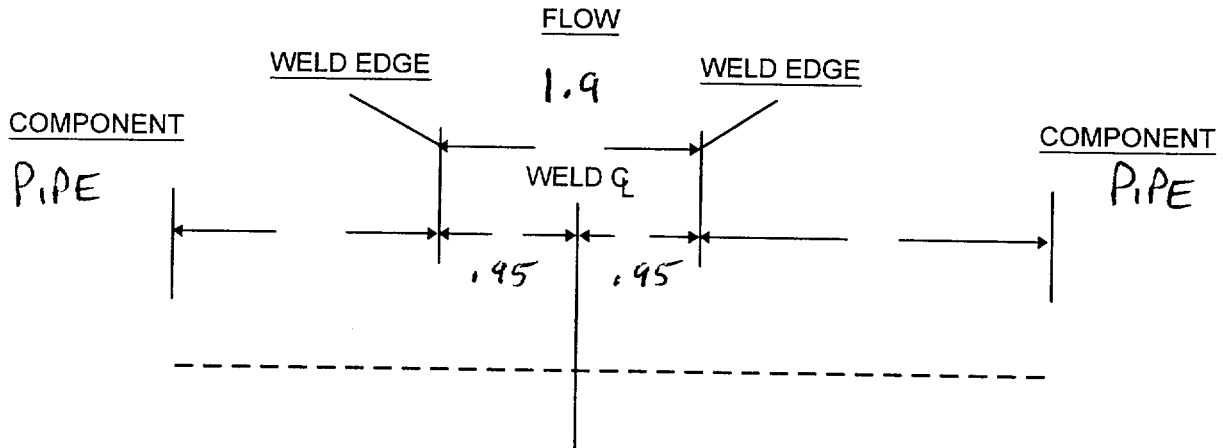
Revision 7

SHARED

Ultrasonic Weld Profile Record Southern Nuclear Operating Company

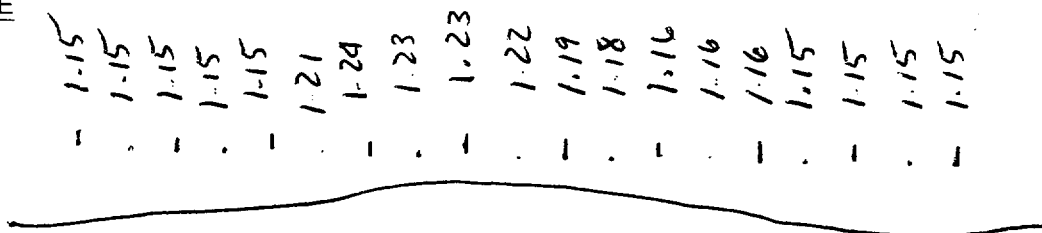
FNP-0-NDE-100.35

Unit 1	Weld Number ALA2-4500-12L1	Sheet Number S00F1U119	Date 3/21/00
ISO/Drawing Number ALA2-4500	Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>	SNT Level II	Search Unit Manufacturer KBA	Size .50
Examiner N/A	SNT Level N/A	Serial Number E10603	Frequency 5.0 MHz
Weld Examination Record No. N/A		Indication No. N/A	
Component Configuration/Flow PIPE LONG SEAM			
Location LMAX CIRC WELD 12 WMAX WELD CL		Component Temp °F 62°	Thermometer S/N PTC 38180



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH .25 IN.

REMARKS:

NDE LII/III Review <i>Danny Cordes</i>	Level III	Date 3-23-00	Non-Technical Review <i>Danny A. Duffles</i>	Date 3-22-00

Revision 1

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-13	Date 3/21/00	Sheet No. S00F1U109	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.20	1T	80	2.1	1.30
Ax. dB		Size	.50	Cal. Temp.	68°	2T	40	4.0	2.30	2T	40	4.2	2.60
Ref.	28.2	Frequency/Mode	2.25 / S	Cal. In	0810	3T	20	6.0	3.50				
Scan	38.2	"A" Dimension	.5"	Cal. Chk.	0945	4T	15	8.0	4.60				
Reject	OFF	Nominal Angle	45	Cal. Out	1215	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	20%/1.2								

Comp. Temp.: **62** °F Configuration: **PIPE TO TEE** Wo Location **WELD CL** Lo Location **IR EL**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI						W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **NONE**

Total Length of Weld		Crown Width		Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
101.50"		2.3"		5 (L) NL		2 (L) NL		7 & 8 (W) NL		5 - from NL to NL		2 - from NL to NL		From (5) NL to (2) NL	
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review		Date	
JOSEPH D. FUNYAK				II		N/A				N/A		[Signature]		3-22-00	
SNC NDE Level II/III Review				Date		Percentage of Code Coverage				ANII Review		Date			
[Signature]				3-23-00		N/A %				[Signature]		3/25/00			

Figure 1

Revision 7

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Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4500-13	Sheet Number S00F1U120	Date 3/21/00		
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA	Size .50	
Examiner N/A		SNT Level N/A	Serial Number E10603	Frequency 5.0	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO TEE		
Location LMAX IR EL WMAX WELD CL			Component Temp °F 62°	Thermometer S/N PTC 38180	
<u>FLOW</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<i>1.58</i> <i>1.55</i> <i>1.53</i> <i>1.5</i> <i>1.47</i> <i>1.45</i> <i>1.42</i> <i>1.40</i> <i>1.31</i> <i>1.32</i> <i>1.33</i> <i>1.34</i> <i>1.32</i> <i>1.32</i> <i>1.31</i> <i>1.25</i> <i>1.19</i> <i>1.14</i> <i>1.12</i> <i>1.13</i> <i>1.15</i> <i>1.15</i> <i>1.16</i> <i>1.16</i>					
<u>T. MEASUREMENT EACH</u> .25 IN.					
REMARKS:					
NDE LII/III Review <i>Darryl Cardo</i>		Level III	Date 3-23-00	Non-Technical Review <i>Darryl P. Lottus</i>	Date 3-22-00
					Revision 1

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-24BC	Date 3/20/00	Sheet No. S00F1U090	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38180 / 8/27/2000	Linearity Sheet No. S00F1UL005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																								
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>1.2</td> <td>1T</td> <td>80</td> <td>2.1</td> <td>1.3</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.0</td> <td>2.3</td> <td>2T</td> <td>40</td> <td>4.2</td> <td>2.6</td> </tr> <tr> <td>3T</td> <td>20</td> <td>6.0</td> <td>3.5</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>15</td> <td>8.0</td> <td>4.6</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	1.2	1T	80	2.1	1.3	2T	40	4.0	2.3	2T	40	4.2	2.6	3T	20	6.0	3.5					4T	15	8.0	4.6					Calibration Remarks: NONE			
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																										
1T	80	2.0	1.2	1T	80		2.1	1.3																																										
2T	40	4.0	2.3	2T	40		4.2	2.6																																										
3T	20	6.0	3.5																																															
4T	15	8.0	4.6																																															
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"																																													
Ax. dB		Circ. dB		Size	.50																																													
Ref.	28.2	30.8	Frequency/Mode	2.25 / S	Cal. Temp.	68°																																												
Scan	38.2	40.8	"A" Dimension	.50	Cal. In	1000																																												
Reject	OFF		Nominal Angle	45	Cal. Chk.	1415	Cal. Out	1555																																										
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484																																												
Mode	P/E		Cable Type	RG174	Reflector	HOLE																																												
Damping	500 OHMS		Cable Length	15'	Amplitude/Sweep	20%/1.2																																												

Comp. Temp.: **67** °F Configuration: **BRANCH CONNECTION TO PIPE** Wo Location **WELD CL** Lo Location **US APEX**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)	Extent of Parallel Scans (L)
56"	2.9"	5 (L) NL 2 (L) NL 7 & 8 (W) NL	5 - from NL to NL 2 - from NL to NL	From (5) NL to (2) NL
Primary Examiner JOSEPH D. FUNYAK	Level II	Assistant Examiner N/A	Level N/A	Non-Technical Review <i>J. Eric Aycock</i>
SNC NDE Level II/III Review <i>Samy Conda L. Hu</i>	Date 3-21-00	Percentage of Code Coverage N/A %	ANII Review <i>19 Wund</i>	Date 3-21-00 Date 3/23/00

Figure 1

Revision 7

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Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4500-24BC	Sheet Number S00F1U092	Date 3/20/00		
ISO/Drawing Number ALA2-4500		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type CS	Calibration Standard/Serial Number RHOMBUS / 796484	Model Number SONIC 136	Serial Number 136-911K		
Examiner JOSEPH D. FUNYAK <i>JD Funyak</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RW	Frequency 5	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow BRANCH CONNECTION TO PIPE		
Location LMAX US APEX WMAX WELD CL		Component Temp °F 67	Thermometer S/N PTC 38180		
T. MEASUREMENTS					
O.D. PROFILE: 1.15" 1.15" 1.17" 1.2" 1.2" 1.25" 1.3" 1.3" 1.35" 1.4" 1.4" 1.45" 1.45" 1.5" 1.5" 1.55" 1.60" 1.61" 1.65" 1.70" 1.75" 1.80"					
T. MEASUREMENT EACH .25 IN.					
REMARKS:					
NDE LII/III Review <i>Dan Cards</i>		Level III	Date 3-21-00	Non-Technical Review <i>J. Eric Dyck</i>	Date 3-21-00
Revision 1					

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4500-25** Date **3/9/00** Sheet No. **S00F1U014** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONATRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L005**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R22	Thickness	.500"								
Ax. dB		Circ. dB		Cal. Temp.	72								
Ref.	35.2		39.4	Frequency/Mode	2.25 / S								
Scan	43.2		47.4	"A" Dimension	.3								
Reject	OFF	Nominal Angle	45	Cal. Chk.	1418	1T	80	2.0	.53	1T	80	2.2	.63
Frequency	2.25	Measured Angle	45	Cal. In	1145	2T	40	4.0	1.10	2T	45	2.4	1.29
Mode	P/E	Cable Type	RG174	Cal. Out	1520	3T	25	6.0	1.59				
Damping	500 OHM	Cable Length	15'	Ref. Blk. No.	796484	4T	18	8.0	2.12				
				Reflector	HOLE	Calibration Remarks: N/A							
				Amplitude/Sweep	20% / 2.9								

Comp. Temp.: **70** °F Configuration: **PIPE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI						W1	Wmax	W2	S1	Smax	S2	1" < -	C/L	- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
27.5"	.7"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL to NL	2 - from	NL to NL	From (5)	NL to (2) NL
Primary Examiner	Level II Assistant Examiner					Level	Non-Technical Review						
GEORGE A. MORINI	N/A					N/A	Lynda Duke						
SNC NDE Level II/III Review	Date					Percentage of Code Coverage		ANII Review		Date			
Dan Cordis	3-13-00					N/A %		CF Ward		3-15-00			

Figure 1

Revision 7

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FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-26	Date 3/9/00	Sheet No. S00F1U015	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R22	Thickness	.500"	1T	80	2.0	.53	1T	80	2.2	.63
Ax. dB		Size	.25	Cal. Temp.	72	2T	40	4.0	1.10	2T	45	2.4	1.29
Ref.	35.2	Frequency/Mode	2.25 / S	Cal. In	1145	3T	25	6.0	1.59				
Scan	43.2	"A" Dimension	.3	Cal. Chk.	1424	4T	18	8.0	2.12				
Reject	OFF	Nominal Angle	45	Cal. Out	1520	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 2.9								

Comp. Temp.: **70** °F Configuration: **PIPE TO TEE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
27.5"	.7"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner				Level		Assistant Examiner				Level		Non-Technical Review				Date				
GEORGE A. MORINI				II		N/A				N/A		Lynda Duke				3-13-00				
SNC NDE Level II/III Review						Date		Percentage of Code Coverage				ANII Review				Date				
Jay Corda LIII						3-13-00		N/A %				cgward				3/15/00				

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-27	Date 3/9/00	Sheet No. S00F1U016	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R22	Thickness	.500"								
Ax. dB		Size	.25	Cal. Temp.	72								
Ref.	35.2	Frequency/Mode	2.25 / S	Cal. In	1145								
Scan	43.2	"A" Dimension	.3	Cal. Chk.	1436								
Reject	OFF	Nominal Angle	45	Cal. Out	1520								
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: N/A							
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 2.9								

Comp. Temp.: **70** °F Configuration: **TEE TO CAP** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- >1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
27.5"	.7"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner		Level				Assistant Examiner				Level				Non-Technical Review				Date		
GEORGE A. MORINI		II				N/A				N/A				Lynda Duke				3-13-00		
SNC NDE Level II/III Review						Date		Percentage of Code Coverage						ANII Review		Date				
Dan Corda L/III						3-13-00		N/A %						egward		3/15/00				

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-28	Date 3/9/00	Sheet No. S00F1U017	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	009R22	Thickness	.500"									
Ax. dB		Circ. dB		Cal. Temp.	72									
Ref.	35.2	39.4	Size	.25	Cal. In									1145
Scan	43.2	47.4	Frequency/Mode	2.25 / S	Cal. Chk.									1445
Reject	OFF		Nominal Angle	45	Cal. Out	1520								
Frequency	2.25		Measured Angle	45	Ref. Blk. No.	796484	Calibration Remarks: N/A							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM		Cable Length	15'	Amplitude/Sweep	20% / 2.9								

Comp. Temp.: **70** °F Configuration: **TEE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
7	●			N/A														
8	●			N/A														
5			●	1	40%	27.1"	27.5"	0.31"	.468"			1.7		.58"	.4"	.42"	(1)	

Examination/Limitation Remarks:

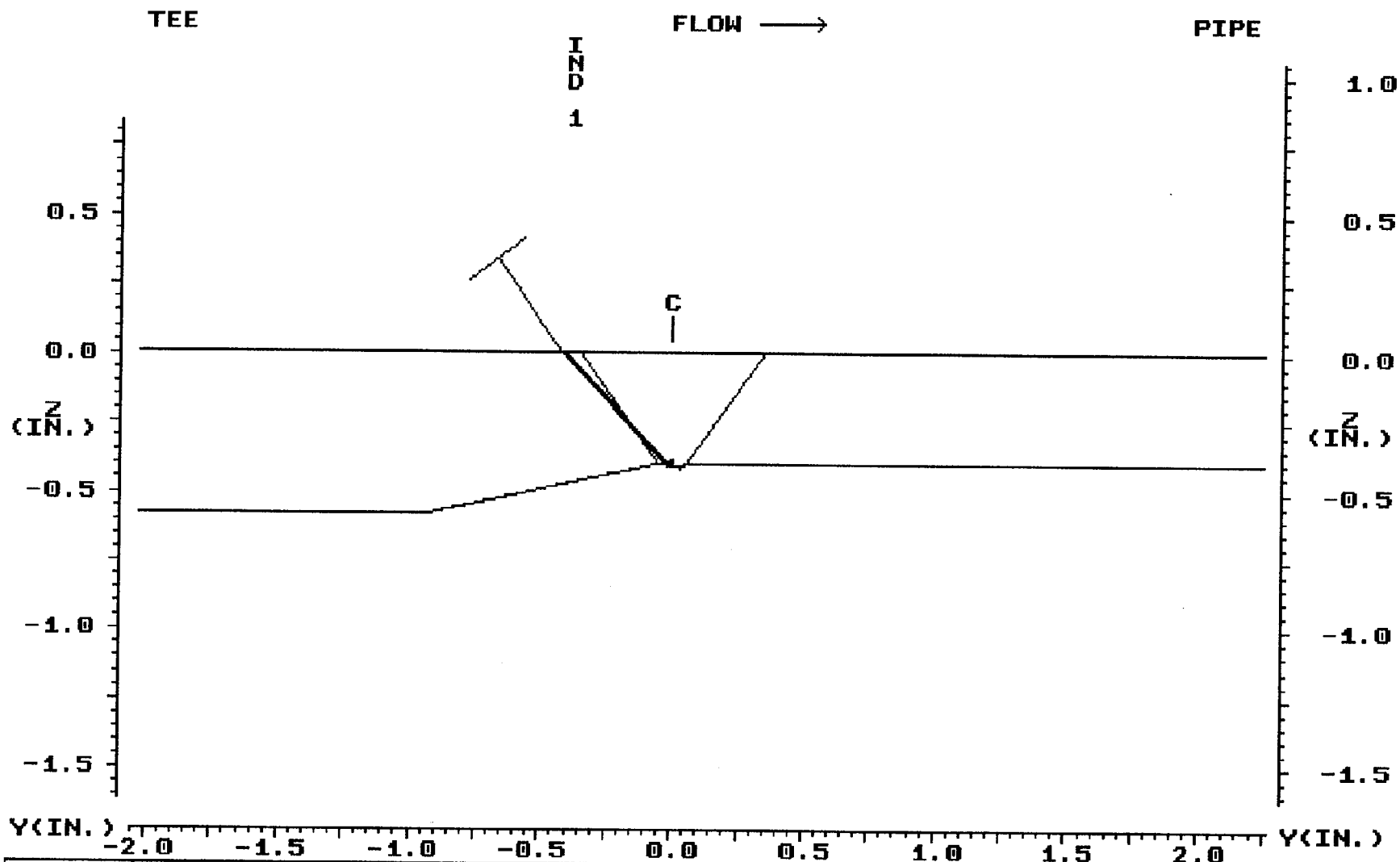
(1) INDICATION UNCHANGED FROM PREVIOUS DATA DATED 4/4/88

IER IR16001

Total Length of Weld	Crown Width	Total Length of Weld Examined	Extent of Perpendicular Scans (W)	Extent of Parallel Scans (L)
27.5"	.7"	5 (L) NL 2 (L) NL 7 & 8 (W) NL 5 - from NL to NL 2 - from NL to NL	From (5) NL to (2) NL	
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A	Level N/A
SNC NDE Level II/III Review <i>Way Corda</i>		Date 3-13-00	Percentage of Code Coverage N/A %	Non-Technical Review <i>Lynada Duke</i> Date 3-13-00
				ANII Review <i>Way Corda</i> Date 3/21/00

Figure 1

Revision 7



IND 1	SET	1R16001.DAT	1R16001A.SCR		SET
0.42	DEP	INDICATION 1 - ID GEOMETRY / ROOT COMPARES WITH PREVIOUS 1988 DATA DR CORDES L/III <i>Inc</i>			DEP
0.59	MP				MP
17.50	TOF				TOF
	ARC				ARC
	GATE				GATE
0.100	STEP	LEFT	RIGHT	TOP	STEP
	EXIT	UTILITY	PRINT	EXIT	EXIT
PLANT: FARLEY 1 3/13/00 CIRC. POS.: 27.5" SYSTEM: MAIN STEAM ANALYST: D.R. CORDES L/III COMPONENT: ALA2-4500-28 11:20 CAL. SHEET: SOOF 1U017					

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-29	Date 3/9/00	Sheet No. S00F1U018	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-26	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R22	Thickness	.500"	1T	80	2.0	.53	1T	80	2.2	.63
Ax. dB	35.2	Circ. dB	39.4	Cal. Temp.	72	2T	40	4.0	1.10	2T	45	2.4	1.29
Ref.	35.2	Size	.25	Cal. In	1145	3T	25	6.0	1.59				
Scan	43.2	Frequency/Mode	2.25 / S	Cal. Chk.	N/A	4T	18	8.0	2.12				
Reject	OFF	"A" Dimension	.3	Cal. Out	1520	Calibration Remarks: N/A							
Frequency	2.25	Nominal Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Measured Angle	45	Reflector	HOLE								
Damping	500 OHM	Cable Type	RG174	Amplitude/Sweep	20% / 2.9								

Comp. Temp.: 70 °F Configuration: PIPE TO CAP Wo Location C/L Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < -	C/L	- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
27.5"	.7"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL	to NL	2 - from NL	to NL	From (5) NL	to (2) NL			
Primary Examiner		Level	Assistant Examiner				Level	Non-Technical Review		Date			
GEORGE A. MORINI		II	N/A				N/A	hymda duke		3-13-00			
SNC NDE Level II/III Review		Date	Percentage of Code Coverage				ANII Review		Date				
Way Card L III		3-13-00	N/A %				cgw		3/15/00				

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4500-44	Date 3/9/00	Sheet No. S00F1U019	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONATRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"	1T	80	2.0	1.2	1T	80	2.1	1.3
Ax. dB		Size	.50	Cal. Temp.	72	2T	40	4.0	2.3	2T	35	4.2	2.6
Ref.	27.4	Frequency/Mode	2.25 / S	Cal. In	1145	3T	20	6.0	3.5				
Scan	35.4	"A" Dimension	.5	Cal. Chk.	1306	4T	15	8.0	4.6				
Reject	OFF	Nominal Angle	45	Cal. Out	1515	Calibration Remarks: N/A							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	796484								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHM	Cable Length	15'	Amplitude/Sweep	20% / 1.2								

Comp. Temp.: **70** °F Configuration: **PIPE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- >1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
101"	1.6"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>Lynnda Duke</i>				Date 3-13-00						
SNO NDE Level II/III Review <i>James Cordes</i>				Date 3-13-00		Percentage of Code Coverage N/A %				ANII Review <i>cg...</i>				Date 3/15/00						

Figure 1

Revision 7

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page
1	ALA2-4500-44L1	3/9/00	S00F1U020	1 of 1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNF-0-NDE-100.31 / 7 / N/A	SONATRACE 40 / 94243	38081 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																								
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-24	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>1.2</td> <td>1T</td> <td>80</td> <td>2.1</td> <td>1.3</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.0</td> <td>2.3</td> <td>2T</td> <td>35</td> <td>4.2</td> <td>2.6</td> </tr> <tr> <td>3T</td> <td>20</td> <td>6.0</td> <td>3.5</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>15</td> <td>8.0</td> <td>4.6</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	1.2	1T	80	2.1	1.3	2T	40	4.0	2.3	2T	35	4.2	2.6	3T	20	6.0	3.5					4T	15	8.0	4.6								
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																										
1T	80	2.0	1.2	1T	80		2.1	1.3																																										
2T	40	4.0	2.3	2T	35		4.2	2.6																																										
3T	20	6.0	3.5																																															
4T	15	8.0	4.6																																															
Serial No.	136-911K	Serial No.	009KTR	Thickness	1.20"																																													
Ax. dB		Circ. dB		Cal. Temp.	72																																													
Ref.	27.4	29.6	Size	.50	Cal. In	1150																																												
Scan	35.4	37.6	Frequency/Mode	2.25 / S	Cal. Chk.	1226	Calibration Remarks: N/A																																											
Reject	OFF		"A" Dimension	.5	Cal. Out	1515																																												
Frequency	2.25		Nominal Angle	45	Ref. Blk. No.	796484																																												
Mode	P/E		Measured Angle	45	Reflector	HOLE																																												
Damping	500 OHM		Cable Type	RG174	Amplitude/Sweep	20% / 1.2																																												
			Cable Length	15'																																														

Comp. Temp.: 70 °F Configuration: PIPE LONG SEAM Wo Location C/L Lo Location CIRC WELD 44

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- >1"	
2	●			N/A														
5	●			N/A														
5	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

NONE

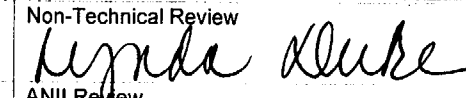
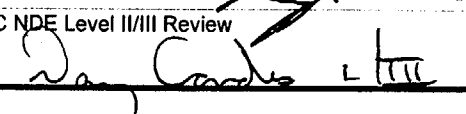
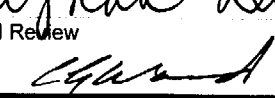
Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
4"	1.9"	5 (L) NL	2 (L) NL	7 & 8 (W) NL		5 - from NL	to NL	2 - from NL	to NL	From (5) NL	to (2) NL		
Primary Examiner	Level				Assistant Examiner	Level				Non-Technical Review		Date	
GEORGE A. MORINI	II				N/A	N/A						3-13-00	
SNC NDE Level II/III Review					Date	Percentage of Code Coverage				ANII Review		Date	
					3-13-00	N/A %						3/15/00	

Figure 1

Revision 7

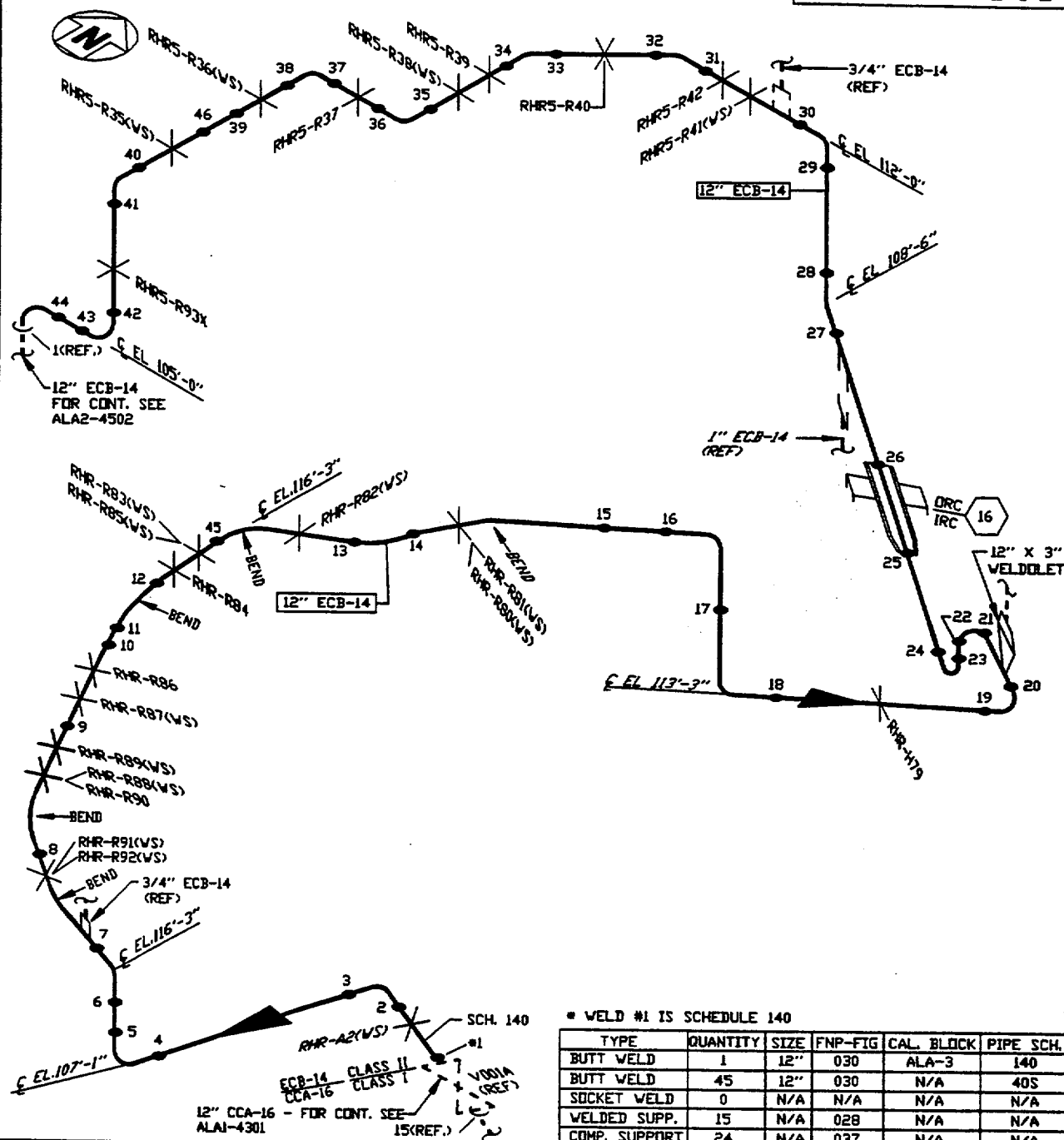
DRAWING ALA2-4501
RHR TRAIN A

[illegible]

CONTAINMENT & AUX. BUILDING

RHR TRAIN A

ALA2-4501



WELD #1 IS SCHEDULE 140

TYPE	QUANTITY	SIZE	FN-FIG	CAL. BLOCK	PIPE SCH.
BUTT WELD	1	12"	030	ALA-3	140
BUTT WELD	45	12"	030	N/A	40S
SOCKET WELD	0	N/A	N/A	N/A	N/A
WELDED SUPP.	15	N/A	028	N/A	N/A
COMP. SUPPORT	24	N/A	037	N/A	N/A

LINE NUMBER: Q-1-E11-ECB-14

BOUNDARY DIAGRAM D-351118 SH. 1

REFERENCE ISO'S D-514040 SH. 1

D-514041 SH. 1

LINE SIZE: 12" ECB-14

2	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0.	LDT	DLG	REV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCM	WRH	AH	DHL
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for

E11-RESIDUAL HEAT REMOVAL

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

99

2

CAD ALA24501
AUTOCAD RAV-03

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.
1	ALA2-4501-28	3/17/00	S00F1U057
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38081 / 8/27/2000	S00F1L005

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																								
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-12	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2</td> <td>.3</td> <td>1T</td> <td>80</td> <td>2.2</td> <td>.3</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4</td> <td>.6</td> <td>2T</td> <td>50</td> <td>4.4</td> <td>.72</td> </tr> <tr> <td>3T</td> <td>30</td> <td>6</td> <td>.9</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>10</td> <td>8</td> <td>1.2</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2	.3	1T	80	2.2	.3	2T	40	4	.6	2T	50	4.4	.72	3T	30	6	.9					4T	10	8	1.2					Calibration Remarks: NONE			
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																										
1T	80	2	.3	1T	80		2.2	.3																																										
2T	40	4	.6	2T	50		4.4	.72																																										
3T	30	6	.9																																															
4T	10	8	1.2																																															
Serial No.	136-911K	Serial No.	009R2K	Thickness	.375"																																													
Ax. dB	39.4	Circ. dB	49	Cal. Temp.	72																																													
Ref.	5	Frequency/Mode	5 / S	Cal. In	0815																																													
Scan	51.4	"A" Dimension	.2	Cal. Chk.	1050																																													
Reject	OFF	Nominal Angle	45	Cal. Out	1230																																													
Frequency	5	Measured Angle	45	Ref. Blk. No.	4976																																													
Mode	P/E	Cable Type	RG174	Reflector	HOLE																																													
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	40% / 4																																													

Comp. Temp.: 78 °F Configuration: ELBOW TO PIPE

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

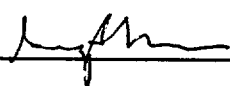
LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
40.5"	.7"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner		Level		Assistant Examiner		Level		Non-Technical Review		Date		ANII Review		Date						
GEORGE A. MORINI		II		N/A		N/A		J. Eric Aycock		3-20-00		3/23/00								
SNC NDE Level II/III Review		Date		Percentage of Code Coverage		i 100 %														
[Signature]		3-20-00																		

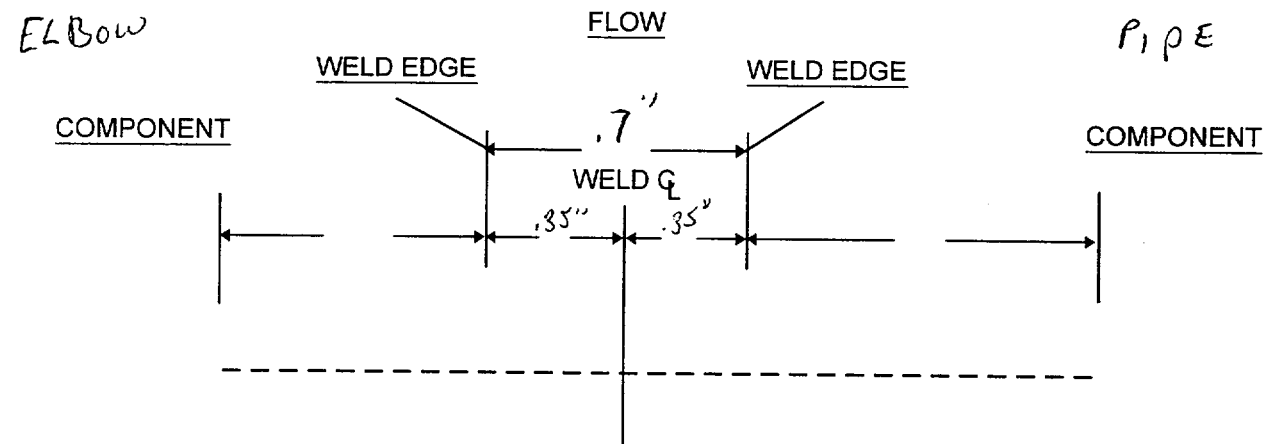
Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4501-28	Sheet Number S00F1U058	Date 3/17/00		
ISO/Drawing Number ALA2-4501		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136-911K		
Examiner GEORGE A. MORINI 		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow ELBOW TO PIPE		
Location LMAX EXTRADOSE WMAX WELD C/L	Component Temp °F 74		Thermometer S/N PTC 38081		

ELBOW FLOW PIPE



T. MEASUREMENTS

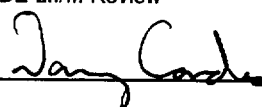
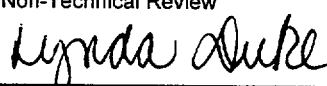
O.D. PROFILE

.45 .45 .45 ~~.38~~ .38 .38 .38

.38 IN 3-18-00

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review 	Level III	Date 3-20-00	Non-Technical Review 	Date 3-18-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4501-28	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P021	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 77 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO PIPE		% of Length Coverage 100	Date 3/18/00	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>ewk</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>[Signature]</i>	Non-Technical Review <i>[Signature]</i>	Date 3-20-00
SNC NDE Level II/III Review <i>Dan Corda L/III</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/23/00	

Figure 1

Revision 6

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4501-35** Date **3/17/00** Sheet No. **S00F1U059** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L005**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-12	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	009R2K	Thickness	.375"									
Ax. dB		Circ. dB		Cal. Temp.	72									
Ref.	39.4	49	Size	.25	Cal. In									0815
Scan	51.4	61	Frequency/Mode	5 / S	Cal. Chk.									1000
Reject	OFF		Nominal Angle	45	Cal. Out	1230								
Frequency	5		Measured Angle	45	Ref. Blk. No.	4976	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	45'	Amplitude/Sweep	40% / 4								

Comp. Temp.: **78** °F Configuration: **PIPE TO ELBOW** Wo Location **C/L** Lo Location **V STAMP**

Scan Dir.	Results	Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement W1	Wmax	W2	Sweep Position S1	Smax	S2	Thickness 1" <-- C/L --> 1"	Notes:
2	●			N/A										
5	●			N/A										
7	●			N/A										
8	●			N/A										

Examination/Limitation Remarks:

LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)			Extent of Parallel Scans (L)		
40.5"	.95"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI	Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>		Date 3-20-00		
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-20-00	Percentage of Code Coverage 100 %		ANI Review <i>[Signature]</i>		Date 3/23/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4501-35	Sheet Number S00F1U060	Date 3/17/00		
ISO/Drawing Number ALA2-4501		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136-911K		
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW		
Location LMAX	TDC	WMAX	WELD C/L	Component Temp °F 78	Thermometer S/N PTC 38081

ELBOW FLOW *PIPE*

T. MEASUREMENTS

O.D. PROFILE

4" .4" .4" .4" .35" .35" .35"

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>[Signature]</i>	Level III	Date 3-20-00	Non-Technical Review <i>[Signature]</i>	Date 3-18-00

Revision 1

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4501-35	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P008	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO ELBOW		% of Length Coverage 100	% of Area Coverage 100	Date 3/17/00
Ind. No. NA	Results NI	Indication Desc. / Exam Limitations / etc. NA		Remarks NONE

Remarks: **NA**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>D. Eric Claycock</i>	Non-Technical Review <i>D. Eric Claycock</i>	Date 3-20-00
SNC NDE Level II/III Review <i>Danny Cordis LIII</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>CK</i>		Date 3/23/00	

Figure 1

Revision 6

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4501-41** Date **3/17/00** Sheet No. **S00F1U061** Page **1 of 1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L005**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-12	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R2K	Thickness	.375"								
Ax. dB	39.4	Circ. dB	49	Cal. Temp.	72								
Ref.	39.4	Size	.25	Cal. In	0815								
Scan	51.4	Frequency/Mode	5 / s	Cal. Chk.	N/A								
Reject	OFF	"A" Dimension	.2	Cal. Out	1230	1T	80	2	.3	1T	80	2.2	.3
Frequency	5	Nominal Angle	45	Ref. Blk. No.	4976	2T	40	4	.6	2T	50	4.4	.72
Mode	P/E	Measured Angle	45	Reflector	HOLE	3T	30	6	.9				
Damping	500 OHMS	Cable Type	RG174	Amplitude/Sweep	40% / 4	4T	10	8	1.2				
Calibration Remarks:						NONE							

Comp. Temp.: **78** °F Configuration: **ELBOW TO PIPE** Wo Location **C/L** Lo Location **V STAMP**

Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax L2	Reference Measurement W1 Wmax W2	Sweep Position S1 Smax S2	Thickness 1" < - C/L - > 1"	Notes:
2	●			N/A					
5	●			N/A					
7	●			N/A					
8	●			N/A					

Examination/Limitation Remarks:

LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
40.5"	.6"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL						
Primary Examiner GEORGE A. MORINI	Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>J. E. Olycock</i>				Date 3-20-00		
SNC NDE Level II/III Review <i>Dan Corda</i>	Date 3-20-00	Percentage of Code Coverage 100 %				AMII Review <i>E. G. Ward</i>				Date 3/23/00			

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4501-41		Sheet Number S00F1U062		Date 3/17/00
ISO/Drawing Number ALA2-4501		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136		Serial Number 136-911K
Examiner GEORGE A. MORINI		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow ELBOW TO PIPE	
Location LMAX EXTRADOSE WMAX C/L		Component Temp °F 78		Thermometer S/N PTC 38081	
<i>PIPE</i> <u>FLOW</u> <i>ELBOW</i> COMPONENT WELD EDGE .6" WELD Q .3" WELD EDGE COMPONENT <i>.38 .38 .48 .4 .4 .4</i>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<i>.38 .38 .48 .4 .4 .4</i>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Don Cordero</i>		Level Date <i>III 3-20-00</i>		Non-Technical Review <i>Lynda Duke</i>	
				Date <i>3-18-00</i>	

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4501-41	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P009
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration ELBOW TO PIPE		% of Length Coverage 100 % of Area Coverage 100	Date 3/17/00
Ind. No. NA	Results NI	Indication Desc. / Exam Limitations / etc. NA	Remarks NONE

Remarks: **NA**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>ck</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>Erie Oyeck</i>	Non-Technical Review <i>Erie Oyeck</i>	Date 3-20-00
SNC NDE Level II/III Review <i>Jan Cordes</i>		Date 3-20-00		Percentage of Code Coverage 100 %		ANII Review <i>lg Ward</i>	
						Date 3/23/00	

Figure 1

Revision 6

EXAMINATION SUMMARY

FOR UNIT 1

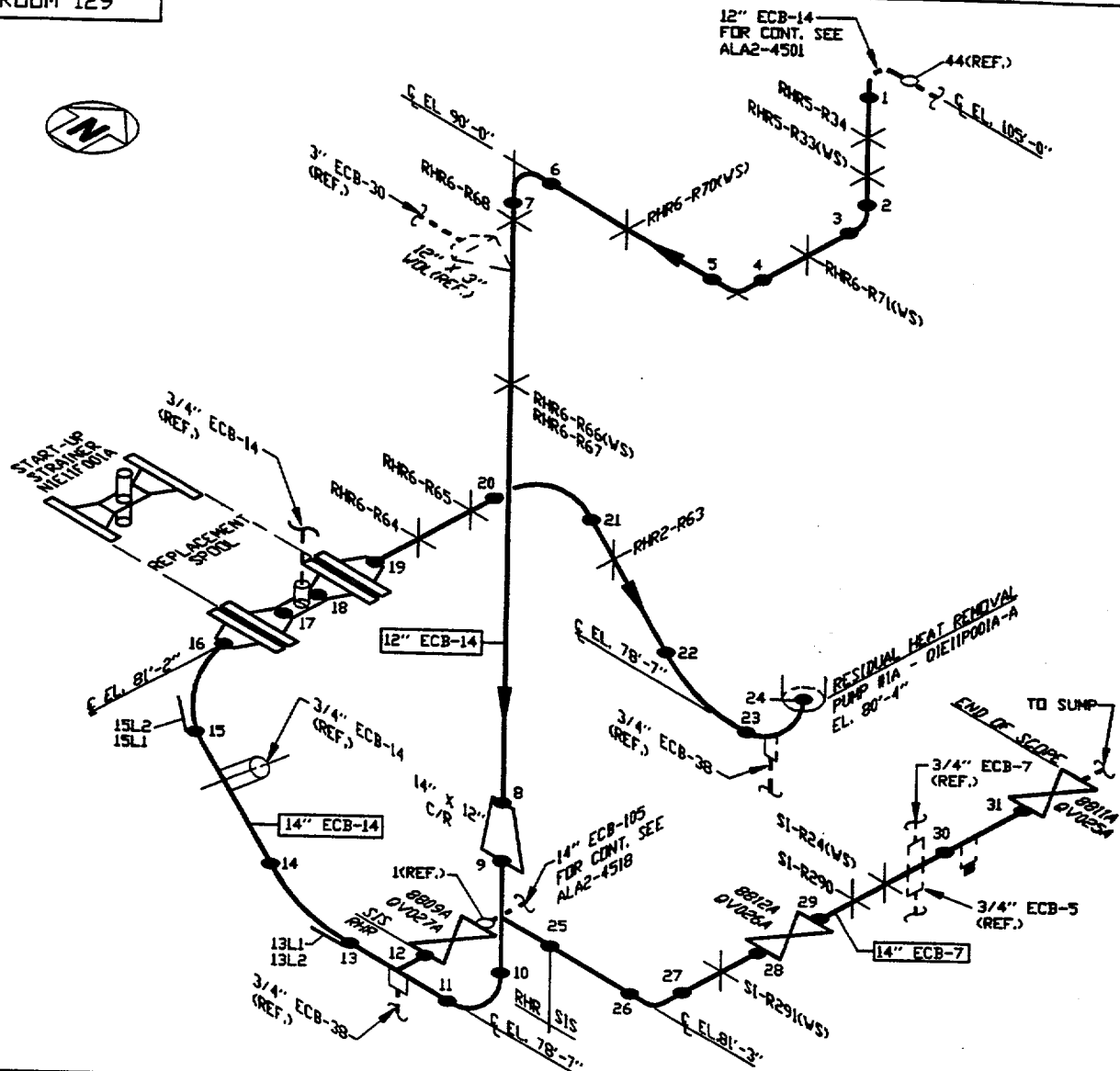
INTERVAL 3 PERIOD 1 OUTAGE 2

DRAWING ALA2-4502

RHR TRAIN A/SI

[illegible]

ALA2-4502



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK	PIPE SCH.
BUTT WELD	23	14"	030	N/A	40S
BUTT WELD	8	12"	030	N/A	40S
LONG SEAM WELD	2	14"	030	N/A	N/A
SOCKET WELD	0	N/A	N/A	N/A	N/A
WELDED SUPP.	6	N/A	028	N/A	N/A
COMP. SUPPORT	12	N/A	037	N/A	N/A

LINE NUMBER: Q-1-E11-ECB-14
Q-1-E11-ECB-7

BOUNDARY DIAGRAM D-351118 SH. 1; D-351115 SH. 2

REFERENCE ISO'S	D-514041 SH. 1

LINE SIZE: 14" ECB-14; 12" ECB-14
14" ECB-7

D-514042	SH.	1
D-514394	SH.	1

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCM for WRH		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc. for

E11-RESIDUAL HEAT REMOVAL

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

100

1

CAD	ALA24502
AUTOCAD	RAV-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNF-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4502-3	Date 3/22/00	Sheet No. S00F1U153	Page 1 of 1
Procedure/Rev./TCN FNF-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38193 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-12	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.375"	1T	80	2.0	0.30	1T	80	2.2	0.30
Ax. dB	43.00	Size	.25	Cal. Temp.	70°	2T	40	4.0	0.60	2T	60	4.2	0.72
Ref.	40	Frequency/Mode	5 / S	Cal. In	0815	3T	30	6.0	0.90				
Scan	50	"A" Dimension	0.2"	Cal. Chk.	N/A	4T	10	8.0	1.20				
Reject	OFF	Nominal Angle	45	Cal. Out	1145	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	N/A								
Mode	P/E	Cable Type	RG174	Reflector	N/A								
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	N/A								

Comp. Temp.: **80 °F** Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 40.0"	Crown Width 0.8"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
		5 (L) NL	2 (L) NL	7 & 8 (W) NL		5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL					
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-23-00			
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00	Percentage of Code Coverage 100 %			ANIL Review <i>[Signature]</i>			Date 3/25/00				

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4502-3		Sheet Number S00F1U152		Date 3/22/00
ISO/Drawing Number ALA2-4502		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136K-472F	
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow ELBOW TO PIPE		
Location LMAX TDC WMAX WELD CL			Component Temp °F 68°	Thermometer S/N PTC 38081	
<u>ELBOW</u> <u>PIPE</u> <u>COMPONENT</u> <u>WELD EDGE</u> <u>WELD CL</u> <u>WELD EDGE</u> <u>COMPONENT</u> <u>FLOW</u> <u>WELD Q</u> <u>T. MEASUREMENTS</u> <u>O.D. PROFILE</u> <u>T. MEASUREMENT EACH</u> IN. REMARKS:					
NDE I/II/III Review <i>Dan Corda</i>		Level III	Date 3-23-00	Non-Technical Review <i>J. Eric Oystock</i>	Date 3-23-00

Revision 1

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4502-3	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P019
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration ELBOW TO PIPE		% of Length Coverage 100 % of Area Coverage 100	Date 3/18/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A Remarks N/A	

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. E. [Signature]</i>	Date 3-20-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/25/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4502-9	Date 3/22/00	Sheet No. S00F1U154	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38193 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.38"	1T	80	2.0	0.35	1T	80	2.0	0.40
Ax. dB	43	Size	.25	Cal. Temp.	70°	2T	50	4.0	0.70	2T	40	4.0	0.80
Ref.	44	Frequency/Mode	5 / S	Cal. In	0825	3T	18	6.0	1.05				
Scan	55	"A" Dimension	0.2"	Cal. Chk.	1010	4T	10	8.0	1.40				
Reject	OFF	Nominal Angle	45	Cal. Out	1146	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	30%/1.4								

Comp. Temp.: **80** °F Configuration: **REDUCER TO TEE** Wo Location **WELD CL** Lo Location **OR OF EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

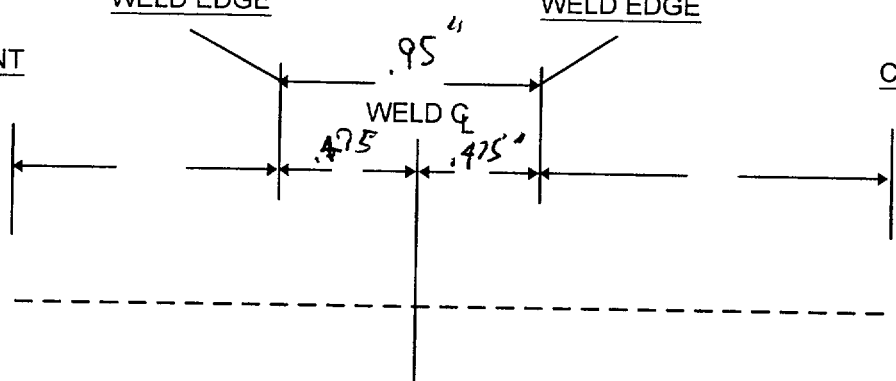
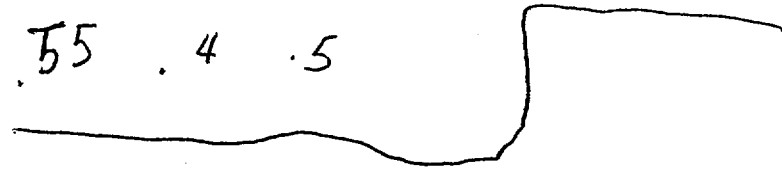
Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 44.0"	Crown Width 0.9"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL		
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>J. Eric Paycock</i>			Date 3-23-00
SNC NDE Level II/III Review <i>Wang Corda L/III</i>		Date 3-23-00	Percentage of Code Coverage 100 %			ANIR Review <i>1964 L 3/23/00</i>			Date 3/23/00	

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4502-9		Sheet Number S00F1U065		Date 3/17/00
ISO/Drawing Number ALA2-4502		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136		Serial Number 136-911K
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow REDUCER TO TEE	
Location LMAX V STAMP WMAX C/L			Component Temp °F 78		Thermometer S/N PTC 38081
<i>tee</i> <u>FLOW</u> <i>Reducer</i> WELD EDGE WELD EDGE COMPONENT .95" COMPONENT WELD Q .475" .475" 					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<i>.55 .4 .5</i> 					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Danny Cards</i>		Level III	Date 3-20-00	Non-Technical Review <i>Lynnda Duke</i>	Date 3-18-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4502-9	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P010	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration REDUCER TO TEE		% of Length Coverage 100	Date 3/17/00	
Ind. No. NA	Results NI	Indication Desc. / Exam Limitations / etc. NA		Remarks NONE

Remarks: **NA**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JSF</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynda Duke</i>	Date 3-18-00
SNC NDE Level II/III Review <i>Dan Corda L/III</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>LG Ward</i>		Date 3/23/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.
1	ALA2-4502-10	3/22/00	S00F1U155
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38193 / 8/27/2000	S00F1L002

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.375								
Ax. dB	<i>Dec 43dB</i>	Size	.25	Cal. Temp.	70°								
Ref.	43	Frequency/Mode	5 / S	Cal. In	0825								
Scan	55	"A" Dimension	0.2"	Cal. Chk.	1015	2T	50	4.0	0.70	2T	40	4.0	0.80
Reject	OFF	Nominal Angle	45	Cal. Out	1146	3T	18	6.0	1.05				
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976	4T	10	8.0	1.40				
Mode	P/E	Cable Type	RG174	Reflector	HOLE	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	30%/1.4								

Comp. Temp.: **80°** °F Configuration: **TEE TO ELBOW** Wo Location **WELD CL** Lo Location **OR OF EL**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2				N/A														
5				N/A														
7				N/A														
8				N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
44.0"	1.1"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL					
Primary Examiner		Level	Assistant Examiner			Level	Non-Technical Review			Date		
GEORGE A. MORINI		II	N/A			N/A	<i>[Signature]</i>			3-23-00		
SNC NDE Level II/III Review			Date	Percentage of Code Coverage			ANII Review			Date		
<i>[Signature]</i>			3-23-00	100 %			<i>[Signature]</i>			3/25/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4502-10		Sheet Number S00F1U067		Date 3/17/00
ISO/Drawing Number ALA2-4502		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136-911K	
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow TEE TO ELBOW	
Location LMAX INTRADOSE WMAX C/L			Component Temp °F 80 Thermometer S/N PTC 38081		

Tee FLOW *Elbow*

COMPONENT WELD Q COMPONENT

T. MEASUREMENTS

O.D. PROFILE

.62 .55 .5 .4 .45

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review	Level	Date	Non-Technical Review	Date
<i>Danny Cordes</i>	III	3-20-00	<i>Lynda Duke</i>	3-18-00

Revision 1

SHARED

Farley Nuclear Plant Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4502-10	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P011	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover Penetrant Developer Type SKC-S SKL-SP SKD-S2 Batch 98A10K 93D12K 96J08K		
Component Configuration TEE TO ELBOW				
Ind. No. NA	Results NI	Indication Desc. / Exam Limitations / etc. NA	% of Length Coverage 100 % of Area Coverage 100	Date 3/17/00
Remarks NONE				

Remarks: **NA**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials JD	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review Lynnda Duke	Date 3-18-00
SNC NDE Level II/III Review Wang Carlos L/III		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review LG Ward		Date 3/23/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4502-12	Date 3/17/88	Sheet No. S00F1U068
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005

Page **1** of **2**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	Cal. Refl. Signal Amp. Sweep Div. Wmax 1T 60 2 .35 2T 50 4 .7 3T 18 6 1.05 4T 10 8 1.4	Cal. Refl. Signal Amp. Sweep Div. Wmax 1T 80 2 .4 2T 40 4 .8						
Serial No.	136-911K	Serial No.	009R2K	Thickness	.375"								
Ax. dB		Circ. dB		Cal. Temp.	72								
Ref.	41	42	Frequency/Mode	5 / S	Cal. In							0820	
Scan	53	54	"A" Dimension	.2	Cal. Chk.							1050	
Reject	OFF	Nominal Angle	45	Cal. Out	1225	Calibration Remarks: NONE							
Frequency	5	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	30% / 4								

Comp. Temp.: **78** °F Configuration: **TEE TO VALVE**

Wo Location C/L Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NR	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 2 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld 44.2"	Crown Width .7"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
		5 (L) NL	2 (L) NA	7 & 8 (W) NL		5 - from NL to NL	2 - from NA to NA	From (5) NL to (2) NL					
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A		Level N/A		Non-Technical Review <i>[Signature]</i>		Date 3-20-00			
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00		Percentage of Code Coverage 73 %		Anti Review <i>[Signature]</i>		Date 3/23/00					

Figure 1

Revision 7

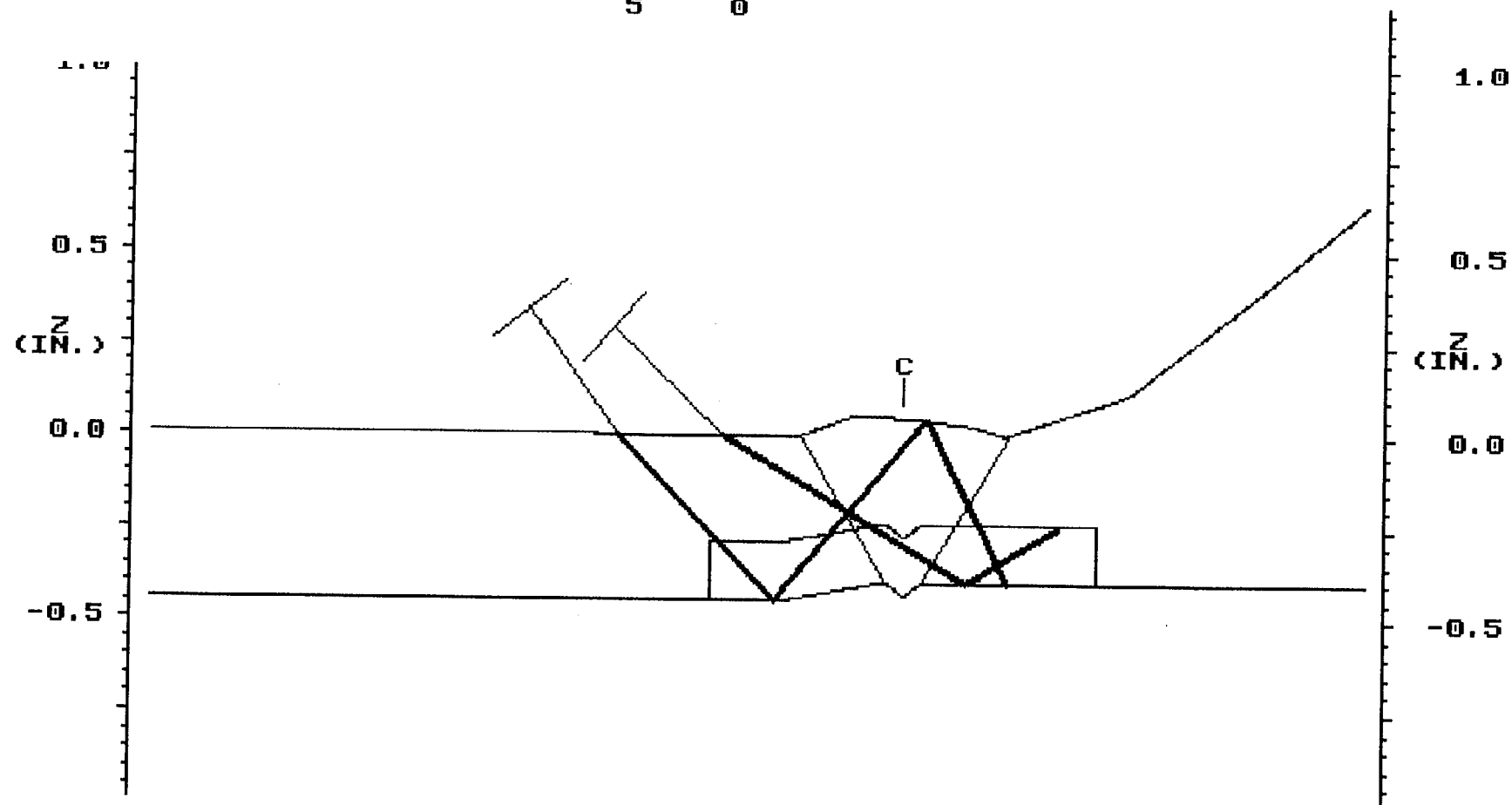
TEE

4
5

FLOW →

6
0

VALVE



Y(IN.) -2.0 -1.5 -1.0 -0.5 0.0 0.5 1.0 Y(IN.)

45	SET	1R16010.DAT 1R16010A.SCR				60	SET
1.27	DEP					0.55	DEP
1.79	MP	ASME CODE COVERAGE				1.11	MP
36.65	TOF					25.70	TOF
	ARC	2/5 SCANS - 75% (3T - 75% 5 / 75% 2)					ARC
	GATE	7/8 SCANS - 71% (TEE AND WELD)					GATE
0.050	STEP	COMPOSITE - 73% RELIEF REQUIRED DR CORDES L/III				0.050	STEP
	EXIT	MAKERAY	UTILITY	LEFT	RIGHT	TOP	PRINT
							EXIT
PLANT: FARLEY 1		3/20/00		CIRC. POS.: TYP			
SYSTEM: RHR				ANALYST: DR CORDES L/III			
COMPONENT: ALA2-4502-12		13:09		CAL. SHEET: SQOF1U068			

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page <u>2</u> of <u>1</u> <u>JAC</u> <u>3-20-00</u>
1	ALA2-4502-12	3/17/00	S00F1U069	
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38081 / 8/27/2000	S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.375								
	Ax. dB	Circ. dB	Size		Cal. Temp.								
Ref.	56	NA	Frequency/Mode	5 / S	Cal. In	1T	80	4	.65				
Scan	68	NA	"A" Dimension	.2	Cal. Chk.	2T	30	8	1.2				
Reject	OFF		Nominal Angle	60	Cal. Out								
Frequency	5		Measured Angle	60	Ref. Blk. No.								
Mode	P/E		Cable Type	RG174	Reflector								
Damping	500 OHMS		Cable Length	45'	Amplitude/Sweep								
					Calibration Remarks: SUPPLEMENTAL EXAM								

Comp. Temp.: **78** °F Configuration: **TEE TO VALVE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NR	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
5				N/A														

Examination/Limitation Remarks:

VALVE RESTRICTS 2 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
44.2"	.7"	5 (L) NL	2 (L) NA	7 & 8 (W) NA	5 - from NA to NA	2 - from NA to NA	From (5) NA to (2) NA						
Primary Examiner	Level	Assistant Examiner				Level	Non-Technical Review		Date				
GEORGE A. MORINI	II	N/A				N/A	<i>[Signature]</i>		3-20-00				
SNC NDE Level II/III Review	Date	Percentage of Code Coverage				Non-Technical Review		Date					
<i>[Signature]</i>	3-20-00	SEE S00F1U068 %				<i>[Signature]</i>		3/23/00					

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4502-12		Sheet Number S00F1U070		Date 3/17/00
ISO/Drawing Number ALA2-4502		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136-911K	
Examiner JOHN W. BELL	SNT Level II		Search Unit Manufacturer KBA	Size .25	
Examiner N/A	SNT Level N/A		Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow TEE TO VALVE	
Location LMAX TDC WMAX C/L		Component Temp °F 78		Thermometer S/N PTC 38180	

TEE FLOW WELD EDGE WELD EDGE VALVE

COMPONENT COMPONENT

T. MEASUREMENTS

O.D. PROFILE .45 .45 .4 .55

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review

Level Date

Non-Technical Review

Date

Dany Corda

III 3-20-00

Lynda Duke

3-18-00

Revision 1

SHARED

Farley Nuclear Plant Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4502-12	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P012	Page 1 of 1
Mfg. / Ser. No. PTC / 38180	Manufacturer MAGNAFLUX	Penetrant Materials		
Cal. Due Date 8/27/2000		Cleaner/Remover SKC-S	Batch 98A10K	
Surface Temp. 80 °F		Penetrant SKL-SP	93D12K	
Component Configuration TEE TO VALVE	Developer SKD-S2	96J08K		
Ind. No. NA	Results NI	Indication Desc. / Exam Limitations / etc. NA	% of Length Coverage 100	Date 3/17/00
			% of Area Coverage 100	
			Remarks NONE	

Remarks: **NA**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>[Signature]</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>[Signature]</i>	Date 3-18-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/23/00	

Figure 1

Revision 6

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Page 1 of 2

Unit 1
Sketch/Component No. ALA2-4502-16

Procedure/Rev./TCN

FNP-0-NDE-100.31 / 7 / N/A

Couplant/Batch No.

SONOTRACE 40 / 94243

Date
3/17/00

Thermometer SN/Cal Due Date
38081 / 8/27/2000

Sheet No.
S00F1U071
Linearity Sheet No.
S00F1L005

Instrument		Search Unit		Calibration Block	
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49
Serial No.	136-911K	Serial No.	009R2K	Thickness	.375"
Ax. dB	41	Size	.25	Cal. Temp.	72
Circ. dB	42	Frequency/Mode	5 / S	Cal. In	0820
Ref.	53	"A" Dimension	.2	Cal. Chk.	1105
Scan	54	Nominal Angle	45	Cal. Out	1225
Reject	OFF	Measured Angle	45	Ref. Blk. No.	4976
Frequency	5	Cable Type	RG174	Reflector	HOLE
Mode	P/E	Cable Length	45'	Amplitude/Sweep	30% / 4
Damping	500 OHMS				

Axial Scan Calibration				Circ. Scan Calibration			
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
1T	60	2	.35	1T	80	2	.4
2T	50	4	.7	2T	40	4	.8
3T	18	6	1.05				
4T	10	8	1.4				

Calibration Remarks:
NONE

Comp. Temp.: 78 °F

Configuration: ELBOW TO FLANGE

Configuration: ELBOW TO FLANGE																		
Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness		Notes:	
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	--> 1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

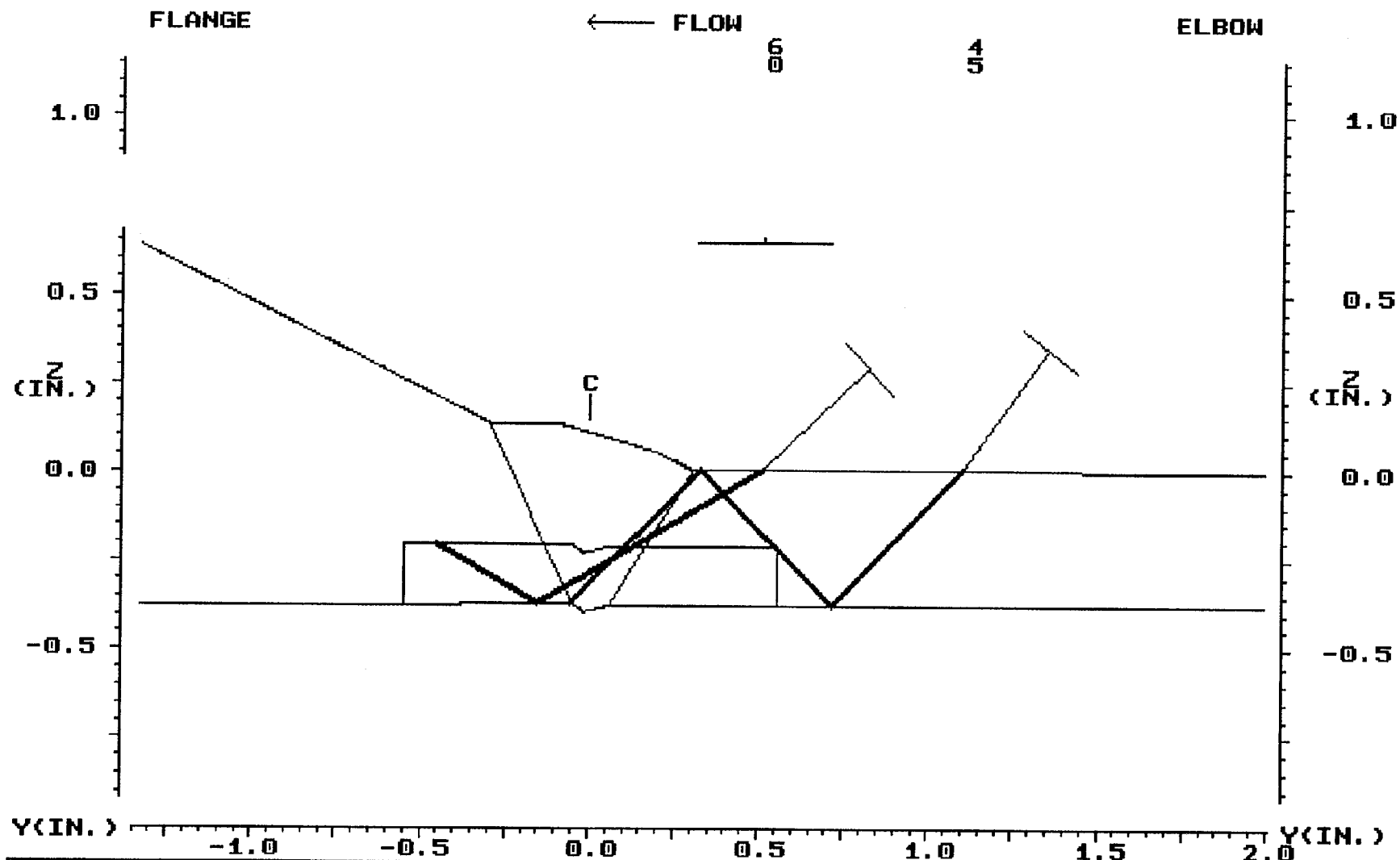
Examination/Limitation Remarks:

FLANGE RESTRICTS 2 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
44.2"	.6"	5 (L) NL	2 (L) NA	7 & 8 (W) NL	5 - from NL	to NL	2 - from NA	to NA	From (5) NL	to (2) NL	
Primary Examiner		Level II		Assistant Examiner		Level N/A		Non-Technical Review		Date	
GEORGE A. MORINI								Date		3-20-00	
SNC NDE Level II/III Review		Date		Percentage of Code Coverage		67 %		Date		3/23/00	
		3-20-00									

Figure 1

Revision 7



45	SET	1R16013.DAT 1R16013A.SCR						60	SET
1.15	DEP							0.55	DEP
1.63	MP	ASME CODE COVERAGE PLOT						1.11	MP
34.05	TOF							25.75	TOF
	ARC	2/5 SCANS - 65% (3T - 50% 5 / 80% 2) <i>DR L/III</i>							ARC
	GATE	7/8 SCANS - 69% (EL+WELD)							GATE
0.050	STEP	COMPOSITE - 67% RELIEF REQUIRED DR CORDES L/III						0.050	STEP
	EXIT	MAKERAY	UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT	EXIT
PLANT:		FARLEY 1		3/20/00		CIRC. POS.:		TYP	
SYSTEM:		RHR				ANALYST:		DR CORDES	
COMPONENT:		ALA2-4502-16				CAL. SHEET:		SOOF1U071 & 072	

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4502-16	Date 3/17/00	Sheet No. S00F1U072	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration				
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.375"									
Ax. dB		Circ. dB		Cal. Temp.	72									
Ref.	56	NA	Size	.25	Cal. In									0809
Scan	68	NA	Frequency/Mode	5 / S	Cal. Chk.	1135	1T	80	4	.65				
Reject	OFF		"A" Dimension	.2	Cal. Out	1228	2T	30	8	1.2				
Frequency	5		Nominal Angle	60	Ref. Blk. No.	4976	Calibration Remarks: SUPPLEMENTAL EXAM							
Mode	P/E		Measured Angle	60	Reflector	HOLE								
Damping	500 OHMS		Cable Type	RG174	Amplitude/Sweep	60% / 7								
			Cable Length	45'										

Comp. Temp.: **78** °F Configuration: **ELBOW TO FLANGE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
5				N/A														

Examination/Limitation Remarks:

FLANGE RESTRICTS 2 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld 44.2		Crown Width .6"	Total Length of Weld Examined 5 (L) NL 2 (L) NA 7 & 8 (W) NA			Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NA to NA			Extent of Parallel Scans (L) From (5) NA to (2) NA		
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-20-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00	Percentage of Code Coverage SEE S00F1U071 %		ANI Review <i>[Signature]</i>			Date 3/23/00			

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4502-16		Sheet Number S00F1U073		Date 3/17/00
ISO/Drawing Number ALA2-4502		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136-911K	
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow ELBOW TO FLANGE	
Location LMAX TDC WMAX C/L		Component Temp °F 78		Thermometer S/N PTC 38081	
<u>FLANGE</u> <u>FLOW</u> <u>ELBOW</u> <u>WELD EDGE</u> <u>WELD EDGE</u> <u>COMPONENT</u> <u>COMPONENT</u> <u>WELD Q</u> <u>6"</u> <u>.3</u> <u>.3</u> <u>T. MEASUREMENTS</u> <u>O.D. PROFILE</u> <u>.5</u> <u>.38</u> <u>.38</u> <u>T. MEASUREMENT EACH</u> <u>IN.</u> REMARKS:					
NDE I/II/III Review <i>[Signature]</i>		Level III	Date 3-20-00	Non-Technical Review <i>[Signature]</i>	Date 3-18-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4502-16	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P013
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration ELBOW TO FLANGE		% of Length Coverage 100 % of Area Coverage 100	Date 3/17/00
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.	Remarks
NA	NI	NA	NONE

Remarks: **NA**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynda Duke</i>	Date 3-18-00
SNC NDE Level II/III Review <i>Jay Conda</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>cg Ward</i>		Date 3/23/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4502-24	Date 3/17/00	Sheet No. S00F1U074	Page i of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R2K	Thickness	.375								
Ax. dB		Circ. dB		Cal. Temp.	72								
Ref.	41		42	Frequency/Mode	5 / S								
Scan	53		54	"A" Dimension	.2								
Reject	OFF	Nominal Angle	45	Cal. Chk.	1115	3T	18	6	1.05				
Frequency	5	Measured Angle	45	Cal. Out	1225	4T	10	8	1.4				
Mode	P/E	Cable Type	RG174	Ref. Blk. No.	4976	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	30% / 4								

Comp. Temp.: **78** °F Configuration: **ELBOW TO NOZZLE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	--> 1"	
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks:

NOZZLE RESTRICTS 2 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld 44.2"	Crown Width .8"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)						Extent of Parallel Scans (L)									
		5 (L)	NL	2 (L)	NA	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NA	to	NA	From (5)	NL	to	(2)	NL
Primary Examiner GEORGE A. MORINI		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-20-00						
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00		Percentage of Code Coverage 86%				ANIR Review <i>[Signature]</i>				Date 3/23/00								

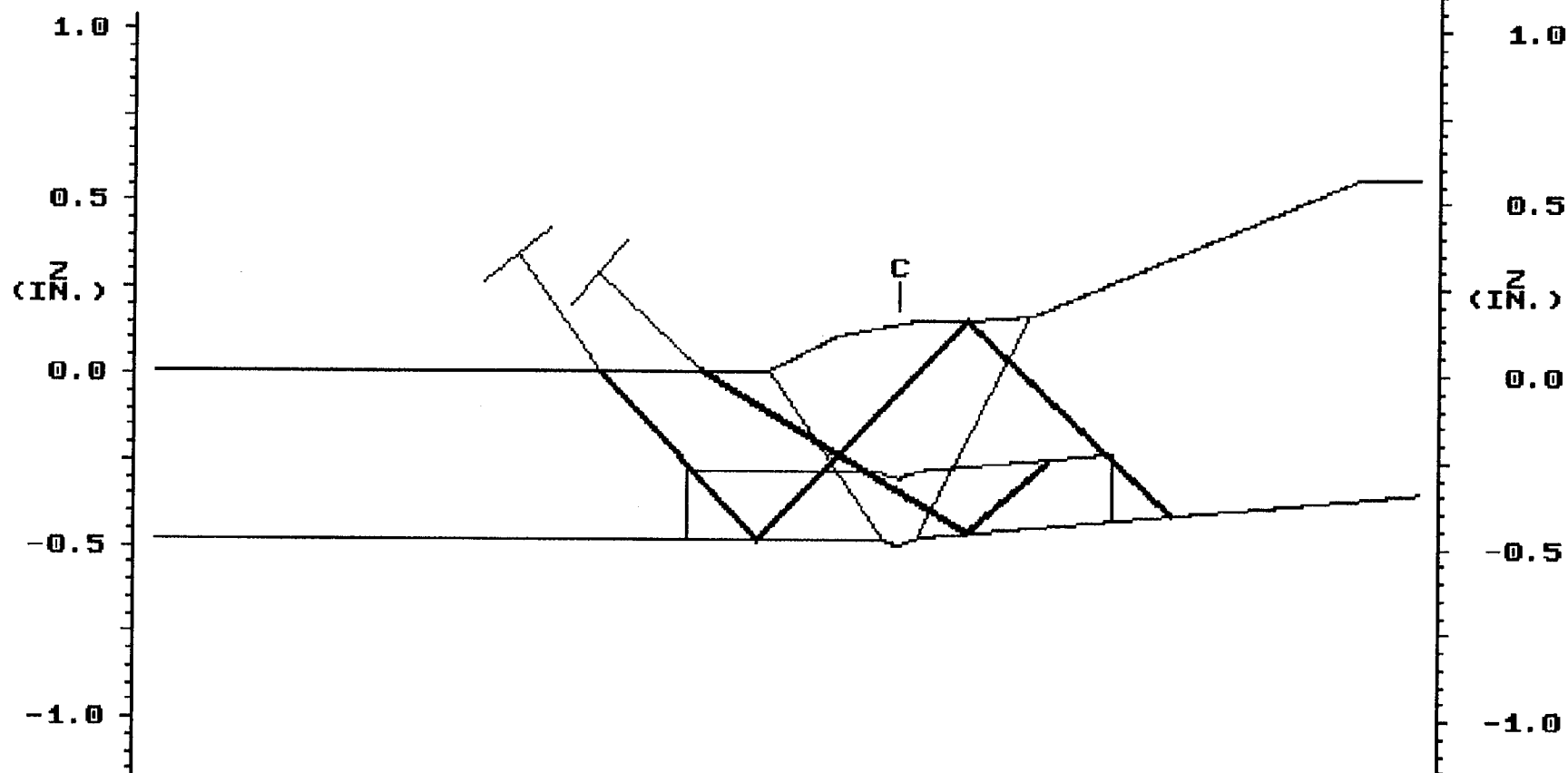
Figure 1

Revision 7

ELBOW

FLOW →

NOZZLE

4
60

Y(IN.) -2.0 -1.5 -1.0 -0.5 0.0 0.5 1.0 1.5 Y(IN.)

45	SET	1R16012.DAT 1R16012A.SCR						60	SET
1.71	DEP	ASME CODE COVERAGE PLOT						0.63	DEP
2.42	MP							1.26	MP
46.75	TOF	2/5 SCANS - 100% (3T)						28.20	TOF
	ARC								ARC
	GATE	7/8 SCANS - 72% (EL+WELD)							GATE
0.050	STEP							0.050	STEP
	EXIT	COMPOSITE - 86% RELIEF REQUIRED DR CORDES L/III							EXIT
		MAKERAY/UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT		EXIT

PLANT: FARLEY 1 3/20/00 CIRC. POS.: TYP
 SYSTEM: RHR ANALYST: DR CORDES
 COMPONENT: ALA2-4502-24 11:23 CAL. SHEET: S00F1U074 & 075

074 20F2

SHARED

FNP-0-NDE-100.31

Unit

Sketch/Component No.

Date _____

Sheet No.

1

ALA2-4502-24

3/17/00

S00F1U075

Page 1 of 1

Procedure/Rev./TCN

Couplant/Batch No.

Thermometer SN/Cal Due Date

Linearity Sheet No.

FNP-0-NDE-100.31 / 7 / N/A

SONOTRACE 40 / 94243

38081 / 8/27/2000

S00F1L005

Comp. Temp.: 78 °F				Configuration: ELBOW TO NOZZLE												Wo Location C/L				Lo Location TDC			
Scan Dir.	Results			Ind. No.	% DAC	L1	Length		Reference Measurement			Sweep Position			Thickness		Notes:						
	NI	NRI	RI				Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < -- C/L -- > 1"								

NOZZLE RESTRICTS 2 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
44.2"	.8"	5 (L) <u>NL</u>	2 (L) <u>NA</u>	7 & 8 (W) <u>NA</u>	5 - from <u>NA</u>	to <u>NA</u>	2 - from <u>NA</u>	to <u>NA</u>	From (5) <u>NA</u>	to (2) <u>NA</u>			
Primary Examiner		Level	Assistant Examiner			Level	Non-Technical Review			Date			
GEORGE A. MORINI		II	N/A			N/A				3-20-00			
SNC NDE Level II/III Review			Date	Percentage of Code Coverage			ANI Review			Date			
 L/III			3-20-00	SEE 5605-10074 %						3/20/00			

Figure 1

Revision 7

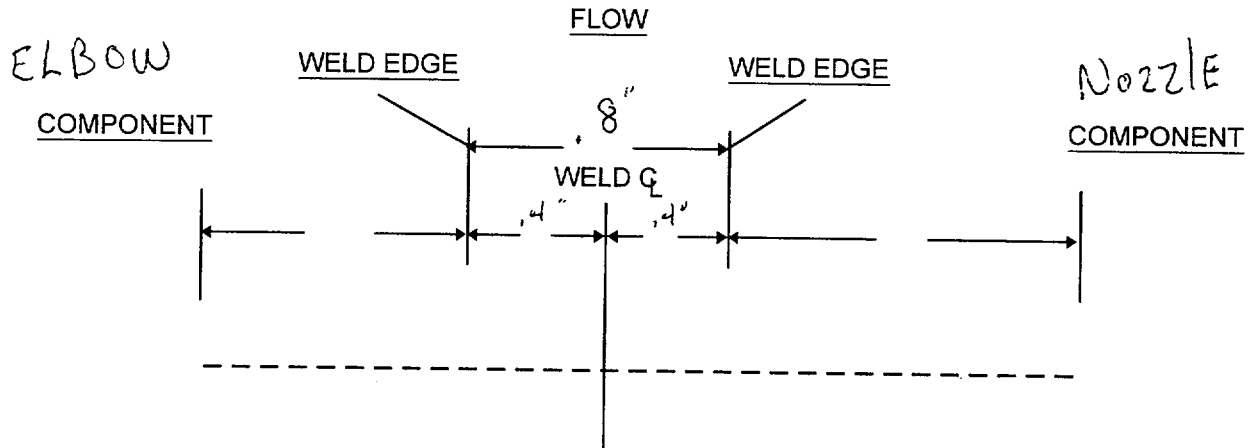
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

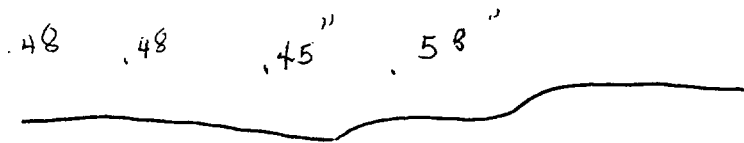
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4502-24	Sheet Number S00F1U076	Date 3/17/00
ISO/Drawing Number ALA2-4502	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136-911K
Examiner GEORGE A. MORINI <i>[Signature]</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow ELBOW TO NOZZLE	
Location LMAX TDC WMAX C/L	Component Temp °F 78	Thermometer S/N PTC 38081	



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>[Signature]</i>	Level III	Date 3-20-00	Non-Technical Review <i>[Signature]</i>	Date 3-18-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4502-24	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P014	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO NOZZLE		% of Length Coverage 100	Date 3/17/00	
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.		Remarks
NA	NI	NA	NONE	

Remarks: **NA**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynda Duke</i>	Date 3-18-00
SNC NDE Level II/III Review <i>Danny Cordes L/III</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>EG</i>		Date 3/23/00	

Figure 1

Revision 6

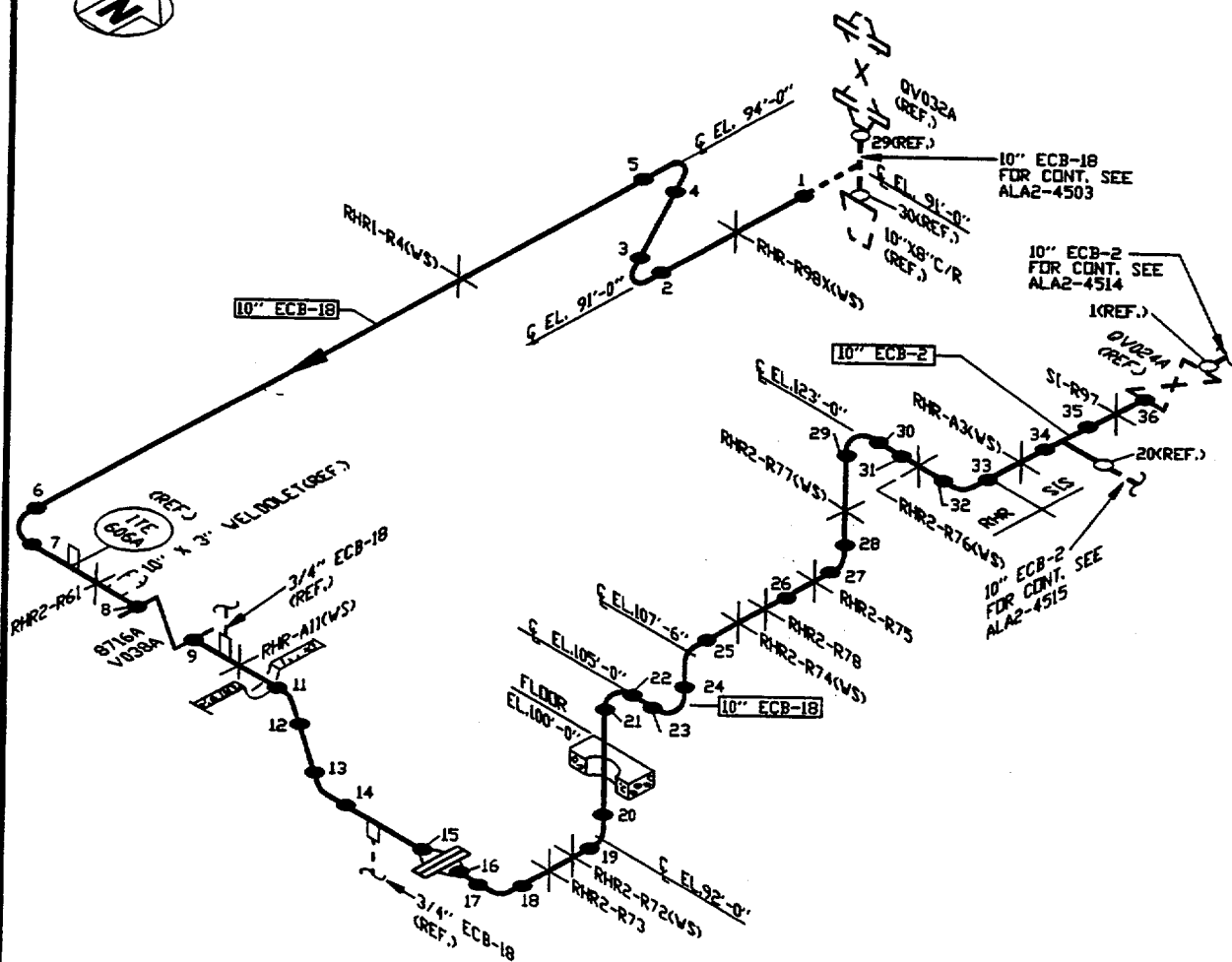
DRAWING ALA2-4504
RHR TRAIN A

[illegible]

AUXILIARY
EL. 83'-0"
ROOM 131

RHR TRAIN A

ALA2-4504



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	35	10"	030	N/A
LONG SEAM WELD	0	N/A	030	N/A
SOCKET WELD	0	N/A	N/A	N/A
WELDED SUPP.	8	N/A	028	N/A
COMP. SUPPORT	13	N/A	037	N/A

LINE NUMBER: Q-1-E11-ECB-18

Q-1-E11-ECB-2

LINE SIZE: 10" ECB-18; 10" ECB-2

BOUNDARY DIAGRAM D-351118 SH. 1

REFERENCE ISO'S D-514037 SH. 1

D-514038 SH. 1

D-514517 SH. 1

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.

LDT

DLG

FED

DEF

WRH

AH

DML

REV. DATE BY CHK'D DESCRIPTION

APPR.1

APPR.2

APPR.3

APPR.4

Southern Company Services, Inc. for

E11-RESIDUAL HEAT REMOVAL

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

102

1

CAD ALA24504
AUTOCAD RAV-02

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4504-RHR2-R72 (W8)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P022
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100 % of Area Coverage 100	Date 3/21/00
Ind. No. N/A	Results NRI	Indication Desc. / Exam Limitations / etc. N/A	Remarks N/A

Remarks: **NONE**

Primary Examiner PAUL DiVALERIO	ASNT Level II	Initials <i>PD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>[Signature]</i>	Non-Technical Review <i>[Signature]</i>	Date 3-21-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-21-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/23/00	

Figure 1

Revision 6

SHARED

FNP-0-NDE-100.23
RTYPE: L1.09

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4504-RHR2-R72	WOW/NA/STP N/A	Sheet No. S00F1V007
Hanger Type SWAY STRUT W/ATTACH	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/9/00
Examiner / Initial PAUL DIVALERIO Sig. <i>Paul DiValerio</i>	Level II	Resolution ● 1/32" Division Scale ○ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable/ Unacceptable Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments: PLANT IN MODE 6 AT TIME OF EXAM			

Danny Cordes L/III 3-10-2000 *ANTI REVIEW: C. G. Ward 3/15/00*

Revision 3

DRAWING ALA2-4505
SI/RHR TRAIN A

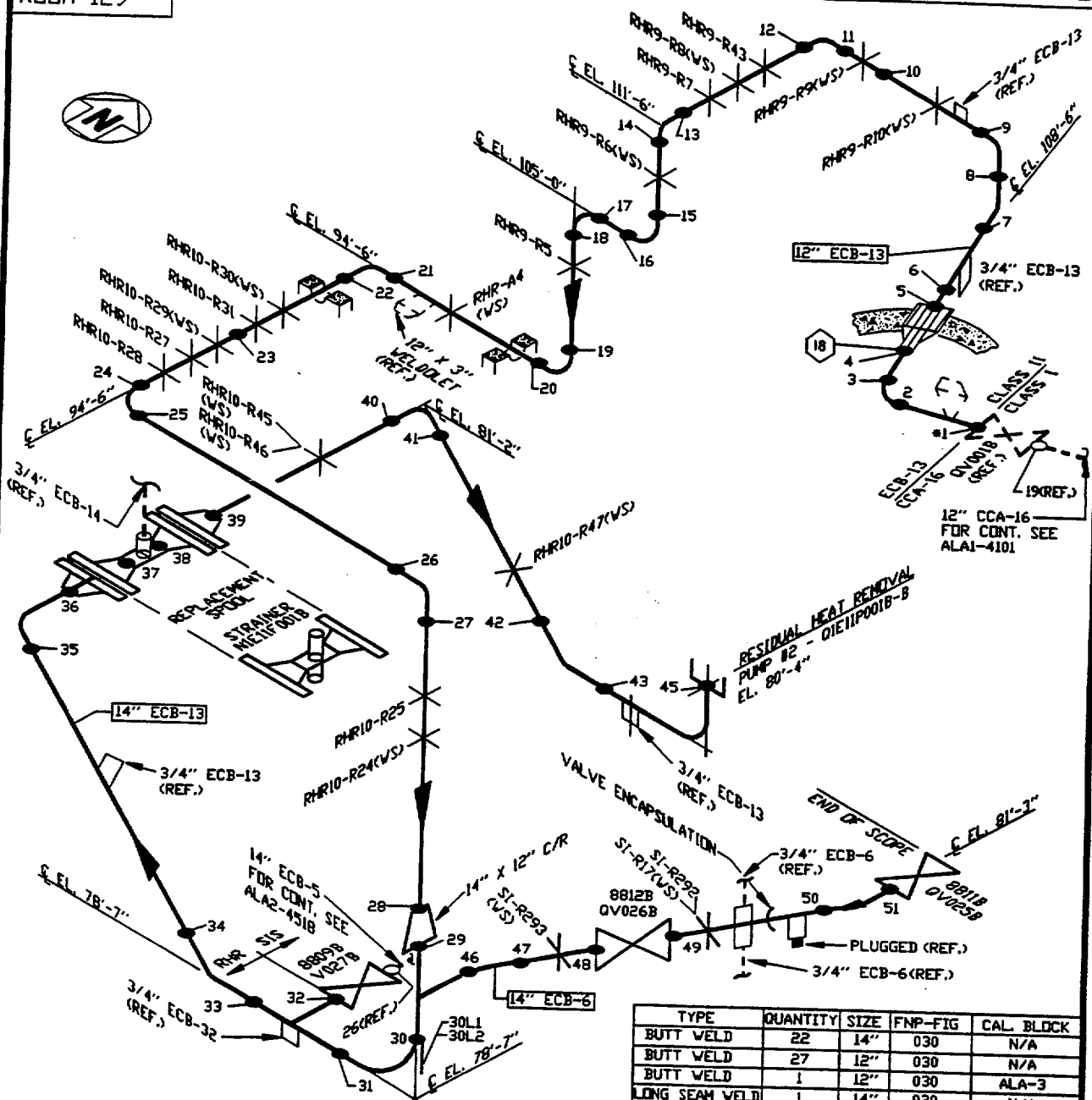
[illegible]

AUXILIARY
EL. 77'-0"
ROOM 129

SI / RESIDUAL HEAT REMOVAL

FNP-1-M-097

ALA2-4505



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	22	14"	030	N/A
BUTT WELD	27	12"	030	N/A
BUTT WELD	1	12"	030	ALA-3
LONG SEAM WELD	1	14"	030	N/A
SOCKET WELD	0	N/A	N/A	N/A
WELDED SUPP.	13	20"	028	N/A
COMP. SUPPORT	21	N/A	037	N/A

LINE NUMBER: Q-1-E11-ECB-6
Q-1-E11-ECB-13

LINE SIZE: 14" ECB-6, 14" ECB-13
12" ECB-13

BOUNDARY DIAGRAM D-351115 SH. 2, D-351118 SH. 1
REFERENCE ISO'S D-514045 SH. 1
D-514046 SH. 2
D-514394 SH. 1
D-514690 SH. 2

2 3-26-98 RAW JAR REVISED PER REA 96-1295, REV. 0.
0 6-30-92 SDH JAR ISSUED PER PCN S-92-1-8162.

REV. DATE BY CHK'D DESCRIPTION LDT DLG MDEW X X X X
CAB CCM/VRH AH DML
APPR.1 APPR.2 APPR.3 APPR.4

Southern Company Services, Inc. for E11-RESIDUAL HEAT REMOVAL

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER SHEET REV.

A-351192

103 2

CAD ALA24505
AUTOCAD JLB-04

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4505-RHR10-R28	WOWA/STP N/A	Sheet No. S00F1V006
Hanger Type SWAY STRUT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/9/00
Examiner / Initial PAUL DIVALERIO Sig. <i>Paul Divalerio</i>	Level II	Resolution ● 1/32" Division Scale ○ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable/Unacceptable Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments: PLANT IN MODE 6 AT TIME OF EXAM			
<i>Danny Cordes L/III 3-10-2000</i> <i>AND REVIEW: CGWand 3/15/00</i>			

Revision 3

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4505-RHR10-R45	WOW/VA/STP N/A	Sheet No. S00F1V005
Hanger Type ONE DIRECTIONAL RESTRAINT W/ATTACH	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/9/00
Examiner / Initial PAUL D'VALERIO	Level II	Resolution 1/32" Division Scale	Tools FLASHLIGHT, MIRROR, SCALE
Sig. <i>[Signature]</i>			
Examiner / Initial N/A	Level N/A	Resolution 1/32" Line (Gray Card)	
Sig.			

EXAMINATION LIST:	Acceptable/ Unacceptable	SKETCH (if applicable)
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable	
Missing, detached, or loosened support items.	Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A	
Improper hot or cold positions.	N/A	
Any crack or linear indication.	Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A	
Other Conditions:	N/A	

Comments: PLANT IN MODE 6 AT TIME OF EXAM

<i>Danny Cordes L/III 3-10-2000</i>	<i>ANTI REVIEW: C.G. W. 3/15/00</i>

Revision 3

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4505-RHR10-R45 (WS)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P018
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2	
		Batch 98A10K 93D12K 96J08K	
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100 % of Area Coverage 100	Date 3/18/00
Ind. No. N/A	Results NI	Remarks N/A	
Indication Desc. / Exam Limitations / etc. N/A			

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. Erwin Dwyer</i>	Date 3-20-00
SNC NDE Level II/III Review <i>Dan Carden</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>cg Ward</i>		Date 3/23/00	

Figure 1

Revision 6

[illegible]

AUXILIARY
EL. 100'-0"
ROOM

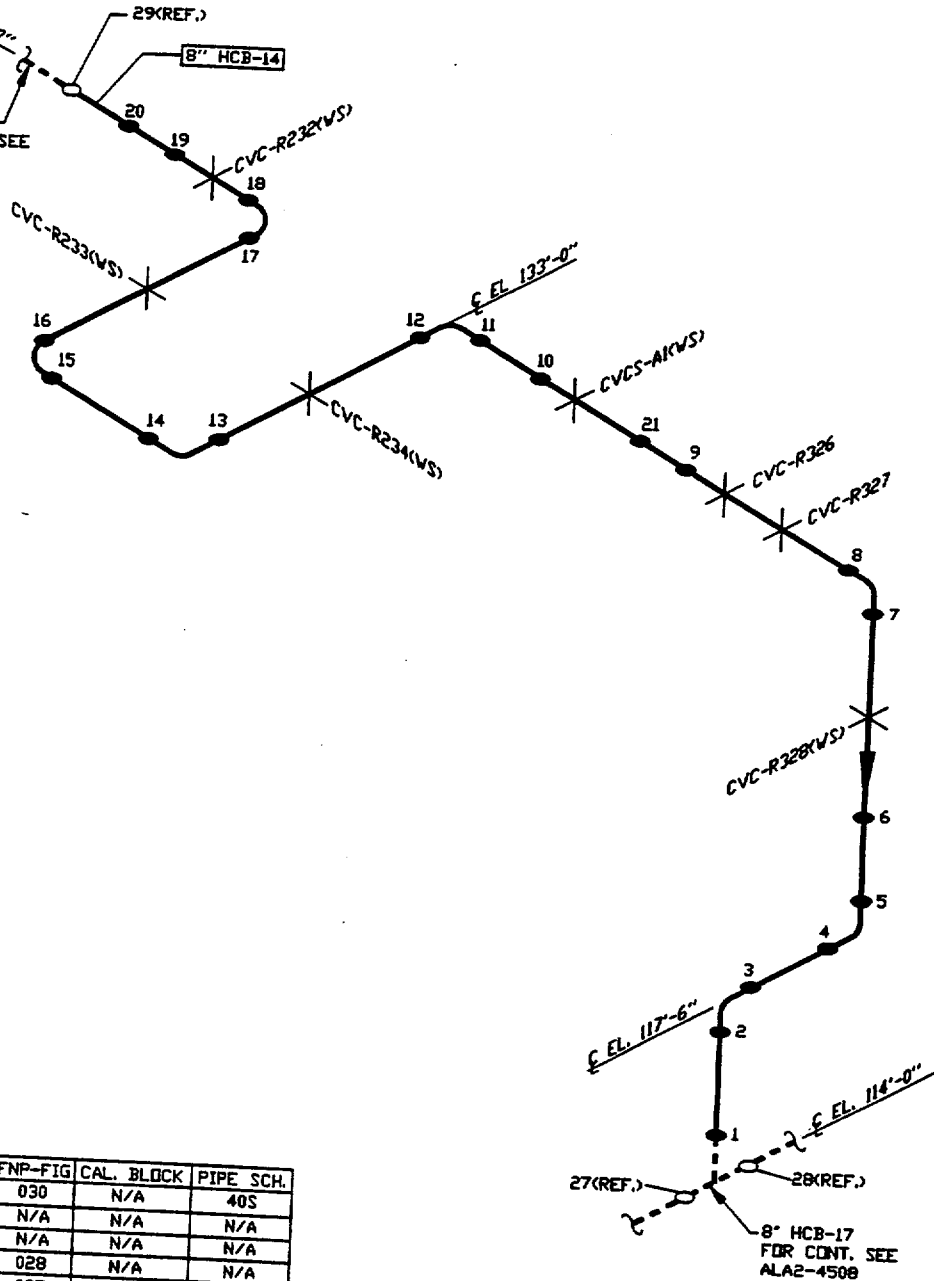
CVCS FROM RHR TRAIN A

FNP-1-M-097

ALA2-4509



8" HCB-14
FOR CONT. SEE
ALA2-4510



TYPE	QTY.	SIZE	FNP-FIG	CAL. BLOCK	PIPE SCH.
BUTT WELD	21	8"	030	N/A	40S
LONG SEAM WELD	0	N/A	N/A	N/A	N/A
SOCKET WELD	0	N/A	N/A	N/A	N/A
WELDED SUPP.	5	N/A	028	N/A	N/A
COMP. SUPPORT	7	N/A	037	N/A	N/A

LINE NUMBER: Q-1-E21-HCB-14

BOUNDARY DIAGRAM D-351116 SH. 2

REFERENCE ISO'S D-514366 SH. 1
D-514589 SH. 1

LINE SIZE: 8" HCB-14

1	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.
REV.	DATE	BY	CHK'D	DESCRIPTION

LDT	DLG	DEV	CCM	WRH	AH	DML
CAB	APPR.1	APPR.2	APPR.3	APPR.4		

Southern Company Services, Inc. for
ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

E21-CHEMICAL AND VOLUME CONTROL

SCS DRAWING NUMBER

A-351192

SHEET

107

REV.

1

CAD ALA24509
AUTOCAD JLB-03

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4509-CVC-R232	WOW/STP N/A	Sheet No. S00F1V014
Hanger Type ONE DIRECTIONAL RESTRAINT W/ATTACH	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL DIVALERIO Sig. <i>Paul Divalerio</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments: PLANT IN MODE 6 AT EXAM TIME			

Danny Cardes LIII 3-14-00

ANTI REVIEW: C. G. Ward 3/16/00

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4509-CVC-R232 (WS)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P016
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100 % of Area Coverage 100	Date 3/18/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A	Remarks N/A

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>[Signature]</i>	Non-Technical Review <i>[Signature]</i>	Date 3-20-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/23/00	

Figure 1

Revision 6

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2
SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4509-CVC-R233	WOW/STP N/A	Sheet No. S00F1V013
Hanger Type TWO DIRECTIONAL RESTRAINT W/ATTACH	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO Sig. <i>Paul D'Valerio</i>	Level II	Resolution ● 1/32" Division Scale ○ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable/Unacceptable Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments: PLANT IN MODE 6 AT EXAM TIME			

Day Cade LHT 3-15-00 *Cy Ward 3/17/00*
AND REMOV

Revision 3

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4509-CVC-R233 (W8)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P017	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F Penetrant Materials Manufacturer MAGNAFLUX Type SKC-S SKL-SP SKD-S2 Batch 98A10K 93D12K 96J08K				
Component Configuration WELDED ATTACHMENT			% of Length Coverage 100 % of Area Coverage 100	Date 3/18/00
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.	Remarks	
N/A	NI	N/A	N/A	

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>ck</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>P. Erwin Deprock</i>	Date 3-20-00
SNC NDE Level II/III Review <i>Darryl Cords</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>cgw</i>		Date 3/23/00	

Figure 1

Revision 6

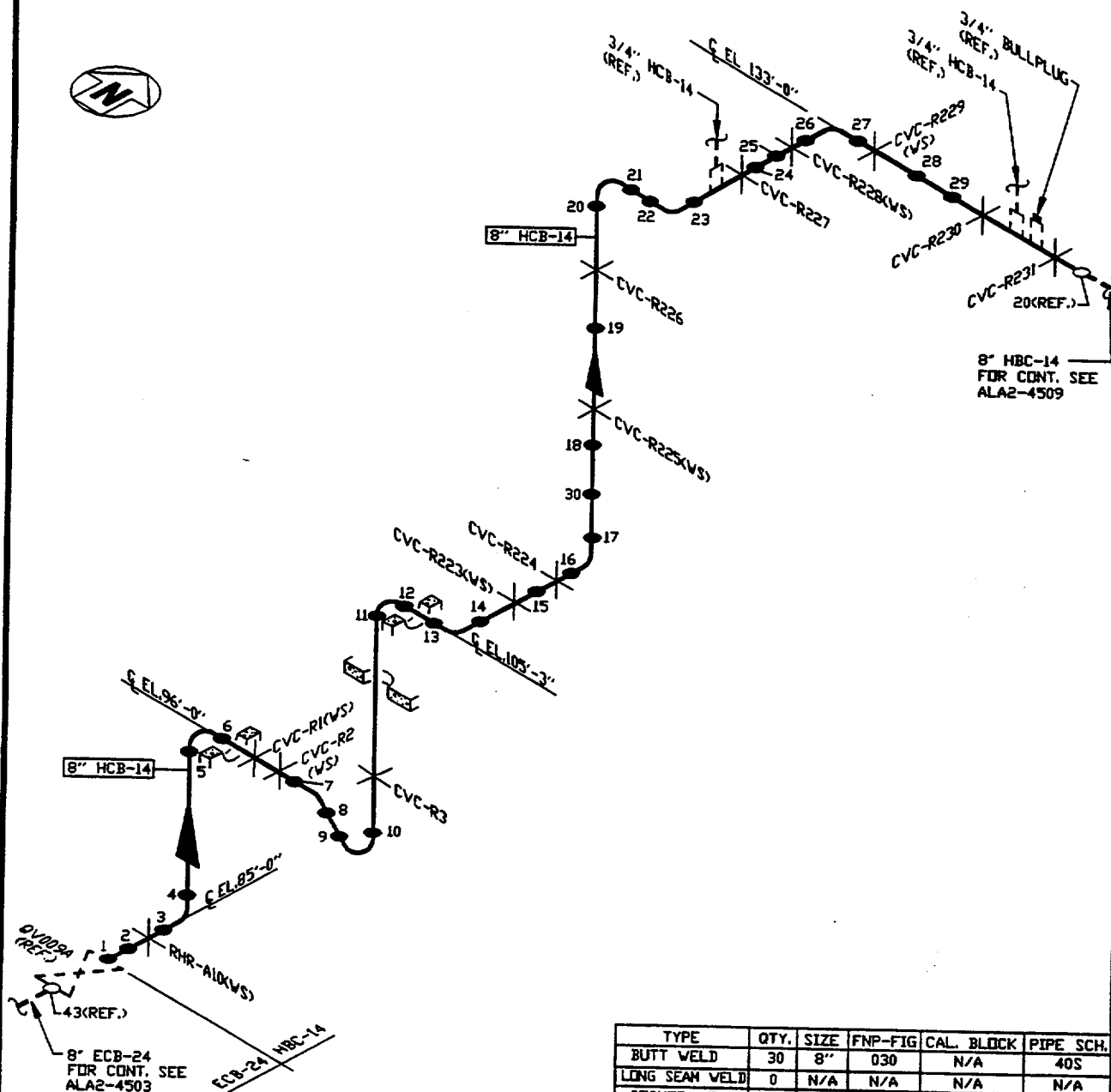
DRAWING ALA2-4510
RHR SINGLE STREAM

[illegible]

AUXILIARY
EL. 100'-0"
ROOM

CVCS FROM TRAIN A

ALA2-4510



TYPE	QTY.	SIZE	FNP-FIG	CAL. BLOCK	PIPE SCH.
BUTT WELD	30	8"	030	N/A	40S
LONG SEAM WELD	0	N/A	N/A	N/A	N/A
SOCKET WELD	0	N/A	N/A	N/A	N/A
WELDED SUPP.	7	N/A	028	N/A	N/A
COMP. SUPPORT	13	N/A	037	N/A	N/A

LINE NUMBER: Q-1-E21-HCB-14

BOUNDARY DIAGRAM D-351116 SH. 6; D-351118 SH. 1

LINE SIZE: 8" HCB-14

REFERENCE ISO'S D-514363 SH. 1
D-514589 SH. 1

2	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG	PR/DEV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCV/WRH	AH	DML	
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for E21-CHEMICAL AND VOLUME CONTROL

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

108

2

CAD ALA24510
AUTOCAD JLB-04

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4510-CVC-R225	WO/WA/STP N/A	Sheet No. S00F1V017
Hanger Type 3 DIRECTIONAL RESTRAINT W/ATTACH	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO	Level II	Resolution ☒ 1/32" Division Scale	Tools FLASHLIGHT, MIRROR, SCALE
Sig. <i>Paul D'Valerio</i>		☐ 1/32" Line (Gray Card)	
Examiner / Initial N/A	Level N/A		
Sig.			

EXAMINATION LIST:	Acceptable/ Unacceptable	SKETCH (if applicable)
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable	
Missing, detached, or loosened support items.	Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A	
Improper hot or cold positions.	N/A	
Any crack or linear indication.	Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A	
Other Conditions:	N/A	

Comments:
PLANT IN MODE 6 AT EXAM TIME

Danny Cordis L/TM 3-14-00

ANDE REVIEW: CgW and 3/16/00

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4510-CVC-R225 (W8)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P015
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 77 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100 % of Area Coverage 100	Date 3/18/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A	Remarks N/A

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>J. Erwin Aycock</i>	Non-Technical Review <i>J. Erwin Aycock</i>	Date 3-20-00
SNC NDE Level II/III Review <i>James Carde L/III</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>CK</i>		Date 3/23/00	

Figure 1

Revision 6

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4510-CVC-R230	WO/WA/STP N/A	Sheet No. S00F1V016
Hanger Type TWO DIRECTIONAL RESTRAINT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO	Level II	Resolution 1/32" Division Scale	Tools
Sig. <i>[Signature]</i>		1/32" Line (Gray Card)	
Examiner / Initial N/A	Level N/A		
Sig.			

EXAMINATION LIST:	Acceptable/ Unacceptable	SKETCH (if applicable)
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable	
Missing, detached, or loosened support items.	Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A	
Improper hot or cold positions.	N/A	
Any crack or linear indication.	Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A	
Other Conditions:	N/A	

Comments:

PLANT IN MODE 6 AT EXAM TIME

Day Cards L/H 3-14-00

ANTI REVIEW: egw and 3/16/00

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4510-CVC-R231	WOWA/STP N/A	Sheet No. S00F1V015
Hanger Type SWAY STRUT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO	Level II	Resolution ● 1/32" Division Scale	Tools FLASHLIGHT, MIRROR, SCALE
Sig. <i>Paul D'Valerio</i>		○ 1/32" Line (Gray Card)	
Examiner / Initial N/A	Level N/A		
Sig.			
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable/ Unacceptable Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments: PLANT IN MODE 6 AT EXAM TIME			

Dan Cade LIII 3-14-00 *ANII REVIEW: Eglwood 3/14/00*

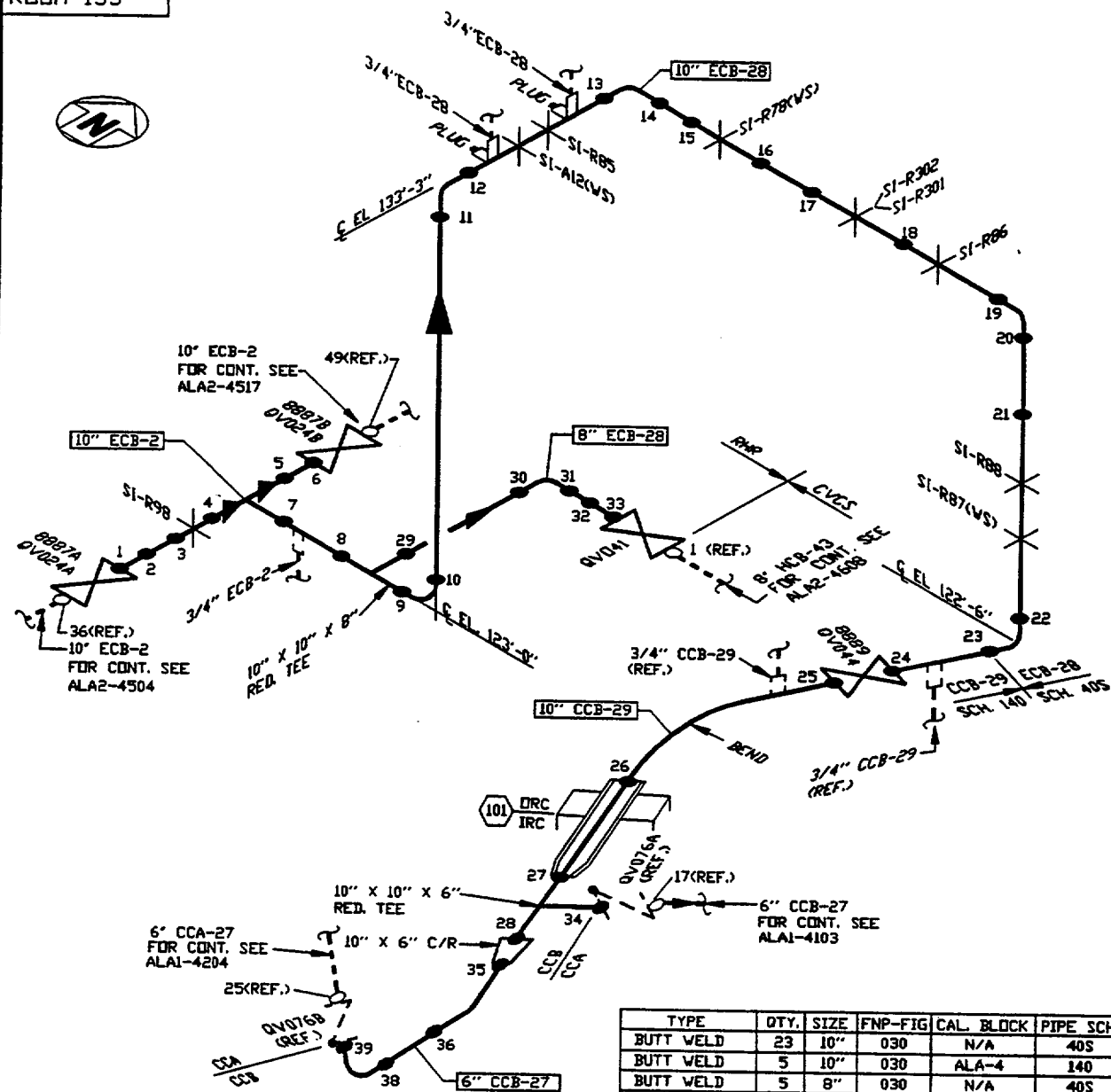
DRAWING ALA2-4514
CVCS FROM RHR

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 133

RHR SINGLE STREAM

ALA2-4514



TYPE	QTY.	SIZE	FNP-FIG	CAL. BLOCK	PIPE SCH.
BUTT WELD	23	10"	030	N/A	40S
BUTT WELD	5	10"	030	ALA-4	140
BUTT WELD	5	8"	030	N/A	40S
BUTT WELD	5	6"	030	ALA-6	160
LONG SEAM WELD	0	N/A	N/A	N/A	N/A
SOCKET WELD	0	N/A	N/A	N/A	N/A
WELDED SUPP.	3	N/A	028	N/A	N/A
COMP. SUPPORT	9	N/A	037	N/A	N/A

LINE NUMBER: Q-1-E11-ECB-2; Q-1-E21-CCB-27
Q-1-E11-ECB-28; Q-1-E11-CCB-29

BOUNDARY DIAGRAM D-351115 SH. 1 & 2

LINE SIZE: 10" ECB-2; 10" CCB-29
10" ECB-28; 8" ECB-28; 6" CCB-27; 10" CCB-27

REFERENCE ISO'S
D-514517 SH. 1
D-514518 SH. 1
D-514715 SH. 1

2	3-26-98	RAW	JAR	REVISED PER REA 96-1295, REV. 0	LDT	DLG	REV		
0	6-30-92	SDH	JAR	ISSUED PER PCN S-92-1-8162.	CAB	CCM/VRH	AH	DML	
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for

E11-RESIDUAL HEAT REMOVAL

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

112

2

CAD ALA24514
AUTOCAD RAV-03

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4514-SI-R86	WO/WA/STP N/A	Sheet No. S00F1V019
Hanger Type ONE DIRECTIONAL RESTRAINT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO Sig. <i>Paul D'Valerio</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable/ Unacceptable Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments: PLANT IN MODE 6 AT EXAM TIME			

Dan Corda L/III 3-14-00

ANTI REVIEW: Cgk and 3/16/00

Revision 3

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4514-SI-R88	WOWA/STP N/A	Sheet No. S00F1V018
Hanger Type SWAY STRUT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO Sig. <i>Paul D'Valerio</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.			
Acceptable			
Missing, detached, or loosened support items.			
Acceptable			
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.			
N/A			
Improper hot or cold positions.			
Any crack or linear indication.			
Acceptable			
Fluid loss or lack of fluid induction (hydraulic snubber only).			
N/A			
Other Conditions:		N/A	
Comments: PLANT IN MODE 6 AT EXAM TIME			
<i>Paul Cordes LTH 3-14-00</i>		<i>ANTI REVIEW: CgWand 3/16/00</i>	

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4517-RHR8-R51	WOWA/STP N/A	Sheet No. S00F1V021
Hanger Type TWO DIRECTIONAL RESTRAINT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial SCOTT R. ERICKSON Sig. <i>Scott R. Erickson</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable/ Unacceptable Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	Acceptable		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments:			
<i>Donny Cordis LIII 3-15-00</i>		<i>ANTI REVIEW: C9Wand 3/19/00</i>	

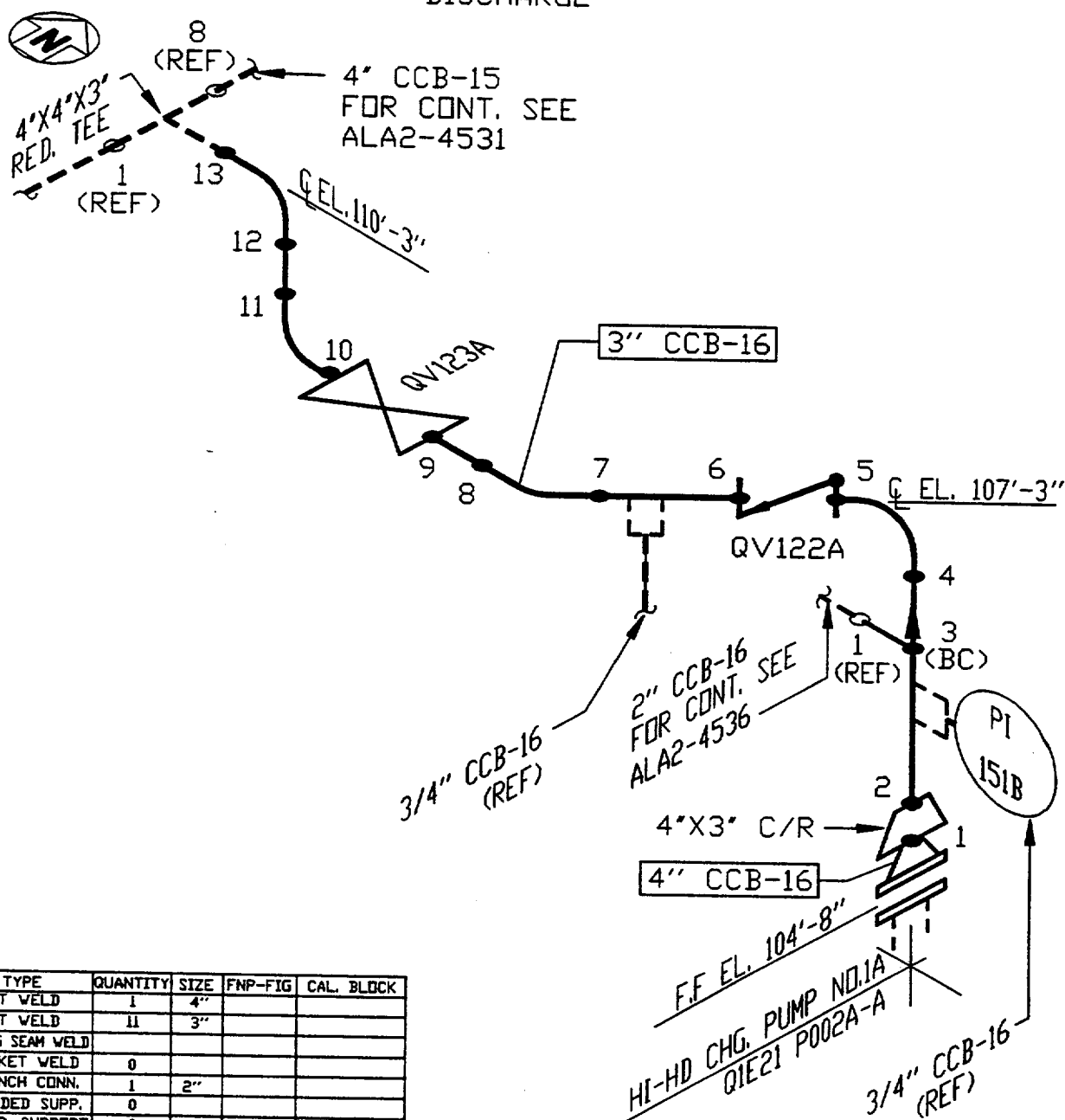
DRAWING ALA2-4523
HHSI CHARGING PUMP 1A DISCHARGE

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 181

HIGH HEAD SAFETY INJECTION CHARGING 1A DISCHARGE

ALA2-4523



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	1	4"		
BUTT WELD	11	3"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	1	2"		
WELDED SUPP.	0			
COMP. SUPPORT	0			

LINE NUMBER: Q-1-E21-CCB-16

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S D-514373 SH. 1

LINE SIZE: 3" CCB-16
4" CCB-16

0 3-26-98 HSK JAR ISSUED PER REA 96-1295 REV.0

LDT

DLG FOR DEV

APPR.1

APPR.2

APPR.3

APPR.4

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

148

0

CAD LA24523
AUTOCAD JLB-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4523-1	Date 3/22/00	Sheet No. S00F1U158	Page 1 of 3
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38193 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-7	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.531"								
Ax. dB	40.4	Circ. dB	49	Size	.25								
Ref.	40.4	Frequency/Mode	5 / S	Cal. Temp.	74°								
Scan	52	"A" Dimension	0.2"	Cal. In	0925								
Reject	OFF	Nominal Angle	45	Cal. Chk.	1100	3T	30	6.0	1.5				
Frequency	5.0	Measured Angle	45	Cal. Out	1146	4T	15	8.0	2.0				
Mode	P/E	Cable Type	RG174	Ref. Blk. No.	4978	Calibration Remarks: NONE							
Damping	500 OHMS	Cable Length	15'	Reflector	HOLE								
		Amplitude/Sweep	40%/2.7										

Comp. Temp.: **78** °F Configuration: **FLANGE TO REDUCER** Wo Location **WELD CL** Lo Location **OR ELBOW**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"< --	C/L	-- >1"	
2	●			N/A														
7	●			N/A														
8	●			N/A														

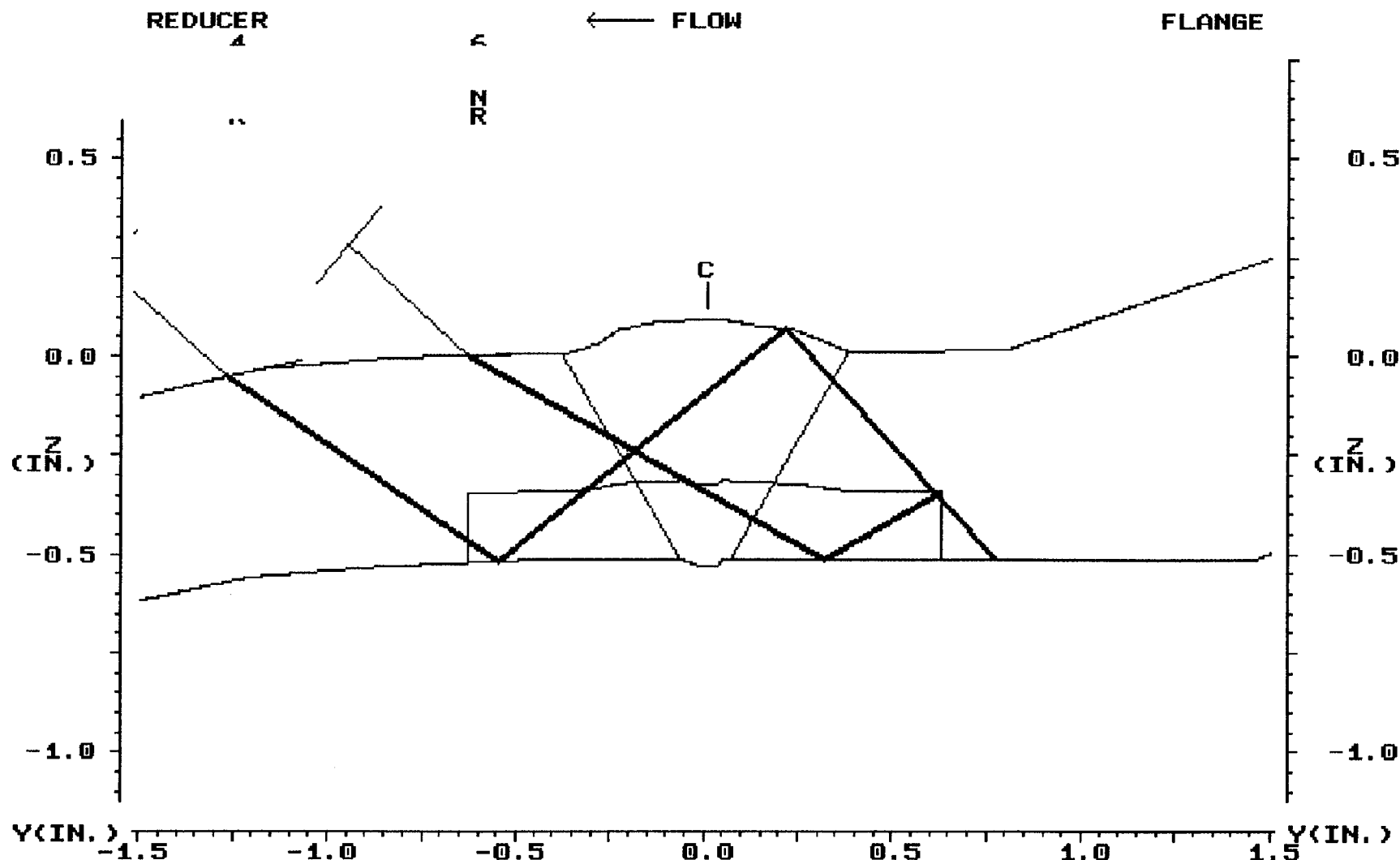
Examination/Limitation Remarks: **(1) FLANGE CONFIG RESTRICTS 5 SCAN.**

BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.

Total Length of Weld 14.75"	Crown Width 0.75"	Total Length of Weld Examined 5 (L) (1) 2 (L) NL 7 & 8 (W) NL				Extent of Perpendicular Scans (W) 5 - from (1) to (1) 2 - from NL to NL				Extent of Parallel Scans (L) From (5) NL to (2) NL			
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>				Date 3-23-00	
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-24-00	Percentage of Code Coverage 96 %				REF S00F1U159	ANII Review <i>[Signature]</i>				Date 3/27/00	

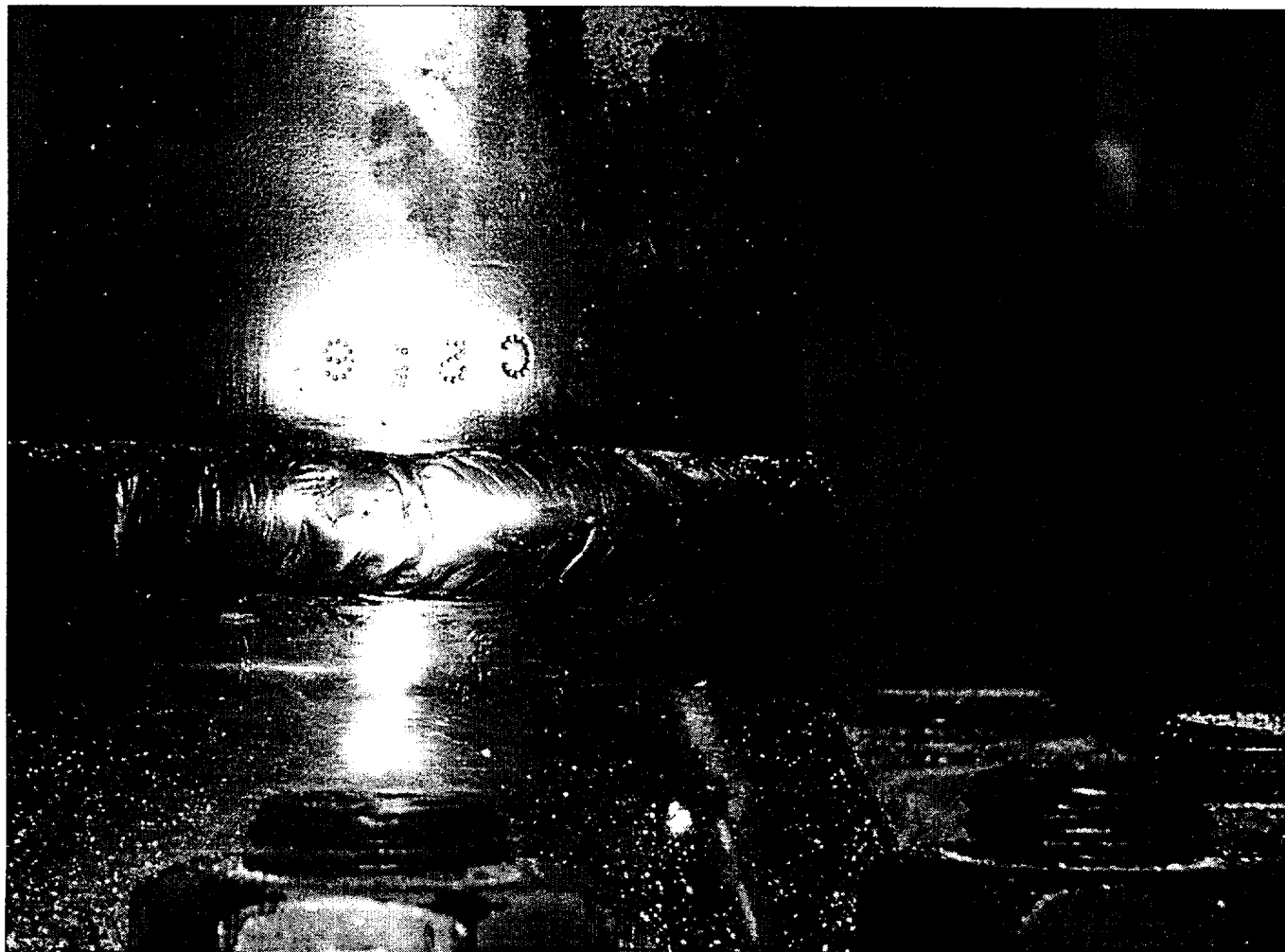
Figure 1

Revision 7



45 FR	SET	1R16015.DAT	1R16015A.SCR	60 NR	SET
1.86	DEP			0.71	DEP
2.63	MP	ASME CODE COVERAGE PLOT		1.42	MP
50.10	TOF			30.80	TOF
	ARC	45/60 2/5 SCANS - 93% (3T - 87% 5 / 100% 2)			ARC
	GATE	45 7/8 SCANS - 100%			GATE
0.050	STEP	COMPOSITE - 96%	DR CORDES L/III	0.050	STEP
	EXIT	MAKERAY/UTILITY	LEFT		EXIT
			RIGHT		
			TOP		
			PRINT		
			EXIT		

PLANT: FARLEY 1 3/24/00 CIRC. POS.: TYP
SYSTEM: HHSI ANALYST: D.R. CORDES
COMPONENT: ALA2-4523-1 8:51 CAL. SHEET: S00F1U158



Name: ala2-4523-1b.jpg
Dimensions: 1024 x 768 pixels

SHARED

FNP-0-NDE-100.31

1 ALA2-4523-1

Date
3/22/00

Sheet No.
S00F1U159

Page 1 of 1

Couplant/Batch No.

Thermometer SN/Cal Due Date

Linearity Sheet No.

FNP-0-NDE-100.31 / 7 / N/A

SONOTRACE 40 / 94243

38193 / 8/27/2000

S00F1L007

[illegible]

Examination/Limitation Remarks: (1) FLANGE CONFIG RESTRICTS 5 SCAN.

Total Length of Weld	Crown Width	Total Length of Weld Examined					Extent of Perpendicular Scans (W)					Extent of Parallel Scans (L)								
14.75"	0.75"	5 (L)	(1)	2 (L)	NL	7 & 8 (W)	N/A	5 - from	(1)	to	(1)	2 - from	NL	to	NL	From (5)	N/A	to	(2)	N/A
Primary Examiner					Level		Assistant Examiner					Level		Non-Technical Review					Date	
GEORGE A. MORINI					II		N/A					N/A		[Signature]					3-23-00	
SNC NDE Level II/III Review					Date		Percentage of Code Coverage					ANII Review		Date						
[Signature]					3-24-00		REF 500FIU158 %					[Signature]					4/21/00			

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4523-1		Sheet Number S00F1U150		Date 3/22/00
ISO/Drawing Number ALA2-4523		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136-898K	
Examiner JOHN W. BELL	SNT Level II		Search Unit Manufacturer KBA	Size .25	
Examiner N/A	SNT Level N/A		Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow FLANGE TO REDUCER	
Location OR UPPER EL		WMAX		WELD CL	
		68°		PTC 38081	

REDUCER

FLOW

WELD EDGE

WELD Q

FLANGE

COMPONENT

COMPONENT

75"

75

.68

.52

.52

T. MEASUREMENTS

O.D. PROFILE

T. MEASUREMENT EACH IN.

REMARKS:

NDE I/II/III Review <i>Dan Corda</i>	Level III	Date 3-23-00	Non-Technical Review <i>J. Eric Plycock</i>	Date 3-23-00

Revision 1

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4523-1	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P030	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration FLANGE TO REDUCER		% of Length Coverage 100%	Date 3/22/00	
Ind. No. N/A		Results NI	Indication Desc. / Exam Limitations / etc. N/A	
		Remarks NONE		

Remarks: **NONE**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. Eric Glycock</i>	Date 3-25-00
SNCNDE Level II/III Review <i>Dany Corda L/III</i>		Date 3-25-00	Percentage of Code Coverage 100 %	ANII Review <i>L. G. Ward</i>		Date 3/27/00	

Figure 1

Revision 6

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4523-5** Date **3/22/00** Sheet No. **S00F1U160** Page **1** of **3**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38193 / 8/27/2000** Linearity Sheet No. **S00F1L002**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.438"	1T	80	2.0	0.40	1T	70	2.00	0.60
Ax. dB	43.00	Size	.25	Cal. Temp.	74°	2T	40	4.0	0.80	2T	80	4.00	1.10
Ref.	40.4	Frequency/Mode	5 / S	Cal. In	0933	3T	30	6.0	1.20				
Scan	52.4	"A" Dimension	0.2"	Cal. Chk.	N/A	4T	15	8.0	1.60				
Reject	OFF	Nominal Angle	45	Cal. Out	1149	Calibration Remarks:							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	49786								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	15%/3.2								

Comp. Temp.: **78°** °F Configuration: **ELBOW TO VALVE** Wo Location **WELD CL** Lo Location **TDC**

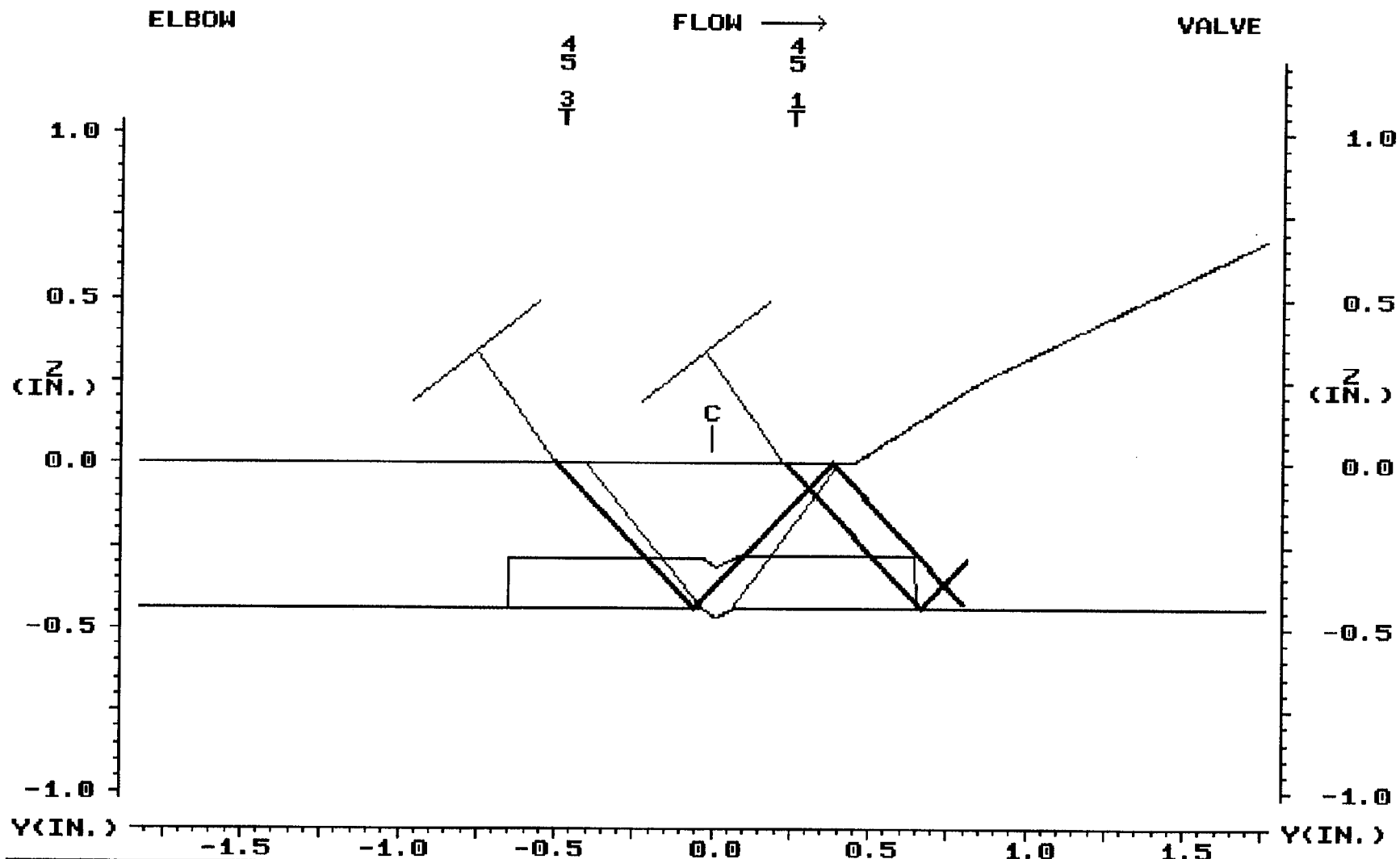
Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax	L2	Reference Measurement W1 Wmax W2	S1	Sweep Position Smax	S2	Thickness 1" <-- C/L -- > 1"	Notes:
5	● ○ ○	N/A										
7	● ○ ○	N/A										
8	● ○ ○	N/A										

Examination/Limitation Remarks: (1) VALVE CONFIG RESTRICTS 2 SCAN.
 BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)		Extent of Parallel Scans (L)	
11.5"	0.8"	5 (L) NL 2 (L) (1) 7 & 8 (W) NL	5 - from NL to NL	2 - from (1) to (1)	From (5) NL to (2) NL		
Primary Examiner	Level	Assistant Examiner	Level	Non-Technical Review	Date		
GEORGE A. MORINI	II	N/A	N/A	<i>Samuel Sifakis</i>	3-23-00		
SNC NDE Level II/III Review	Date	Percentage of Code Coverage	ANII Review	Date			
<i>Samuel Sifakis</i>	3-24-00	86 %	<i>EG and</i>	3/30/00			

Figure 1

Revision 7



45 1T	SET	1R16017.DAT	1R16017A.SCR	45 3T	SET
0.58	DEP	ASME CODE COVERAGE PLOT		1.30	DEP
0.82	MP			1.84	MP
21.10	TOF			37.45	TOF
	ARC				ARC
	GATE				GATE
0.050	STEP			0.050	STEP
	EXIT				EXIT
		2/5 DIR - 100% (3T)			
		7/8 DIR - 72% (ELBOW & WELD)			
		COMPOSITE - 86%	DR CORDES L/III		
		MAKERAY/UTILITY	LEFT		
		RIGHT	TOP		
		PRINT	EXIT		
PLANT: FARLEY 1		3/24/00	CIRC. POS.: TYP		
SYSTEM: HHSI		10:44	ANALYST: DR CORDES		
COMPONENT: ALA2-4523-5			CAL. SHEET: S00F1U160		

ALA2-4523-6

500F10160
3 of 3



Name: ala2-4523-45.jpg
Dimensions: 1024 x 768 pixels

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.
1	ALA2-4523-5	3/22/00	S00F1U161
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38193 / 8/27/2000	s00f1I007

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	009R2K	Thickness	.438"	1T	80	4.0	0.55				
Ax. dB	43.00	Size	.25	Cal. Temp.	74°	2T	20	8.0	1.10				
Ref.	51.8	Frequency/Mode	5 / S	Cal. In	0940	Calibration Remarks: NONE							
Scan	63.8	"A" Dimension	0.2"	Cal. Chk.	N/A								
Reject	OFF	Nominal Angle	60	Cal. Out	1150								
Frequency	5.0	Measured Angle	60	Ref. Blk. No.	4978								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	20%/7.1								

Comp. Temp.: 78° °F Configuration: ELBOW TO VALVE

Wo Location WELD CL Lo Location TDC

Scan Dir.	Results	Ind. No.	% DAC	L1	Length	Reference Measurement	Sweep Position	Thickness	Notes:
	NI NRI RI				Lmax L2	W1 Wmax W2	S1 Smax S2	1" < -- C/L -- > 1"	
5	●								

Examination/Limitation Remarks: (1) VALVE CONFIG RESTRICTS 2 SCAN.

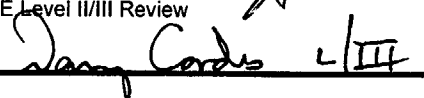
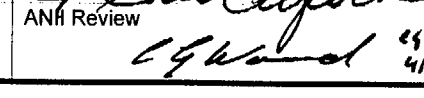
Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
11.5"	0.8"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	N/A	5 - from	NL	to	NL	2 - from	(1)	to	(1)	From (5)	N/A	to	(2)	N/A
Primary Examiner		Level		Assistant Examiner				Level		Non-Technical Review				Date						
GEORGE A. MORINI		II		N/A				N/A						3-23-00						
SNC NDE Level II/III Review		Date		Percentage of Code Coverage				SEE		ANR Review				Date						
		3-24-00		500F1U160				%						3/30/00						

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4523-5	Sheet Number S00F1U149	Date 3/22/00		
ISO/Drawing Number ALA2-4523	Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY		
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136-898K		
Examiner JOHN W. BELL	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A			
		Component Configuration/Flow ELBOW TO VALVE			
Location LMAX	TDC	WMAX	WELD CL	Component Temp °F 78°	Thermometer S/N PTC 38081

ELBOW FLOW VALVE

1.8"

WELD Q

T. MEASUREMENTS

O.D. PROFILE

.44" .44" .44" .45"

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Dan Cords</i>	Level III	Date 3-23-00	Non-Technical Review <i>J. Eric Oyeck</i>	Date 3-23-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4523-5	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P029	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 78 °F Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Batch 98A10K 93D12K 96J08K				
Component Configuration ELBOW TO VALVE			% of Length Coverage 100% % of Area Coverage 100%	Date 3/22/00
Ind. No. N/A	Results RI	Indication Desc. / Exam Limitations / etc. 3/32" ROUNDED .49" FROM TOE ON VALVE BODY @ 90°CW FROM TDC.		Remarks NONE

Remarks:

NONE *QAC*
3-27-00 *CODE ACCEPTABLE SURFACE INDICATION. SEE IER 1R16 010. QAC 3-27-00*

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>QDF</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Samuel Hoffer</i>	Date 3-30-00
SNC/NDE Level II/III Review <i>Samuel Cordes LTH</i>			Date 3-24-00	Percentage of Code Coverage 100 %	ANII Review <i>QAC</i>		Date 3/30/00

Figure 1

Revision 6

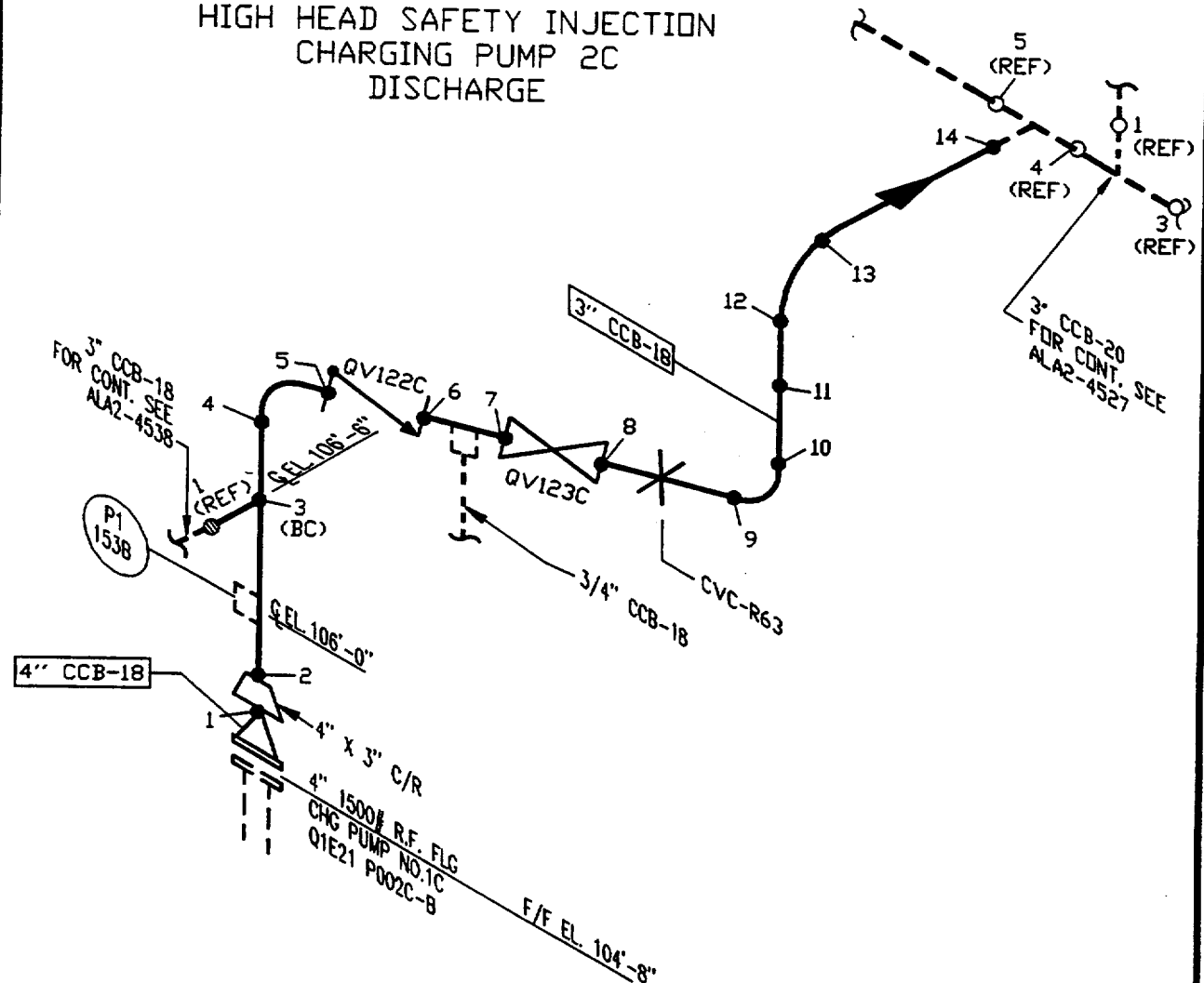
[illegible]

AUXILIARY
EL. 100'-0"
ROOM 173

ALA2-4526



HIGH HEAD SAFETY INJECTION
CHARGING PUMP 2C
DISCHARGE



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	12	3"		
BUTT WELD	1	4"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	1	2"		
WELDED SUPP.	0	N/A		
COMP. SUPPORT	1	N/A		

LINE NUMBER: Q-1-E21-CCB-18

BOUNDARY DIAGRAM	D-351116 SH. 6

REFERENCE ISO'S	D-514370 SH. 1

LINE SIZE: 3" CCB-18
4" CCB-18

0	3-26-98	BFB	JAR	ISSUED PER REA 96-1295 REV. 0.

LDT	DLG FOR DEW		
APPR.1	APPR.2	APPR.3	APPR.4

DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4
Southern Company Services, Inc. for E21-HIGH HEAD SAFETY INJECTION SYS.				

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET	REV.

A-351192

151	0

0

CAD	LA24526
AUTOCAD	JLB-01

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4526-3BC	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P026	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 72 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration BRANCH CONNECTION		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/21/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks NONE

Remarks: **NONE**

Primary Examiner GEORGE A. MORINI	ASNT Level II	Initials <i>GM</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>David Cordis</i>	Date 3-23-00
SNC NDE Level II/III Review <i>David H. Hoffman</i>		Date 3-22-00	Percentage of Code Coverage 100 %	ANII Review <i>CFH</i>		Date 3/25/00	

Figure 1

Revision 6

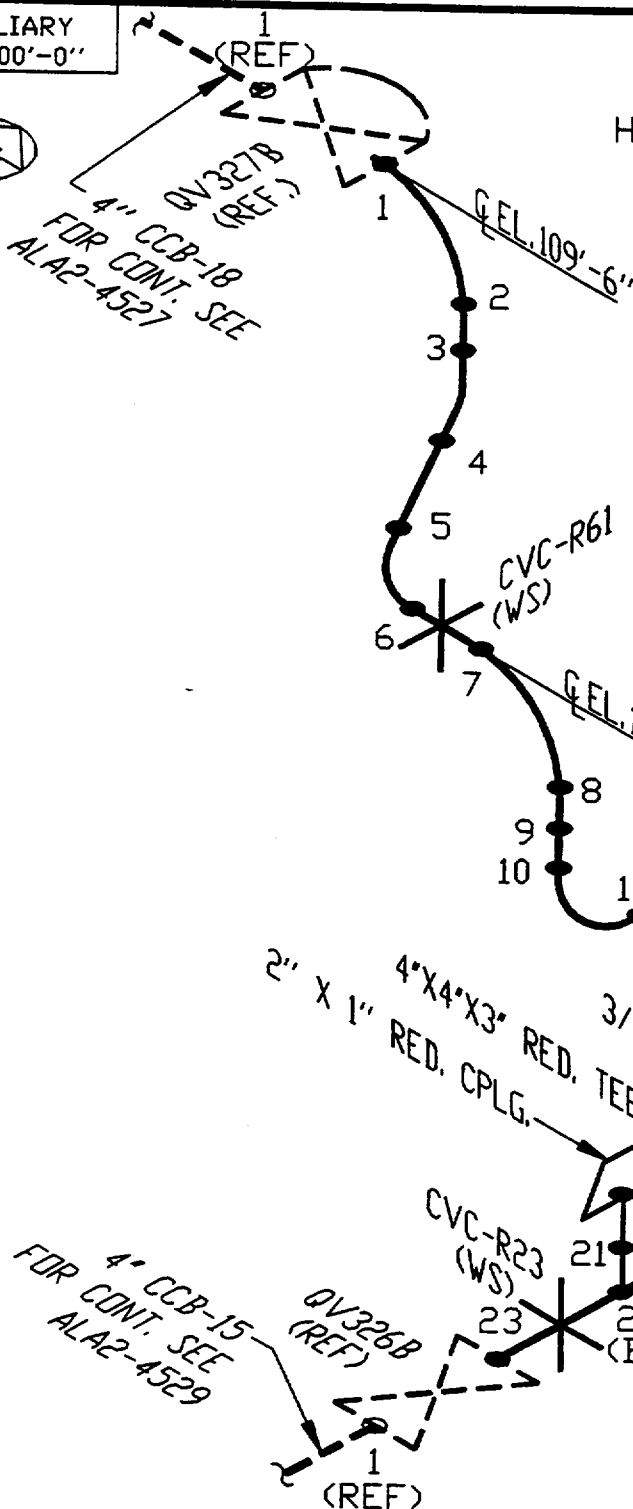
[illegible]

AUXILIARY
EL. 100'-0"

ALA2-4528

HIGH HEAD SAFETY INJECTION
CHARGING PUMPS
DISCHARGE

4" CCB-18
FOR CONT. SEE
ALA2-4527



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	20	4"		
LONG SEAM WELD				
SOCKET WELD	2	2"		
BRANCH CONN.	1	2"		
WELDED SUPP.	3	N/A		
COMP. SUPPORT	3	N/A		

LINE NUMBER: Q-1-E21-CCB-15

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S D-514371 SH. 1

LINE SIZE: 4" CCB-15

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0
REV.	DATE	BY	CHK'D	DESCRIPTION

LDT

DLG

REV

APPR.1

APPR.2

APPR.3

APPR.4

Southern Company Services, Inc. for E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

153

0

CAD LA24528
AUTOCAD JLB-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4528-17	Date 3/17/00	Sheet No. S00F1U077	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L005	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-7	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	009R2K	Thickness	.531"	1T	80	2	.5	1T	80	2	.6
Ax. dB		Size	.25	Cal. Temp.	72	2T	30	4	1.00	2T	40	4	1.2
Ref.	33.6	Frequency/Mode	5 / S	Cal. In	0830	3T	18	6	1.5				
Scan	45.6	"A" Dimension	.2	Cal. Chk.	NA	4T	17	8	2.00				
Reject	OFF	Nominal Angle	45	Cal. Out	1232	Calibration Remarks: NONE							
Frequency	2.25	Measured Angle	45	Ref. Blk. No.	NA								
Mode	P/E	Cable Type	RG174	Reflector	NA								
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	NA								

Comp. Temp.: **78** °F Configuration: **VALVE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
7	●			N/A														
8	●			N/A														

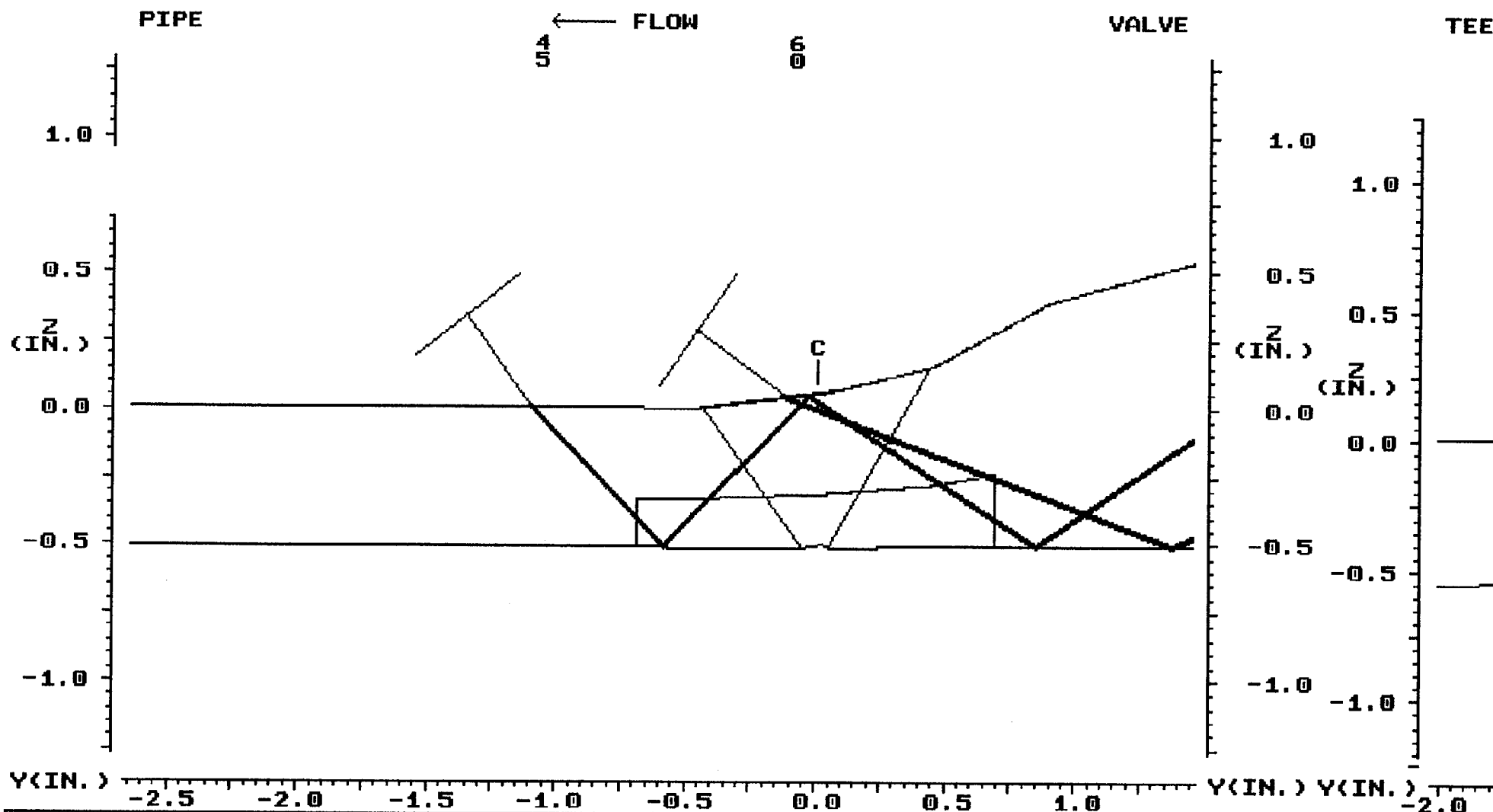
Examination/Limitation Remarks:

VALVE RESTRICTS 5 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
14.85"	.875"	5 (L) NA	2 (L) NL	7 & 8 (W) NL	5 - from NA to NA	2 - from NL to NL	From (5) NL to (2) NL					
Primary Examiner GEORGE A. MORINI		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-20-00		
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-20-00	Percentage of Code Coverage 86 %			ANI Review <i>[Signature]</i>			Date 3/23/00			

Figure 1

Revision 7



45	SET	1R16011.DAT	1R16011A.SCR	60	SET	45	SE
1.27	DEP	ASME CODE COVERAGE				1.50	DE
1.79	MP	2/5 SCANS - 100% (3T - 75% 5 / 75% 2) 7/8 SCANS - 73% (TEE AND WELD) COMPOSITE - 86% RELIEF REQUIRED DR CORDES L/III				2.12	MP
36.65	TOF					41.85	TO
	ARC						AR
	GATE						GA
0.050	STEP					0.050	ST
	EXIT	MAKERAY	UTILITY	LEFT	RIGHT		EX
				TOP	PRINT		
PLANT: FARLEY 1		3/20/00		CIRC. POS.: TYP		PLANT:	
SYSTEM: RHR				ANALYST: DR CORDES		SYSTEM:	
COMPONENT: ALA2-4528-17				CAL. SHEET: SQ. OF 10077 & 078		COMPONENT:	

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

SHARED

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit **1** Sketch/Component No. **ALA2-4528-17** Date **3/17/00** Sheet No. **S00F1U078** Page **1** of **1**
 Procedure/Rev./TCN **FNP-0-NDE-100.31 / 7 / N/A** Couplant/Batch No. **SONOTRACE 40 / 94243** Thermometer SN/Cal Due Date **38081 / 8/27/2000** Linearity Sheet No. **S00F1L005**

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-7	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136-911K	Serial No.	00B2J2	Thickness	.531"	1T	80	4.0	.7				
Ax. dB	47.4	Circ. dB	NA	Cal. Temp.	72	2T	50	8.0	1.4				
Ref.	59.2	Size	.25	Cal. In	0835								
Scan	OFF	Frequency/Mode	5 / S	Cal. Chk.	NA								
Reject	NA	"A" Dimension	.2	Cal. Out	1235								
Frequency	5	Nominal Angle	60	Ref. Blk. No.	NA	Calibration Remarks: SUPPLEMENTAL EXAM							
Mode	P/E	Measured Angle	60	Reflector	NA								
Damping	500 OHMS	Cable Type	RG174	Amplitude/Sweep	NA								
		Cable Length	45'										

Comp. Temp.: **78** °F Configuration: **VALVE TO PIPE** Wo Location **C/L** Lo Location **TDC**

Scan Dir.	Results NI NRI RI	Ind. No.	% DAC	L1	Length Lmax L2	Reference Measurement W1 Wmax W2	Sweep Position S1 Smax S2	Thickness 1" < -- C/L -- > 1"	Notes:
2	● ○ ○	N/A							

Examination/Limitation Remarks:

VALVE RESTRICTS 5 SCAN. LAM SCAN PERFORMED IN AREA OF ANGLE BEAM EXAM PER PROCEDURE WITH TRANSDUCER # 00B5RV.

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
14.85"	.875"	5 (L) NA	2 (L) NL	7 & 8 (W) NA	5 - from NA to NA	2 - from NL to NL	From (5) NA to (2) NA						
Primary Examiner GEORGE A. MORINI	Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>J. Eric Olyock</i>		Date 3-20-00				
SNC NDE Level II/III Review <i>Wang</i>	Date 3-20-00	Percentage of Code Coverage SEE S00F1U077 %				ANI Review <i>egh</i>		Date 3/23/00					

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4528-17		Sheet Number S00F1U079		Date 3/17/00
ISO/Drawing Number ALA2-4528		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136-911K	
Examiner GEORGE A. MORINI <i>[Signature]</i>		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow VALVE TO PIPE	
Location LMAX TDC WMAX C/L			Component Temp °F Thermometer S/N 78 PTC 38081		
<i>PIPE</i> COMPONENT WELD EDGE WELD EDGE COMPONENT <i>VALVE</i>					
T. MEASUREMENTS					
O.D. PROFILE <i>.51" .51" .51" .51" .62" .72" .72"</i>					
T. MEASUREMENT EACH IN.					
REMARKS:					
NDE LII/III Review <i>[Signature]</i>		Level Date <i>III 3-20-00</i>		Non-Technical Review <i>Lynda Duke</i>	
				Date 3-18-00	

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4528-17	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P020	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration VALVE TO PIPE		% of Length Coverage 100	Date 3/18/00	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks: **N/A**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>awk</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. Erwin Quynck</i>	Date 3-20-00
SNC NDE Level II/III Review <i>Dan Gordon L/III</i>		Date 3-20-00	Percentage of Code Coverage 100 %	ANII Review <i>CG Ward</i>		Date 3/23/00	

Figure 1

Revision 6

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2
SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4528-CVC-A14	WOWA/STP N/A	Sheet No. S00F1V022
Hanger Type ANCHOR	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL DiVALERIO Sig. <i>Paul DiValerio</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable/Unacceptable Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments:			
<i>Dan Corda L III 3-14-00</i>			
<i>ANTI REVIEW: C. G. W. 3/14/00</i>			

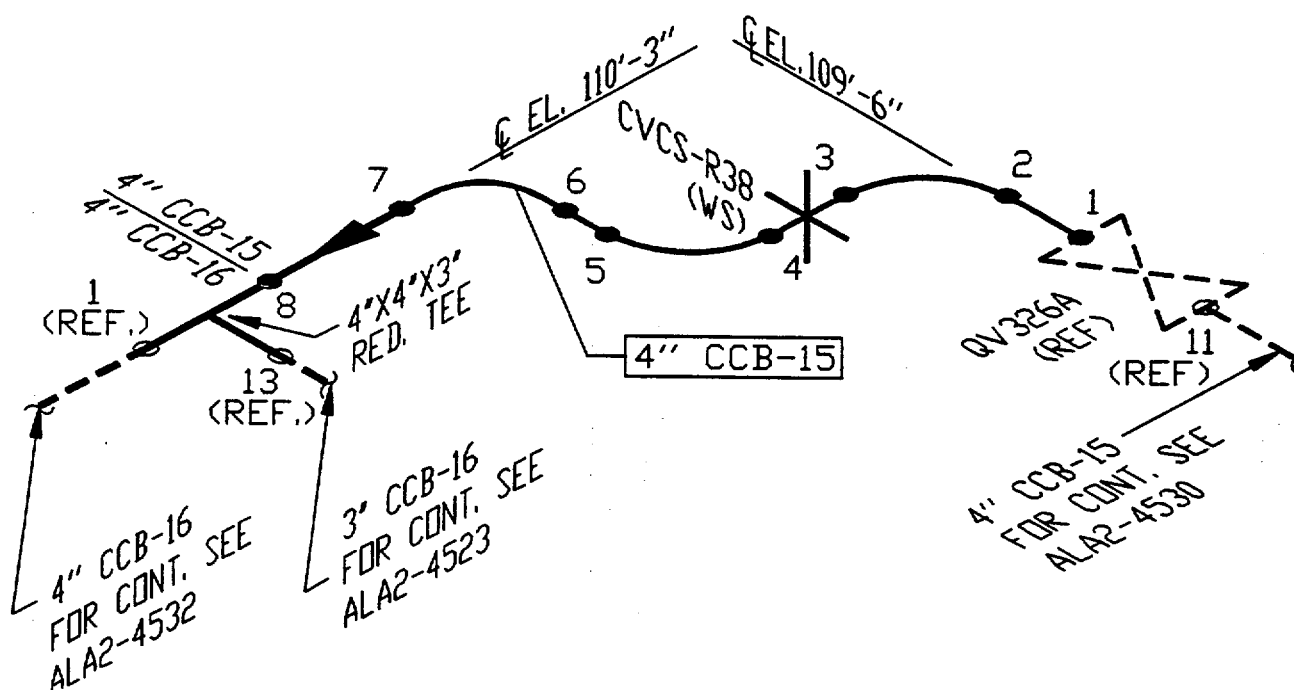
Revision 3

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 181

HIGH HEAD SAFETY INJECTION CHARGING PUMPS DISCHARGE

ALA2-4531



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	8	4"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	0			
WELDED SUPP.	1	N/A		
COMP. SUPPORT	1	N/A		

LINE NUMBER: Q-1-E21-CCB-15
Q-1-E21-CCB-16

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S D-514373 SH. 1

LINE SIZE: 4" CCB-15
4" CCB-16

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	DEF		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

156

0

CAD LA24531
AUTOCAD JLB-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4531-8	Date 3/22/00	Sheet No. S00F1U156	Page of 3
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38193 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-7	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.531"								
Ax. dB	<i>43.00</i>	Size	.25	Cal. Temp.	74°								
Ref.	40.4	Frequency/Mode	5 / S	Cal. In	0925								
Scan	52	"A" Dimension	0.2"	Cal. Chk.	1050	1T	80	2.0	0.5	1T	80	2.1	0.6
Reject	OFF	Nominal Angle	45	Cal. Out	1146	2T	40	4.0	1.0	2T	60	4.2	1.2
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	49786 <i>4200</i>	3T	30	6.0	1.5				
Mode	P/E	Cable Type	RG174	Reflector	HOLE	4T	15	8.0	2.0				
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	40%/2.7	Calibration Remarks: NONE							

Comp. Temp.: **78°** °F Configuration: **PIPE TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: (1) TEE CONFIG RESTRICTS 2 SCAN AND CROWN LIMITS 7/8 SCANS.

BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.

Total Length of Weld 14.75"	Crown Width 0.75"	Total Length of Weld Examined 5 (L) NL 2 (L) (1) 7 & 8 (W) (1)				Extent of Perpendicular Scans (W) 5 - from .58" to NL				Extent of Parallel Scans (L) 2 - from (1) to (1) From (5) (1) to (2) (1)			
Primary Examiner GEORGE A. MORINI <i>George Morini</i>		Level II	Assistant Examiner N/A				Level N/A	Non-Technical Review <i>[Signature]</i>				Date 3-23-00	
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-24-00	Percentage of Code Coverage 57 %				ANII Review <i>[Signature]</i> 4/3/00				Date 3/27/00		

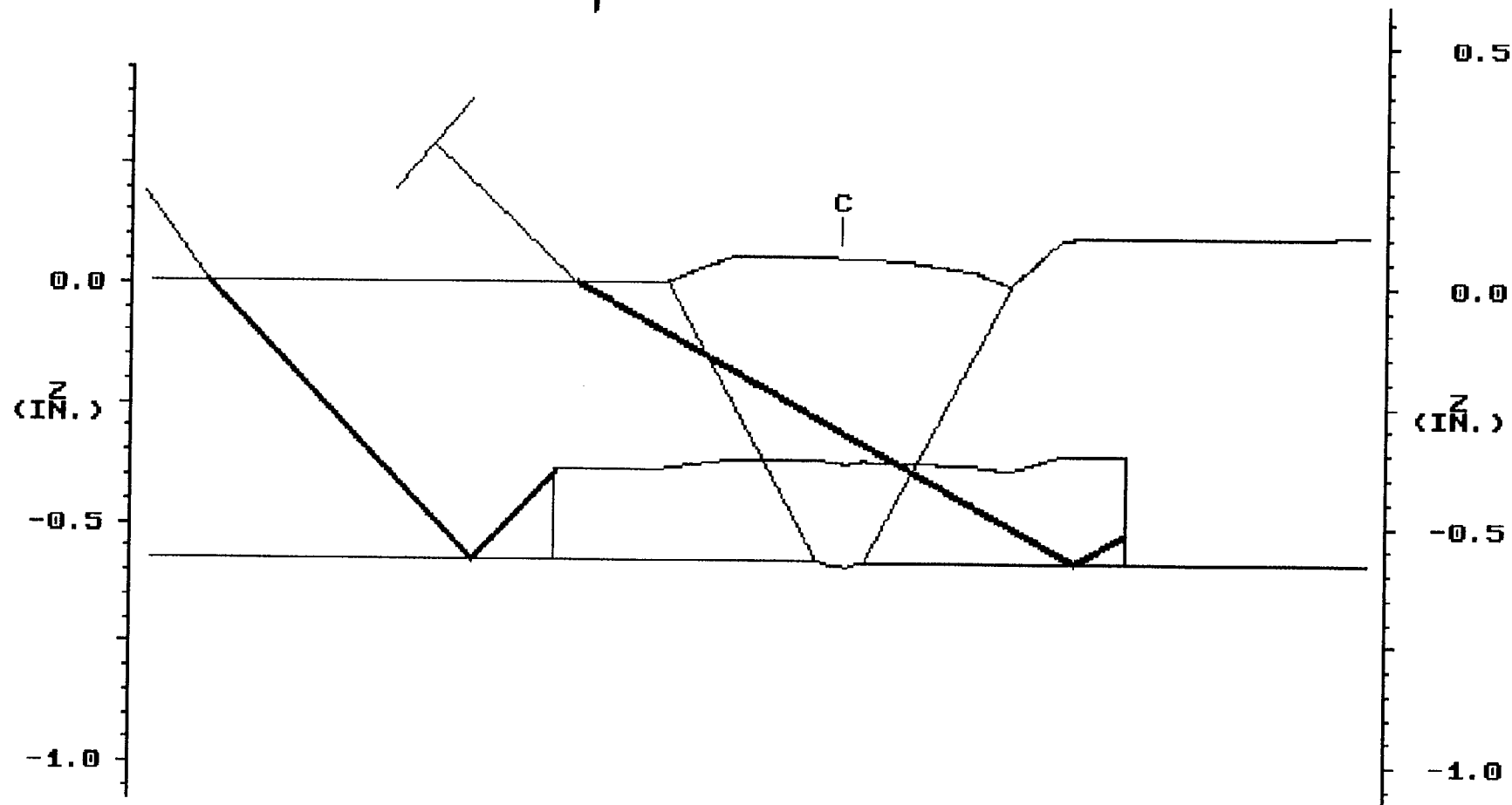
Figure 1

Revision 7

PIPE
4

← FLOW

TEE



Y (IN.) -1.5 -1.0 -0.5 0.0 0.5 1.0 Y (IN.)

45	SET	1R16016.DAT	1R6016A.SCR	60	SET
0.76	DEP			0.68	DEP
1.08	MP			1.37	MP
25.30	TOF			29.85	TOF
	ARC	ASME CODE COVERAGE PLOT			ARC
	GATE	2/5 DIR (NO 3T DUE TO CROWN CONFIG) 85% (75-2/95-5)			GATE
	STEP	7/8 DIR (PIPE ONLY DUE TO CROWN CONFIG) 29%			STEP
0.050	EXIT	COMPOSITE COVERAGE - 57% DR CORDES L/III			EXIT
	MAKERAY/UTILITY	LEFT	RIGHT	TOP	PRINT
					EXIT

PLANT: FARLEY 1
SYSTEM: HHSI
COMPONENT: ALA2-4534-8

3/24/00

CIRC. POS.: TYP

ANALYST: D.R. CORDES

CAL. SHEET: S00F10156

S00F10156 3003



Name: ala2-4531-8.jpg
Dimensions: 1024 x 768 pixels

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page	of
1	ALA2-4531-8	3/22/00	S00F1U157	1	1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.		
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38193 / 8/27/2000	S00F1L007		

Instrument			Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY		Transducer Mfg.	KBA	Cal. Blk. No.	ALA-7	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F		Serial No.	009R2K	Thickness	.531"								
Ax. dB	43 dB	Circ. dB	Size	.25	Cal. Temp.	74°								
Ref.	51.8	N/A	Frequency/Mode	5 / S	Cal. In	0945	1T	80	4.0	0.7				
Scan	63.8	N/A	"A" Dimension	0.2"	Cal. Chk.	1040	2T	20	8.0	1.4				
Reject	OFF		Nominal Angle	60	Cal. Out	1148								
Frequency	5.0		Measured Angle	60	Ref. Blk. No.	4978	Calibration Remarks: NONE							
Mode	P/E		Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS		Cable Length	15'	Amplitude/Sweep	15%/6.5								

Comp. Temp.: **78°** °F Configuration: **PIPE TO TEE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
5				N/A														

Examination/Limitation Remarks: (1) TEE CONFIG RESTRICTS 2 SCAN.

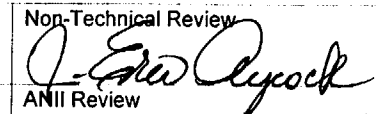
Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
14.75"	0.75"	5 (L)	NL	2 (L)	(1)	7 & 8 (W)	N/A	5 - from	.58"	to	NL	2 - from	(1)	to	(1)	From (5)	N/A	to	(2)	N/A
Primary Examiner		Level	Assistant Examiner				Level	Non-Technical Review				Date								
GEORGE A. MORINI		II	N/A				N/A					3-23-00								
SNC NDE Level II/III Review		Date	Percentage of Code Coverage				ANII Review				Date									
		3-24-00	SEE S00F1U156 %								3/27/00									

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4531-8	Sheet Number S00F1U151	Date 3/22/00		
ISO/Drawing Number ALA2-4531		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number <i>Box 440</i> 136K-472F		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO TEE		
Location LMAX TDC WMAX WELD CL			Component Temp °F Thermometer S/N		
			68° PTC 38081		
<u>PIPE</u> COMPONENT <u>WELD EDGE</u> <u>TEE</u> COMPONENT					
T. MEASUREMENTS					
O.D. PROFILE					
T. MEASUREMENT EACH IN.					
REMARKS:					
NDE LII/III Review <i>Dan Corda</i>		Level III	Date 3-23-00	Non-Technical Review <i>J. Eric Dyck</i>	
				Date 3-23-00	
Revision 1					

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4531-8	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P031	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO TEE		% of Length Coverage 100%	Date 3/22/00	
% of Area Coverage 100%				
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.		Remarks
N/A	NI	N/A		NONE

Remarks: **NONE**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JOFF</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Dany Cards</i>	Date 3-23-00
SNC NDE Level II/III Review <i>Joseph D. Funyak</i>		Date 3-23-00	Percentage of Code Coverage 100 %	ANII Review <i>CGW</i>		Date 3/27/00	

Figure 1

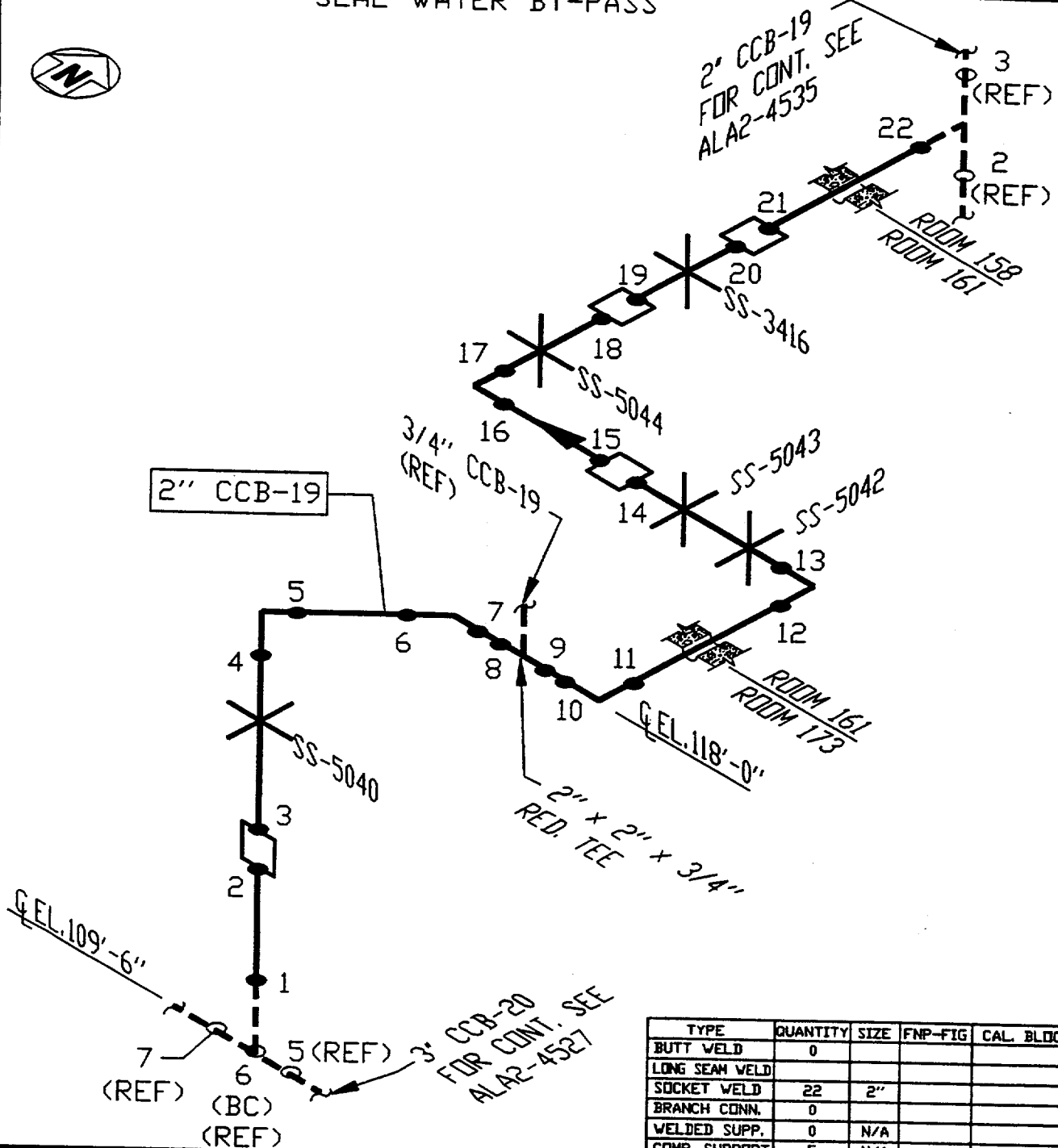
Revision 6

DRAWING ALA2-4534
HHSI SEAL WATER BY-PASS

[illegible]

AUXILIARY
EL. 100'-0"HIGH HEAD SAFETY INJECTION
SEAL WATER BY-PASS

ALA2-4534



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	0			
LONG SEAM WELD				
SOCKET WELD	22	2"		
BRANCH CONN.	0			
WELDED SUPP.	0	N/A		
COMP. SUPPORT	5	N/A		

LINE NUMBER: Q-1-E21-CCB-19

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S D-518117 SH. 2

LINE SIZE: 2" CCB-19

D-518070 SH. 2

REV.	DATE	BY	CHK'D	DESCRIPTION
0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0

LDT	DLG	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

159

0

CAD LA24534

JLB-01
AUTOCAD

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4534-1	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P027	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 72 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration BRANCH CONNECTION TO PIPE		% of Length Coverage 100%	Date 3/21/00	
Ind. No. N/A		Results NI	Indication Desc. / Exam Limitations / etc. N/A	
		Remarks NONE		

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Harry Cordes</i>	Date 3-23-00
SNC NDE Level II/III Review <i>Harry A. Kiehl</i>		Date 3-22-00	Percentage of Code Coverage 100 %	ANII Review <i>Edward</i>		Date 3/25/00	

Figure 1

Revision 6

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4534-5	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P035	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO PIPE		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/27/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks NONE

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials JWB	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review J. Eric Aycock	Date 3-29-00
SNC NDE Level II/III Review Wang Carlos L/III		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review cgward		Date 3/30/00	

Figure 1

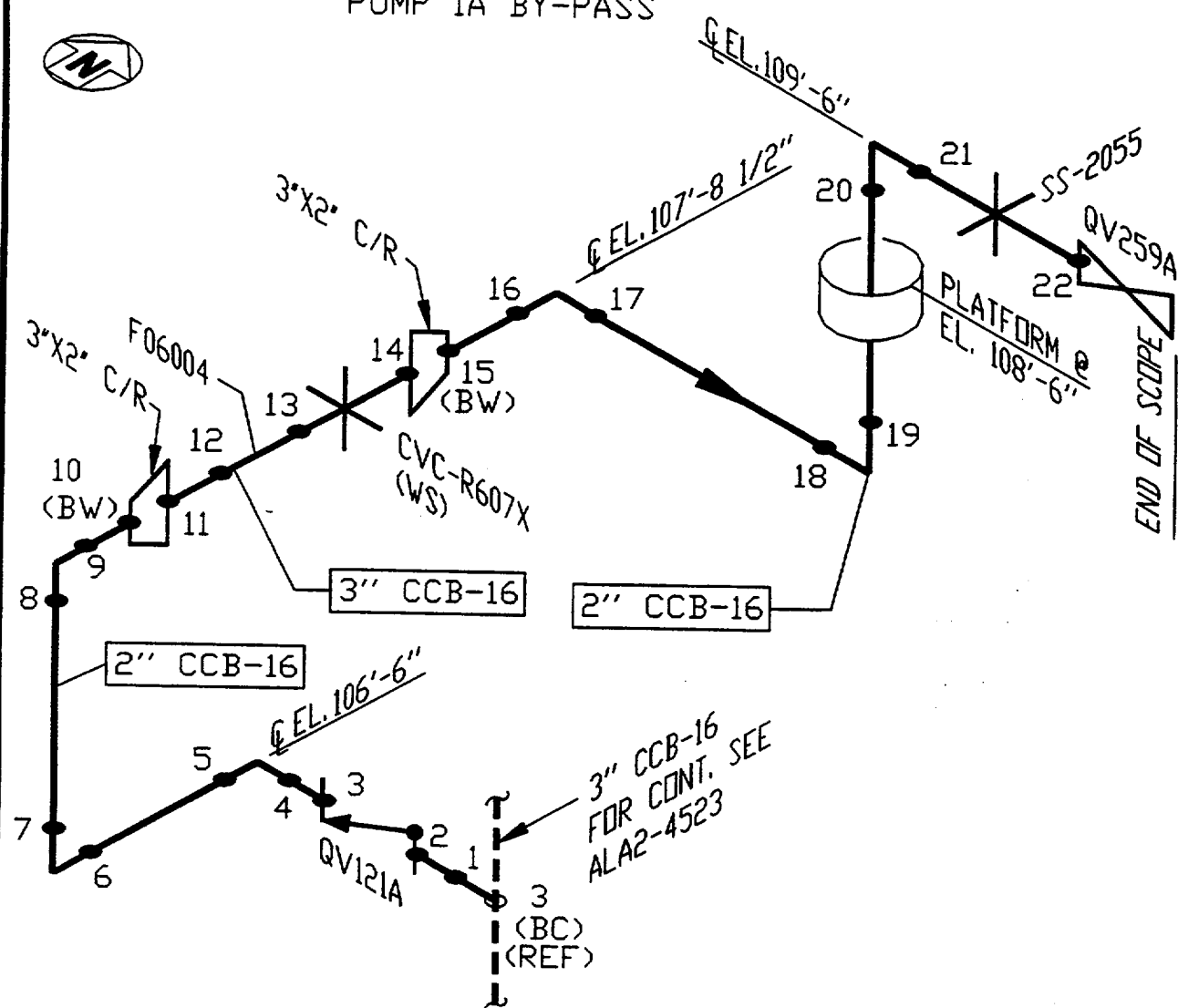
Revision 6

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 174

HIGH HEAD SAFETY INJECTION CHARGING PUMP 1A BY-PASS

ALA2-4536



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	4	3"		
BUTT WELD	2	2"		
LONG SEAM WELD				
SOCKET WELD	16	2"		
BRANCH CONN.				
WELDED SUPP.	1	N/A		
COMP. SUPPORT	2	N/A		

LINE NUMBER: Q-1-E21-CCB-16

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S D-518691 SH. 2

LINE SIZE: 3" CCB-16

D-514778 SH. 1

2" CCB-16

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

161

0

CAD LAR24536
AUTOCAD JLB-02

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4536-3	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P028	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration VALVE TO PIPE		% of Length Coverage 100%	Date 3/22/00	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks NONE

Remarks: **NONE**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>[Signature]</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>[Signature]</i>	Non-Technical Review <i>[Signature]</i>	Date 3-23-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-23-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/25/00	

Figure 1

Revision 6

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4536-17	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P036	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F <u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover Penetrant Developer Type SKC-S SKL-SP SKD-S2 Batch 98A10K 93D12K 96J08K				
Component Configuration ELBOW TO PIPE			% of Length Coverage 100% % of Area Coverage 100%	Date 3/27/00
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.	Remarks	
N/A	NI	N/A	NONE	

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>[Signature]</i>	Date 3-29-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/30/00	

Figure 1

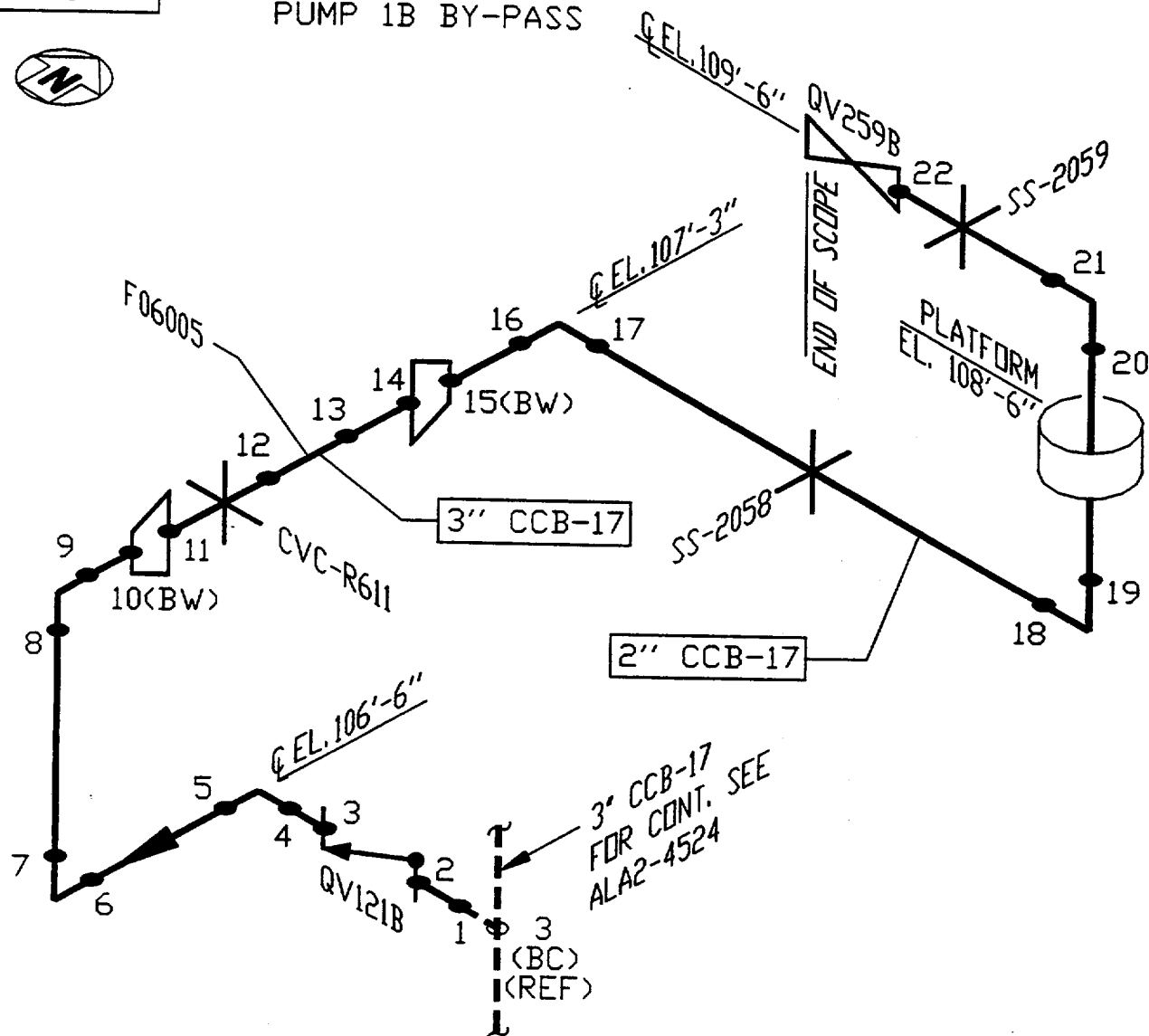
Revision 6

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 174

HIGH HEAD SAFETY INJECTION
CHARGING
PUMP 1B BY-PASS

ALA2-4537



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	4	3"		
BUTT WELD	2	2"		
LONG SEAM WELD				
SOCKET WELD	16	2"		
BRANCH CONN.	0			
WELDED SUPP.	0			
COMP. SUPPORT	3	N/A		

LINE NUMBER: Q-1-E21-CCB-17

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S	D-518690 SH. 2

D-514778 SH. 1

LINE SIZE: 3" CCB-17
2" CCB-17

0	3-26-98	HSH	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

162

0

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4537-18	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P037	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO ELBOW		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/27/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks NONE

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials gwb	Assistant Examiner N/A	ASNT Level N/A	Initials 	Non-Technical Review J. Eric Paycock	Date 3-29-00
SNC NDE Level II/III Review John Carter LIII		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review cgua		Date 3/30/00	

Figure 1

Revision 6

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4537-19	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P038	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO PIPE		% of Length Coverage 100%	Date 3/27/00	
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.		Remarks
N/A	NI	N/A		N/A

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>JWB</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. Eric Dyck</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Dan Corda LIII</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>EG</i>		Date 3/30/00	

Figure 1

Revision 6

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4537-CVC-R611	WOW/VA/STP N/A	Sheet No. S00F1V023
Hanger Type ONE DIRECTIONAL RESTRAINT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial SCOTT R. ERICKSON Sig. <i>Scott R. Erickson</i>	Level II	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments:			
<i>Long Cards L/TTL 3-15-00</i>		<i>ANTI REVIEW: C. G. Ward 3/17/00</i>	

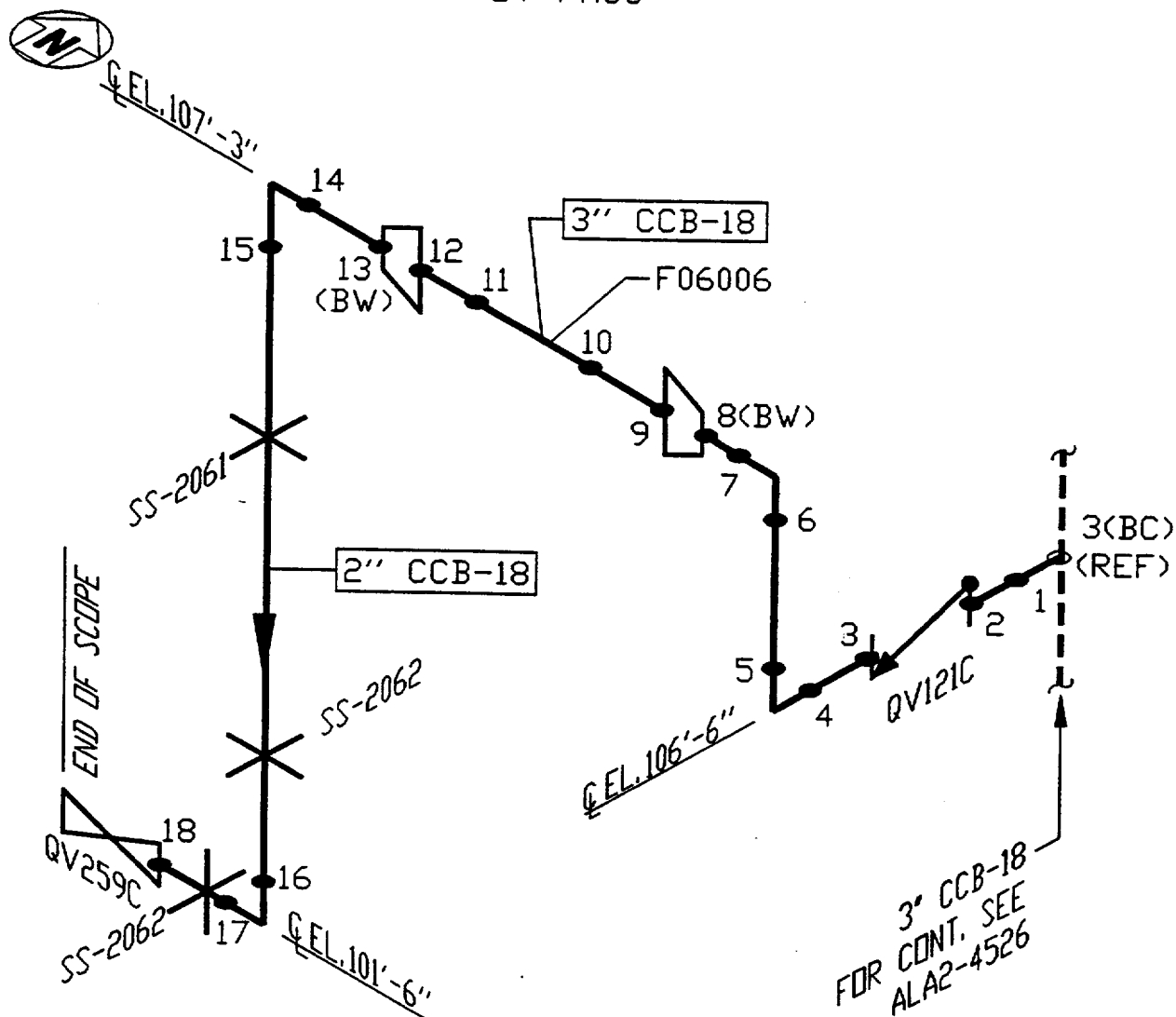
DRAWING ALA2-4538
HHSI CHARGING PUMP 1C BY-PASS

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 173

HIGH HEAD SAFETY INJECTION CHARGING PUMP 1C BY-PASS

ALA2-4538



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	4	3"		
BUTT WELD	2	2"		
LONG SEAM WELD				
SOCKET WELD	12	2"		
BRANCH CONN.				
WELDED SUPP.				
COMP. SUPPORT	2	N/A		

LINE NUMBER: Q-1-E21-CCB-18

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S D-518689 SH. 2

LINE SIZE: 3" CCB-18

D-514778 SH. 1

2" CCB-18

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	REV		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

163

0

CAD LA24538
AUTOCAD JLB-03

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4538-3	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P025	Page <u>1</u> of <u>1</u>									
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 72 °F		<u>Penetrant Materials</u> <table style="width: 100%;"> <tr> <td style="width: 33%;">Manufacturer MAGNAFLUX</td> <td style="width: 33%;">Cleaner/Remover SKC-S</td> <td style="width: 33%;">Batch 98A10K</td> </tr> <tr> <td>Penetrant SKL-SP</td> <td></td> <td>93D12K</td> </tr> <tr> <td>Developer SKD-S2</td> <td></td> <td>96J08K</td> </tr> </table>			Manufacturer MAGNAFLUX	Cleaner/Remover SKC-S	Batch 98A10K	Penetrant SKL-SP		93D12K	Developer SKD-S2		96J08K
Manufacturer MAGNAFLUX	Cleaner/Remover SKC-S	Batch 98A10K											
Penetrant SKL-SP		93D12K											
Developer SKD-S2		96J08K											
Component Configuration VALVE TO PIPE			% of Length Coverage 100% % of Area Coverage 100%	Date 3/21/00									
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.	Remarks										
N/A	NI	N/A	NONE										

Remarks: **NONE**

Primary Examiner GEORGE A. MORINI	ASNT Level II	Initials <i>GM</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>Wang Cordis</i>	Non Technical Review <i>Wang Cordis</i>	Date 3-23-00
SNC NDE Level II/III Review <i>Barry R. Lefter</i>		Date 3-22-00	Percentage of Code Coverage 100 %	ANII Review <i>cgward</i>		Date 3/25/00	

Figure 1

Revision 6

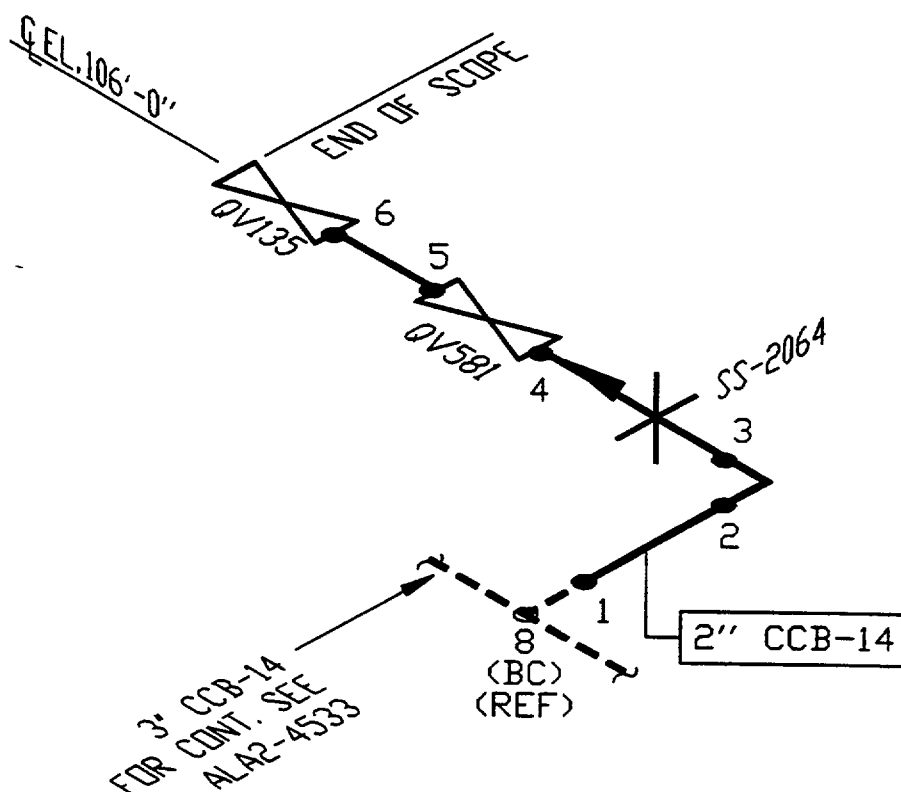
DRAWING ALA2-4539
HHSI CHARGING FLOW REGULATOR BY-PASS

[illegible]

AUXILIARY
EL. 100'-0"
ROOM 18B

ALA2-4539

HIGH HEAD SAFETY INJECTION CHARGING FLOW REGULATOR BY-PASS



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	0			
LONG SEAM WELD				
SOCKET WELD	6	2"		
BRANCH CONN.	0			
WELDED SUPP.	0			
COMP. SUPPORT	1	N/A		

LINE NUMBER: Q-1-E21-CCB-14

BOUNDARY DIAGRAM D-351116 SH. 6

REFERENCE ISO'S E3609

LINE SIZE: 2" CCB-14

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	DEFV		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

164

0

CAD LA24539
AUTOCAD JLB-01

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4539-5	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P023
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration VALVE TO PIPE		% of Length Coverage 100% % of Area Coverage 100%	Date 3/21/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A	Remarks NONE

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Dan Cordes</i>	Date 3-23-00
SNC NDE Level II/III Review <i>Dan R. Hopkins</i>		Date 3-22-00	Percentage of Code Coverage 100 %	ANII Review <i>C. Ward</i>		Date 3/25/00	

Figure 1

Revision 6

DRAWING ALA2-4600

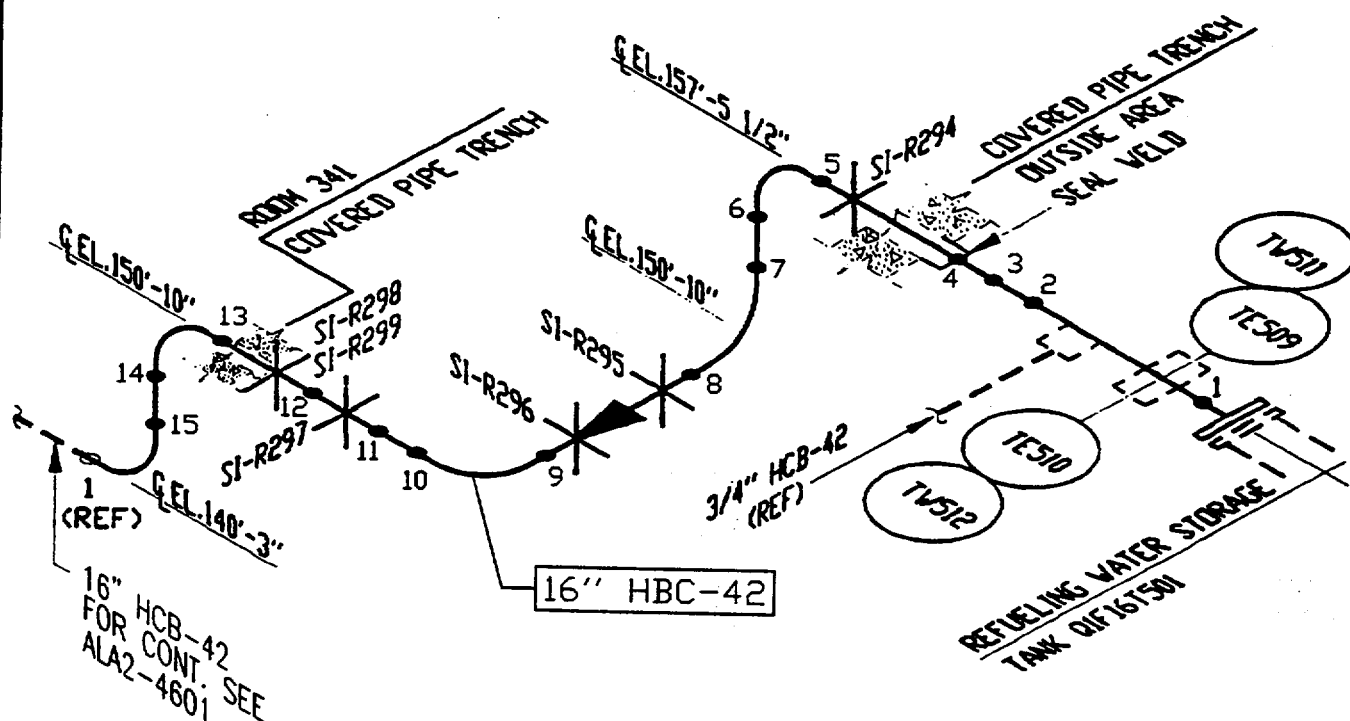
CVCS FROM RWST

[illegible]

OUTSIDE AREA
EL. 155'-0"

ALA2-4600

CVCS
FROM RWST



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	14	16"		
SEAL WELD	1	16"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	0			
WELDED SUPP.	0			
COMP. SUPPORT	6	N/A		

LINE NUMBER: Q-1-E21-HCB-42

BOUNDARY DIAGRAM	D-351115 SH. 1

REFERENCE ISO'S	D-514755 SH. 1

LINE SIZE: 16" HCB-42

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc.		for	E21-CHEMICAL & VOLUME CONTROL SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

165

0

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4600-1	Date 3/30/00	Sheet No. S00F1U227	Page 1 of 2
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. s00f1i007	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	0.375"	1T	80	2.0	0.35	1T	80	2.1	0.35
Ax. dB	43 dB	Size	.25	Cal. Temp.	66°	2T	60	4.0	0.65	2T	30	4.2	0.70
Ref.	30.2	Frequency/Mode	5 / S	Cal. In	0745	3T	40	6.0	0.95				
Scan	44.2	"A" Dimension	0.2"	Cal. Chk.	0822	4T	20	8.0	1.30				
Reject	OFF	Nominal Angle	45	Cal. Out	0850	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	10%/4.0								

Comp. Temp.: **74°** °F Configuration: **FLANGE TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

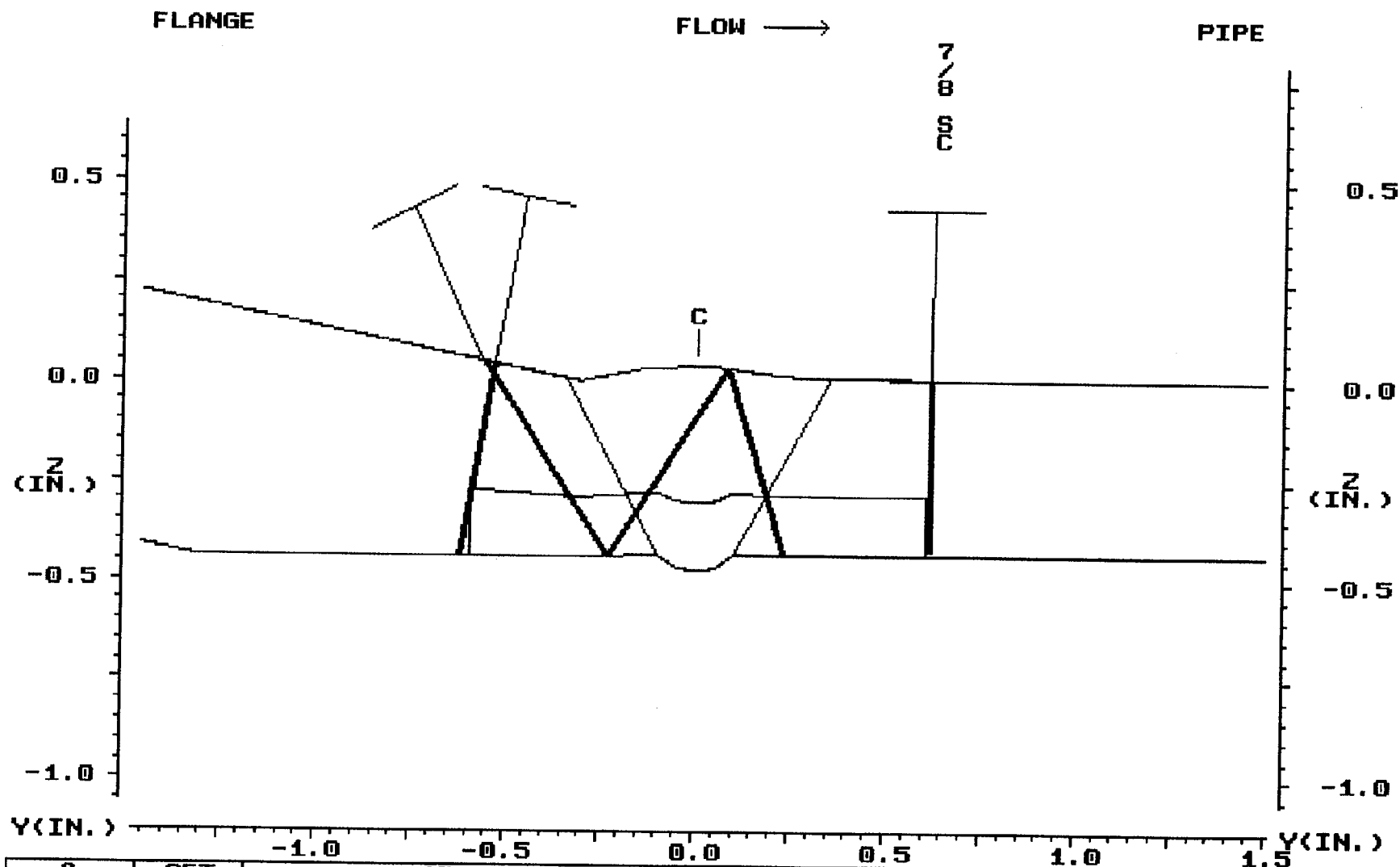
Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

3.5" ID PLATE ON PIPE SIDE (2 SCAN) FROM 26" TO 29.5", 1/4" FROM WELD TOE.

Total Length of Weld 51.0"		Crown Width 0.69"	Total Length of Weld Examined 5 (L) NL 2 (L) 47.5" 7 & 8 (W) 47.5"		Extent of Perpendicular Scans (W) 5 - from 0.55" to NL 2 - from 0.55" to NL		Extent of Parallel Scans (L) From (5) NL to (2) NL	
Primary Examiner JOHN W. BELL			Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-30-00	Percentage of Code Coverage 97 %			ANII Review <i>[Signature]</i>	Date 3-30-00

Figure 1

Revision 7



3	SET	1R16022.DAT	1R16022A.SCR	1	SET		
1.16	DEP	ASME VOLUMETRIC CODE COVERAGE			0.50	DEP	
1.63	MP				0.50	MP	
34.15	TOF				12.40	TOF	
	ARC					ARC	
	GATE	45 DEG FOR 93% OF WELD - 100%			GATE		
	STEP	45 DEG FOR 7% OF WELD - 60% 3T (60/40/70/70)			STEP		
0.050	EXIT	COMPOSITE 97%	D.R. CORDES L/III	0.050	EXIT		
	MAKERAY	UTILITY	LEFT	RIGHT	TOP	PRINT	EXIT
PLANT: FARLEY 1		3/30/00		CIRC. POS.: TYP			
SYSTEM: CVCS		11:11		ANALYST: D.R. CORDES L/III			
COMPONENT: ALA2-4600-1				CAL. SHEET: S00F1U227 & 228			

FNP-0-NDE-100.31
Southern Nuclear Operating Company

s00f1|007

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	64468	Thickness	0.375"								
Ax. dB	43.0	Circ. dB		Cal. Temp.	66°								
Ref.	50.0	N/A	Frequency/Mode	5.0 / S	Cal. In								
Scan	64.0	N/A	"A" Dimension	0.2"	Cal. Chk.	0829							
Reject	OFF		Nominal Angle	60	Cal. Out	0853							
Frequency	5.0		Measured Angle	59	Ref. Blk. No.	4976	Calibration Remarks: NONE						
Mode	P/E		Cable Type	RG174	Reflector	HOLE							
Damping	500 OHMS		Cable Length	15'	Amplitude/Sweep	20%/8.8							

Lo Location TDC

[illegible]

Examination/Limitation Remarks: 3.5" ID PLATE ON PIPE SIDE (2 SCAN) FROM 26" TO 29.5", 1/4" FROM WELD TOE.

Total Length of Weld	Crown Width	Total Length of Weld Examined		Extent of Perpendicular Scans (W)		Extent of Parallel Scans (L)	
51.0"	0.69"	5 (L) NL	2 (L) 47.5"	7 & 8 (W) 47.5"	5 - from 0.56" to NL	2 - from 0.56" to NL	From (5) NL to (2) NL
Primary Examiner		Level	Assistant Examiner		Level	Non-Technical Review	
JOHN W. BELL <i>John W Bell</i>		II	N/A		N/A	<i>J. Eric Aycock</i>	
SNC-NDE Level II/III Review		Date	Percentage of Code Coverage		ANII Review		Date
<i>Dan Corde</i> <i>L/III</i>		3-30-00	SEE 500F1U227 %		<i>E. J. Ward</i> <i>CSW</i> <i>4/3/00</i>		3/30/00

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4600-1	Sheet Number S00F1U229	Date 3/30/00		
ISO/Drawing Number ALA2-4600		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136K-472F		
Examiner JOHN W. BELL	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow FLANGE TO PIPE		
Location LMAX	TDC	WMAX	WELD CL	Component Temp °F 66°	Thermometer S/N PTC 38102

FLOW

T. MEASUREMENTS

O.D. PROFILE

Position	Measurement
1	1.4
2	1.2
3	1.0
4	.82
5	.74
6	.64
7	.54
8	.60
9	.44
10	.44
11	.44
12	.44

T. MEASUREMENT EACH .25 IN.

REMARKS:

NDE LII/III Review <i>[Signature]</i>	Level III	Date 3-30-00	Non-Technical Review <i>[Signature]</i>	Date 3-30-00

Revision 1

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4600-1	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P048	Page 1 of 1
Thermometer Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 74 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration FLANGE TO PIPE		% of Length Coverage 100%	Date 3/29/00	
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. ID PLATE FROM 26" TO 29.5", 1/4" FROM TOE OF WELD ON PIPE SIDE.		Remarks N/A

Remarks: **NONE**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. D. Funyak</i>	Date 3-30-00
SNC NDE Level II/III Review <i>Day Cards LIII</i>		Date 3-30-00	Percentage of Code Coverage 99 %	ANII Review <i>Cybernet</i>		Date 3/30/00	

Figure 1

Revision 6

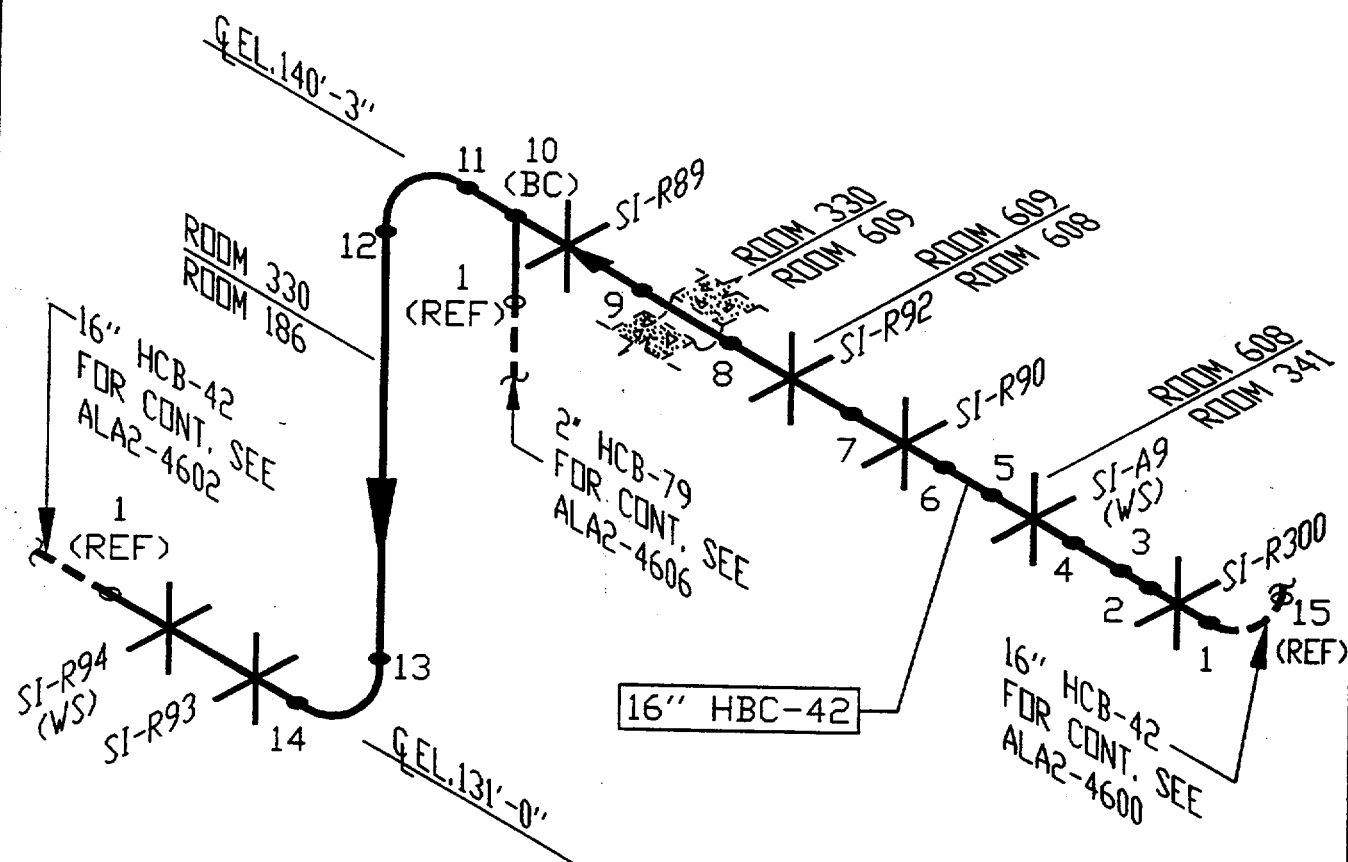
DRAWING ALA2-4601

CVCS FROM RWST

[illegible]

AUXILIARY
EL. 139'-0"

ALA2-4601

CVCS
FROM RWST

TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	13	16"		
BUTT WELD				
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	1	2"		
WELDED SUPP.	2	N/A		
COMP. SUPPORT	7	N/A		

LINE NUMBER: Q-1-E21-HCB-42

BOUNDARY DIAGRAM D-351115 SH. 1

REFERENCE ISO'S D-514754 SH. 1

D-514755 SH. 1

LINE SIZE: 16" HCB-42

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	DEV		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for E21-CHEMICAL & VOLUME CONTROL SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

166

0

CAD LA24601
AUTOCAD JLB-02

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4601-11	Date 3/28/00	Sheet No. S00F1U206	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A		Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38102 / 8/27/2000	Linearity Sheet No. S00F1L002

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K472F	Serial No.	00B2J2	Thickness	0.375"	1T	80	2.0	0.35	1T	80	2.1	0.35
Ax. dB	26.0	Size	.25	Cal. Temp.	66°	2T	60	4.0	0.65	2T	30	4.2	0.70
Circ. dB	30.0	Frequency/Mode	5 / S	Cal. In	0840	3T	40	6.0	0.95				
Ref.	26.0	"A" Dimension	0.2"	Cal. Chk.	0900	4T	20	8.0	1.30				
Scan	38.0	Nominal Angle	45	Cal. Out	1232	Calibration Remarks: NONE							
Reject	OFF	Measured Angle	45	Ref. Blk. No.	4976								
Frequency	5.0	Cable Type	RG174	Reflector	HOLE								
Mode	P/E	Cable Length	15'	Amplitude/Sweep	5%/4.0								
Damping	500 OHMS												

Comp. Temp.: 79° °F Configuration: PIPE TO ELBOW Wo Location WELD CL Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.

Total Length of Weld 50.5"	Crown Width 0.7"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)						Extent of Parallel Scans (L)									
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner JOHN W. BELL		Level II		Assistant Examiner N/A			Level N/A		Non-Technical Review <i>J. Eric Oyeck</i>			Date 3-29-00								
SNC NDE Level II/III Review <i>Vandy Corda</i>		Date 3-29-00		Percentage of Code Coverage 100 %			ANII Review <i>C. G. ...</i>			Date 3/29/00										

Figure 1

Revision 7

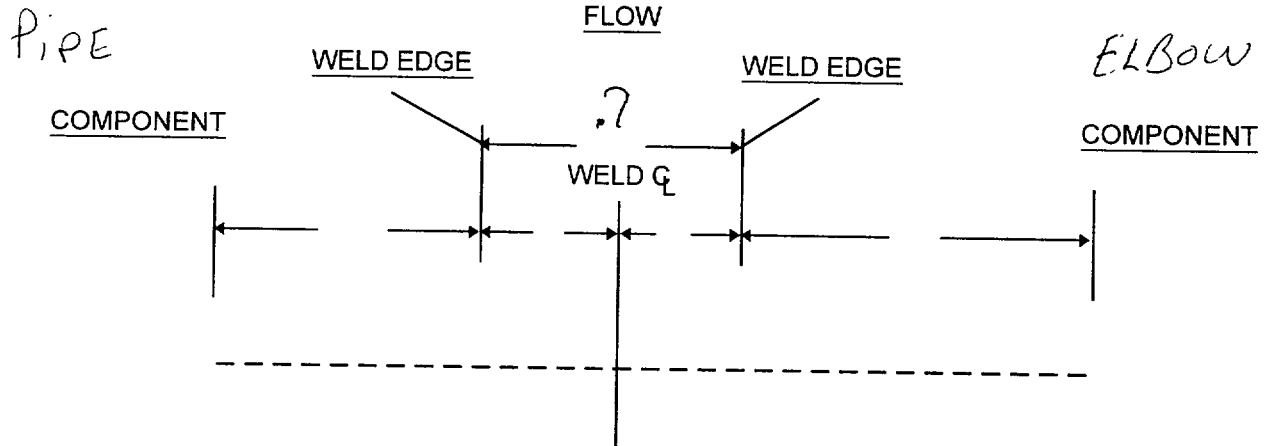
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4601-11	Sheet Number S00F1U213	Date 3/28/00
ISO/Drawing Number ALA2-4601	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136K-472F <i>Sal 4-4-00</i>
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A	
Component Configuration/Flow PIPE TO ELBOW			
Location LMAX TDC WMAX WELD CL		Component Temp °F 66°	Thermometer S/N PTC 38102



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Dan Corda</i>	Level III	Date 3-29-00	Non-Technical Review <i>J. Edm. Lopez</i>	Date 3-29-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4601-11	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P039	Page / of /
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO ELBOW		% of Length Coverage 100%	Date 3/28/00	
Ind. No. N/A		Results NI	Indication Desc. / Exam Limitations / etc. N/A	
Remarks N/A				

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>JWB</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>J. Edwin Pappach</i>	Non-Technical Review <i>J. Edwin Pappach</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Samuel B. Lott</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>CG</i>		Date 3/30/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4601-12	Date 3/28/00	Sheet No. S00F1U207	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38102 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	0.375"	1T	80	2.0	0.35	1T	80	2.1	0.35
Ax. dB	<i>Del 4-3-00</i>	Size	.25	Cal. Temp.	66°	2T	60	4.0	0.65	2T	30	4.2	0.70
Ref.	26.0 30.0	Frequency/Mode	5 / S	Cal. In	0840	3T	40	6.0	0.95				
Scan	38.0 42.0	"A" Dimension	0.2"	Cal. Chk.	0916	4T	20	8.0	1.30				
Reject	OFF	Nominal Angle	45	Cal. Out	1232	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	5%/4.0								

Comp. Temp.: **79** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **OR ELBOW**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
50.5"	0.7"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner JOHN W. BELL <i>John W Bell</i>		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-29-00						
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-29-00		Percentage of Code Coverage 100 %				ANW Review <i>[Signature]</i> 4/3/00				Date 3/30/00						

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4601-12	Sheet Number S00F1U212	Date 3/28/00		
ISO/Drawing Number ALA2-4601	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY			
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136K-472F <i>4400</i>		
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A			
		Component Configuration/Flow ELBOW TO PIPE			
Location LMAX OR ELBOW WMAX WELD CL		Component Temp °F 66°	Thermometer S/N PTC 38102		

FLOW

T. MEASUREMENTS

O.D. PROFILE

.55" .55" .55" .60" .4" .4" .4"

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Danny Carde</i>	Level III	Date 3-29-00	Non-Technical Review <i>J. E. D. Dwyer</i>	Date 3-29-00

Revision 1

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4601-12	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P040	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO PIPE		% of Length Coverage 100%	Date 3/28/00	
Ind. No. N/A		Results NI	Indication Desc. / Exam Limitations / etc. N/A	
Remarks N/A				

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>JWB</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>J. Eric Dupont</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Barry R. Loftis</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>CG</i>		Date 3/30/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit	Sketch/Component No.	Date	Sheet No.	Page
1	ALA2-4601-13	3/28/00	S00F1U208	1 of 1
Procedure/Rev./TCN	Couplant/Batch No.	Thermometer SN/Cal Due Date	Linearity Sheet No.	
FNP-0-NDE-100.31 / 7 / N/A	SONOTRACE 40 / 94243	38102 / 8/27/2000	S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	0.375"	1T	80	2.0	0.35	1T	80	2.1	0.35
Ax. dB	50 43.00	Size	.25	Cal. Temp.	66°	2T	60	4.0	0.65	2T	30	4.2	0.70
Ref.	26.0	Frequency/Mode	5 / S	Cal. In	0840	3T	40	6.0	0.95				
Scan	38.0	"A" Dimension	0.2"	Cal. Chk.	0930	4T	20	8.0	1.30				
Reject	OFF	Nominal Angle	45	Cal. Out	1232	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	5%/4.0								

Comp. Temp.: 79° °F Configuration: PIPE TO ELBOW Wo Location **WELD CL** Lo Location **OR ELBOW**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld	Crown Width	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)			
50.5"	0.65"	5 (L) NL	2 (L) NL	7 & 8 (W) NL	5 - from NL to NL	2 - from NL to NL	From (5) NL to (2) NL						
Primary Examiner		Level	Assistant Examiner				Level	Non-Technical Review				Date	
JOHN W. BELL <i>John W. Bell</i>		II	N/A				N/A	<i>J. Eric O'Leary</i>				3-29-00	
SNC NDE Level II/III Review		Date	Percentage of Code Coverage				ANII Review				Date		
<i>Danny Cordia LIII</i>		3-29-00	100 %				<i>cgwand</i> 4/13/00				3/30/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4601-13	Sheet Number S00F1U211	Date 3/28/00		
ISO/Drawing Number ALA2-4601		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136K-472F <i>Del 4-4-00</i>		
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW		
Location OR ELBOW		Component Temp °F 66°	Thermometer S/N PTC 38102		
<i>P.PE</i> <u>WELD EDGE</u> <u>FLOW</u> <u>WELD EDGE</u> <i>ELBow</i> <u>COMPONENT</u> <i>.65</i> <u>WELD Q</u> <u>COMPONENT</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<i>.4" .4" .4" .6" .55" .58"</i>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Danny Cochrane</i>		Level III	Date 3-29-00	Non-Technical Review <i>J. Eric Aycock</i>	
				Date 3-29-00	
Revision 1					

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4601-13	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P041	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO ELBOW		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/28/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Ed Chyock</i>	Date 3-29-00
SNO-NDE Level II/III Review <i>Wm Card</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>cgward</i>		Date 3/30/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4601-14	Date 3/28/00	Sheet No. S00F1U209	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A		Couplant/Batch No. SONOTRACE 40 / 94243		Thermometer SN/Cal Due Date 38102 / 8/27/2000
		Linearity Sheet No. S00F1L002		

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	0.375"	1T	80	2.0	0.35	1T	80	2.1	0.35
Ax. dB	43-00	Size	.25	Cal. Temp.	66°	2T	60	4.0	0.65	2T	30	4.2	0.70
Ref.	26.0	Frequency/Mode	5 / S	Cal. In	0840	3T	40	6.0	0.95				
Scan	38.0	"A" Dimension	0.2"	Cal. Chk.	0944	4T	20	8.0	1.30				
Reject	OFF	Nominal Angle	45	Cal. Out	1232	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	5%/4.0								

Comp. Temp.: **79°** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld	Crown Width	Total Length of Weld Examined			Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)											
50.5"	0.8"	5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner JOHN W. BELL <i>John W Bell</i>		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>J. E. [Signature]</i>			Date 3-29-00										
SNC-NDE Level II/III Review <i>Dany Corda L/III</i>		Date 3-29-00	Percentage of Code Coverage 100 %			ANII Review <i>egward</i> 4/3/00			Date 3/30/00											

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4601-14	Sheet Number S00F1U210	Date 3/28/00		
ISO/Drawing Number ALA2-4601		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number <i>sal 4-4-00</i> 136K-472F		
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A			
Component Configuration/Flow ELBOW TO PIPE					
Location LMAX TDC WMAX WELD CL		Component Temp °F 66°		Thermometer S/N PTC 38102	
<u>PIPE</u> <u>FLOW</u> <u>ELBOW</u> <u>WELD EDGE</u> <u>WELD EDGE</u> <u>COMPONENT</u> <u>WELD CL</u> <u>COMPONENT</u> .8"					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					
NDE LII/III Review <i>Dan Corda</i>		Level III	Date 3-29-00	Non-Technical Review <i>J. Eric Opack</i>	
				Date 3-29-00	
Revision 1					

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4601-14	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P042
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 79 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration ELBOW TO PIPE		% of Length Coverage 100% % of Area Coverage 100%	Date 3/28/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A	Remarks N/A

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>[Signature]</i>	Date 3-29-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/30/00	

Figure 1

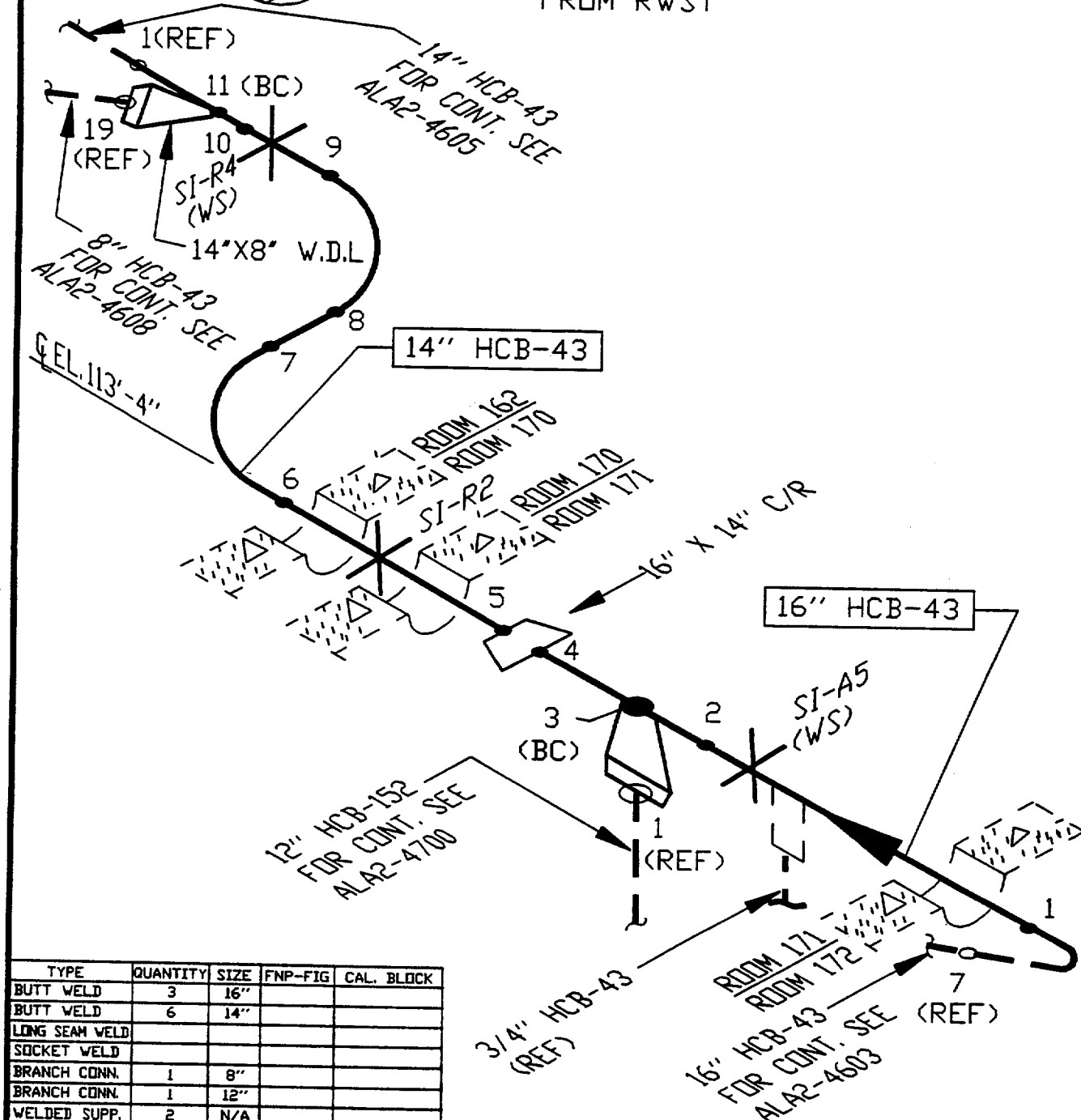
Revision 6

DRAWING ALA2-4604
CVCS FROM RWST

[illegible]

AUXILIARY
EL. 121'-0"CVCS
FROM RWST

ALA2-4604



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	3	16"		
BUTT WELD	6	14"		
LONG SEAM WELD				
SOCKET WELD				
BRANCH CONN.	1	8"		
BRANCH CONN.	1	12"		
WELDED SUPP.	2	N/A		
COMP. SUPPORT	3	N/A		

LINE NUMBER: Q-1-E21-HCB-43

BOUNDARY DIAGRAM D-351115 SH. 1

REFERENCE ISO'S D-514395 SH. 1

LINE SIZE: 16" HCB-43

D-514396 SH. 1

14" HCB-43

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0
REV.	DATE	BY	CHK'D	DESCRIPTION

LDT	DLG	APP.1	APP.2	APP.3	APP.4

Southern Company Services, Inc. for E21-CHEMICAL & VOLUME CONTROL SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

169

0

CAD LA24604
AUTOCAD JLB-02

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4604-4	Date 3/28/00	Sheet No. S00F1U205	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38102 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-50	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	0.375"								
Ax. dB	26.0	Size	.25	Cal. Temp.	66°								
Circ. dB	30.0	Frequency/Mode	5 / S	Cal. In	0840								
Ref.	26.0	"A" Dimension	0.2"	Cal. Chk.	1010	1T	80	2.0	0.35	1T	80	2.1	0.35
Scan	38.0	Nominal Angle	45	Cal. Out	1232	2T	60	4.0	0.65	2T	30	4.2	0.70
Reject	OFF	Measured Angle	45	Ref. Blk. No.	4976	3T	40	6.0	0.95				
Frequency	5.0	Cable Type	RG174	Reflector	HOLE	4T	20	8.0	1.30				
Mode	P/E	Cable Length	15'	Amplitude/Sweep	5%/4.0	Calibration Remarks: NONE							
Damping	500 OHMS												

Comp. Temp.: **80°** °F Configuration: **PIPE TO REDUCER** Wo Location **WELD CL** Lo Location **TDC**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1"<--	C/L	-->1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 50.5"	Crown Width 0.7"	Total Length of Weld Examined			Extent of Perpendicular Scans (W)						Extent of Parallel Scans (L)									
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	NL	to	NL	2 - from	NL	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner JOHN W. BELL		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-29-00						
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-29-00		Percentage of Code Coverage 100 %				AMII Review <i>[Signature]</i>				Date 3/30/00								

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4604-4	Sheet Number S00F1U214	Date 3/28/00		
ISO/Drawing Number ALA2-4604		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136K-472F		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner n/a		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. n/a		Indication No. n/a	Component Configuration/Flow PIPE TO REDUCER		
Location LMAX tdc WMAX weld cl			Component Temp °F 66°	Thermometer S/N PTC 38102	

FLOW

T. MEASUREMENTS

O.D. PROFILE

.37" .37" .55" .48" .48" .48"

T. MEASUREMENT EACH IN.

REMARKS:

NDE LII/III Review <i>Dan Corda</i>	Level III	Date 3-29-00	Non-Technical Review <i>J. E. O'Connell</i>	Date 3-29-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4604-4	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P043	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 81 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO REDUCER		% of Length Coverage 100%	Date 3/28/00	
Ind. No. N/A		Results NI	Indication Desc. / Exam Limitations / etc. N/A	
Remarks N/A				

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>JWB</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>J. Eric O'cock</i>	Non-Technical Review <i>J. Eric O'cock</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Harry D. Loftis</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>CG Ward</i>		Date 3/30/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4604-5	Date 3/27/00	Sheet No. S00F1U204	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38102 / 8/27/2000	Linearity Sheet No. S00F1L002	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																								
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	ALA-49	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>0.35</td> <td>1T</td> <td>80</td> <td>2.1</td> <td>0.55</td> </tr> <tr> <td>2T</td> <td>40</td> <td>4.0</td> <td>0.70</td> <td>2T</td> <td>20</td> <td>4.2</td> <td>0.90</td> </tr> <tr> <td>3T</td> <td>15</td> <td>6.0</td> <td>1.05</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>10</td> <td>8.0</td> <td>1.40</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	0.35	1T	80	2.1	0.55	2T	40	4.0	0.70	2T	20	4.2	0.90	3T	15	6.0	1.05					4T	10	8.0	1.40					Calibration Remarks: NONE			
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																										
1T	80	2.0	0.35	1T	80		2.1	0.55																																										
2T	40	4.0	0.70	2T	20		4.2	0.90																																										
3T	15	6.0	1.05																																															
4T	10	8.0	1.40																																															
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	0.375"																																													
Ax. dB <i>43.00</i>	<i>43.00</i>	Size	.25	Cal. Temp.	66°																																													
Ref.	36.0	Frequency/Mode	5 / S	Cal. In	0830																																													
Scan	48.0	"A" Dimension	0.2"	Cal. Chk.	N/A																																													
Reject	OFF	Nominal Angle	45	Cal. Out	1230																																													
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	N/A																																													
Mode	P/E	Cable Type	RG174	Reflector	N/A																																													
Damping	500 OHMS	Cable Length	15'	Amplitude/Sweep	N/A																																													

Comp. Temp.: 79 °F Configuration: REDUCER TO PIPE Wo Location WELD CL Lo Location TDC

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.

Total Length of Weld 44.75"	Crown Width 0.7"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from NL to NL 2 - from NL to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL		
Primary Examiner JOHN W. BELL <i>John W Bell</i>		Level II	Assistant Examiner N/A		Level N/A	Non-Technical Review <i>J. Eric Orrock</i>			Date 3-29-00	
SNC NDE Level II/III Review <i>Nancy Cardo L III</i>		Date 3-29-00	Percentage of Code Coverage 100 %		ANII Review <i>EGuard 4/3/00</i>			Date 3/30/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4604-5	Sheet Number S00F1U215	Date 3/28/00		
ISO/Drawing Number ALA2-4604		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number <i>304408</i> 136K-472F		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5	MHz
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow REDUCER TO PIPE		
Location LMAX TDC WMAX WELD CL			Component Temp °F 66°	Thermometer S/N PTC 38102	
<u>REDUCER</u> <u>COMPONENT</u> <u>WELD EDGE</u> <u>WELD CL</u> <u>FLOW</u> .65 <u>WELD EDGE</u> <u>PIPE</u> <u>COMPONENT</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<u>.45" .45" .45" .50" .4" .4" .4"</u>					
<u>T. MEASUREMENT EACH</u> IN.					
REMARKS:					

NDE LII/III Review <i>Dan Corda</i>	Level III	Date 3-29-00	Non-Technical Review <i>J. E. D. Aycock</i>	Date 3-29-00

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4604-5	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P044	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 81 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration REDUCER TO PIPE		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/28/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Eric Chyock</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Long Card</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>CG</i>		Date 3/30/00	

Figure 1

Revision 6

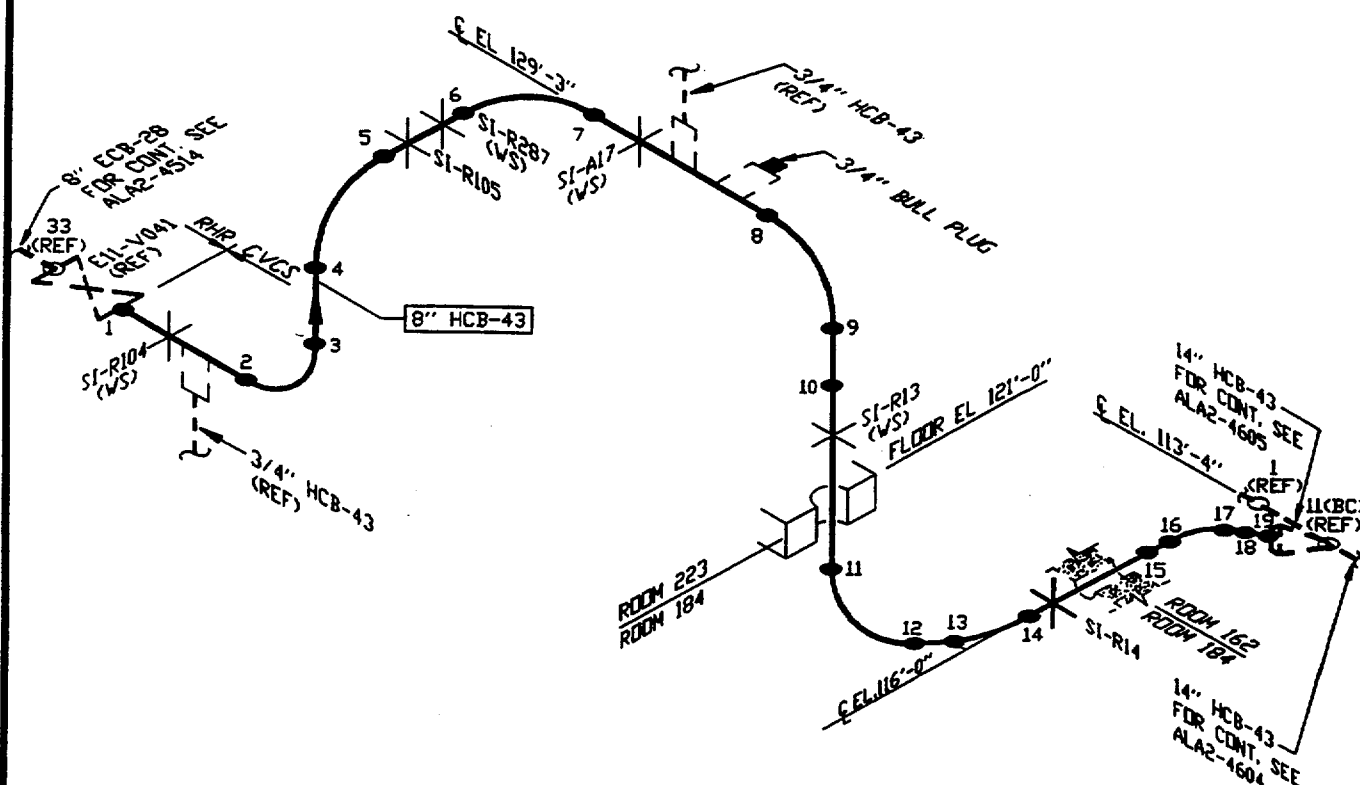
DRAWING ALA2-4608
CVCS RETURN TO RWST

[illegible]

AUXILIARY
EL. 121'-0"

ALA2-4608

CVCS
RETURN TO RWST



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	19	8"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	0			
WELDED SUPP.	4			
COMP. SUPPORT	6			

LINE NUMBER: Q-1-E21-HCB-43	BOUNDARY DIAGRAM	D-351115 SH. 1 D-351115 SH. 2
	REFERENCE ISO'S	D-514518 SH. 1
LINE SIZE: 8" HCB-43		D-514395 SH. 1

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	DEF		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for		E21-CHEMICAL & VOLUME CONTROL SYS	APR 82	APR 82	APR 82	APR 82

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET	REV.

A-351192

173

1

CAD LA24608 JLB-02

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

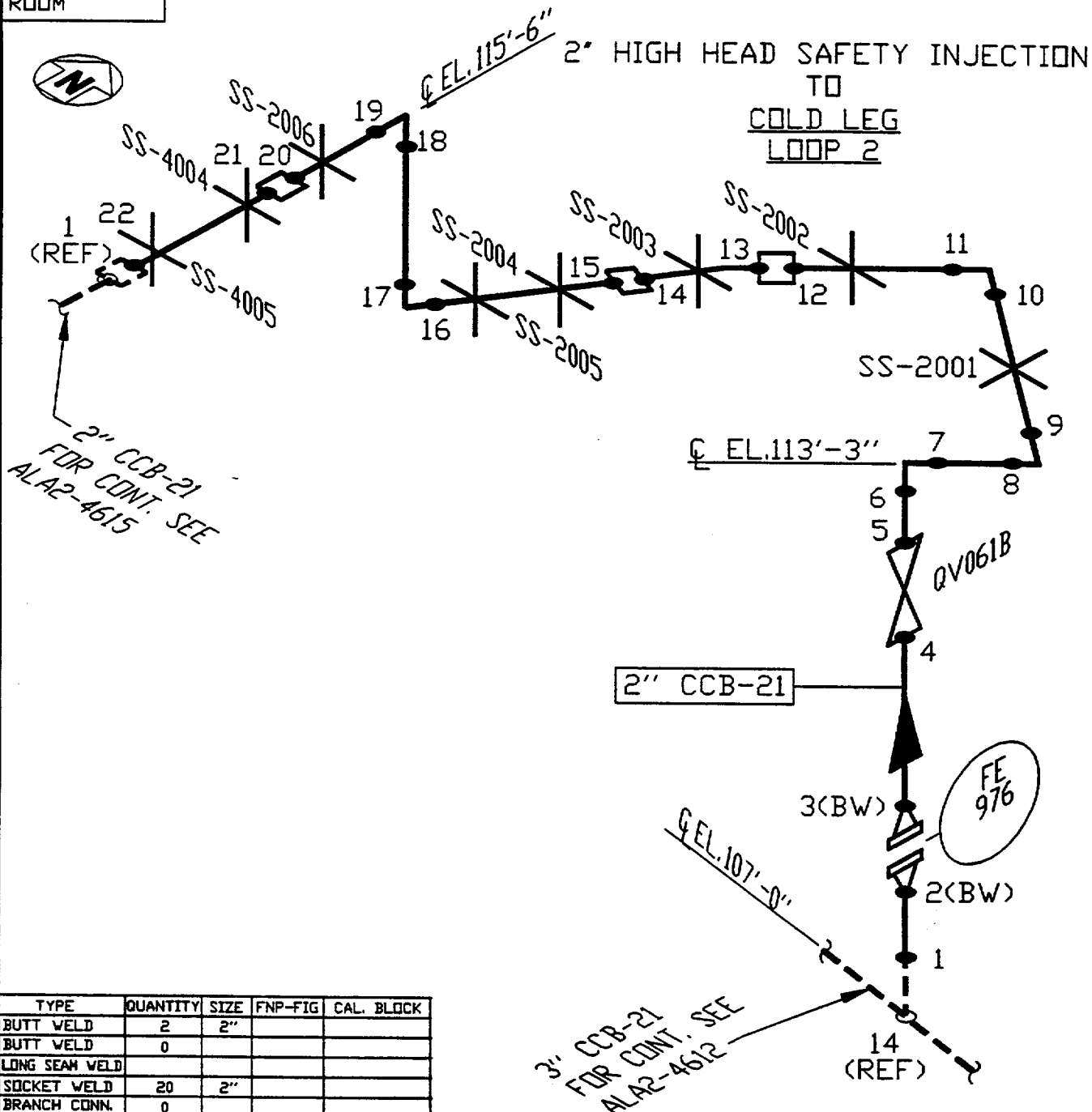
Plant/Unit Farley / 1	System/Support No. ALA2-4608-SI-A17	WO/WA/STP N/A	Sheet No. S00F1V020
Hanger Type ANCHOR	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial PAUL D'VALERIO	Level II	Resolution ● 1/32" Division Scale	Tools FLASHLIGHT, MIRROR, SCALE
Sig. <i>Paul D'Valerio</i>		○ 1/32" Line (Gray Card)	
Examiner / Initial N/A	Level N/A		
Sig.			
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable/ Unacceptable Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments: PLANT IN MODE 6 AT EXAM TIME			
<i>Dan Corda LTH 3-14-00</i>		<i>DATE REVIEW: 6/6/00 3/16/00</i>	

DRAWING ALA2-4614
HHSI TO COLD LEG – LOOP 2

[illegible]

AUXILIARY
EL.
ROOM

ALA2-4614



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	2	2"		
BUTT WELD	0			
LONG SEAM WELD				
SOCKET WELD	20	2"		
BRANCH CONN.	0			
WELDED SUPP.	0			
COMP. SUPPORT	8	N/A		

LINE NUMBER: Q-1-E21-CCB-21

BOUNDARY DIAGRAM D-351115 SH. 1

REFERENCE ISO'S D-518113 SH. 2

LINE SIZE: 2" CCB-21

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	REV		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for E21-HIGH HEAD SAFETY INJECTION SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

179

0

CAD LA24614
AUTOCAD JLB-02

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2
SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

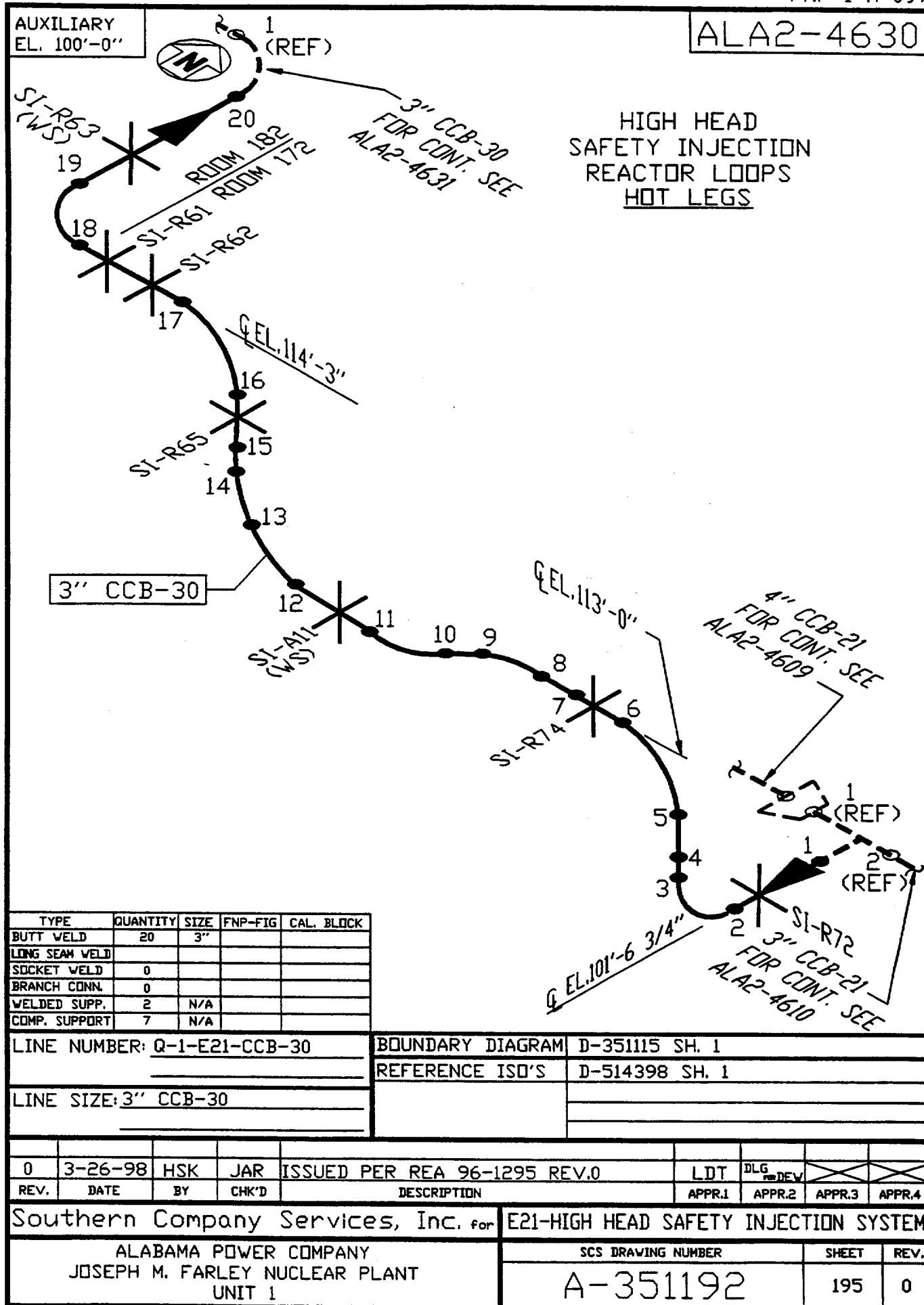
SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4614-SS-2004	WOWA/STP N/A	Sheet No. S00F1V012
Hanger Type ANCHOR 2 U-BOLTS	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/13/00
Examiner / Initial GARY A. LOFTHUS Sig. <i>Gary A. Loftus</i>	Level III	Resolution ☒ 1/32" Division Scale ☐ 1/32" Line (Gray Card)	Tools FLASHLIGHT, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable/Unacceptable Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		N/A	
Improper hot or cold positions.		N/A	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		N/A	
Other Conditions:		N/A	
Comments: ELEVATION 105, CONTAINMENT			
<i>Danny Cordes L III 3-14-2000</i> <i>ANTI REVIEW: E. G. [signature] 3/16/00</i>			

Revision 3

DRAWING ALA2-4630
HHSI TO REACTOR LOOPS HOT LEGS

[illegible]



SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4630-3	Date 3/29/00	Sheet No. S00F1U221	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L007	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																					
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>0.38</td> </tr> <tr> <td>2T</td> <td>42</td> <td>4.0</td> <td>0.78</td> </tr> <tr> <td>3T</td> <td>20</td> <td>6.0</td> <td>1.20</td> </tr> <tr> <td>4T</td> <td>12</td> <td>8.0</td> <td>1.50</td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	0.38	2T	42	4.0	0.78	3T	20	6.0	1.20	4T	12	8.0	1.50	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.1</td> <td>0.53</td> </tr> <tr> <td>2T</td> <td>60</td> <td>4.2</td> <td>1.06</td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.1	0.53	2T	60	4.2	1.06								
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax																																												
1T	80	2.0	0.38																																												
2T	42	4.0	0.78																																												
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4T	12	8.0	1.50																																												
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax																																												
1T	80	2.1	0.53																																												
2T	60	4.2	1.06																																												
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.438"																																										
Ax. dB	Del 43.0	Size	.25	Cal. Temp.	68°																																										
Ref.	29.6	Frequency/Mode	5 / S	Cal. In	0915																																										
Scan	43.6	"A" Dimension	0.2"	Cal. Chk.	1102																																										
Reject	OFF	Nominal Angle	45	Cal. Out	1235																																										
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976																																										
Mode	P/E	Cable Type	RG174	Reflector	HOLE																																										
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	15%/3.3																																										

Calibration Remarks:
NONE

Comp. Temp.: **72°** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **OR EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- >1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 11.5"		Crown Width 0.75"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from 0.575" to NL			Extent of Parallel Scans (L) 2 - from 0.575" to NL			From (5) NL to (2) NL		
Primary Examiner JOHN W. BELL		Level II		Assistant Examiner N/A			Level N/A		Non-Technical Review <i>[Signature]</i>			Date 3-29-00		
SNC NDE Level II/III Review <i>[Signature]</i>				Date 3-29-00		Percentage of Code Coverage 100 %			ANII Review <i>[Signature]</i>			Date 3/30/00		

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4630-3		Sheet Number S00F1U226		Date 3/29/00
ISO/Drawing Number ALA2-4630		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136K-472F	
Examiner JOHN W. BELL		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow ELBOW TO PIPE	
Location LMAX OR EL WMAX WELD CL			Component Temp °F 72°	Thermometer S/N PTC 38081	
<u>FLOW</u> T. MEASUREMENTS O.D. PROFILE T. MEASUREMENT EACH .25 IN. REMARKS:					
NDE LII/III Review <i>Danny Cards</i>		Level III	Date 3-29-00	Non-Technical Review <i>Edw. O'Connell</i>	
				Date 3-29-00	Revision 1

SHARED

Farley Nuclear Plant
Liquid Penetrant Examination Record

FNP-0-NDE-100.5

PT-F-Form 001

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4630-3	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P045	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO PIPE		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/28/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Eric Oycoc</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Wing Card</i> L III		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>Edward</i>		Date 3/30/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4630-18	Date 3/29/00	Sheet No. S00F1U220	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L007	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.438"	1T	80	2.0	0.38	1T	80	2.1	0.53
Ax. dB	43.0	Size	.25	Cal. Temp.	68°	2T	42	4.0	0.78	2T	60	4.2	1.06
Ref.	29.6	Frequency/Mode	5 / S	Cal. In	0915	3T	20	6.0	1.20				
Scan	43.6	"A" Dimension	0.2"	Cal. Chk.	1115	4T	12	8.0	1.50				
Reject	OFF	Nominal Angle	45	Cal. Out	1235	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	15%/3.3								

Comp. Temp.: **72°** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **OR EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 11.5"		Crown Width 0.75"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from 0.575" to NL			Extent of Parallel Scans (L) 2 - from 0.575" to NL			From (5) NL to (2) NL		
Primary Examiner JOHN W. BELL		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-29-00				
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-29-00	Percentage of Code Coverage 100 %			ANII Review <i>[Signature]</i>			Date 3/30/00				

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4630-18		Sheet Number S00F1U225		Date 3/29/00
ISO/Drawing Number ALA2-4630		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886		Model Number SONIC 136	Serial Number 136K-472F	
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA		Size .25
Examiner N/A		SNT Level N/A	Serial Number 00B5RV		Frequency 5 MHz
Weld Examination Record No. N/A		Indication No. N/A		Component Configuration/Flow PIPE TO ELBOW	
Location LMAX OR EL WMAX WELD CL			Component Temp °F 72°	Thermometer S/N PTC 38081	
<u>FLOW</u> T. MEASUREMENTS O.D. PROFILE T. MEASUREMENT EACH .25 IN. REMARKS:					
NDE I/II/III Review <i>Dan Card</i>		Level III	Date 3-29-00	Non-Technical Review <i>Eric O'Connell</i>	
				Date 3-29-00	Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4630-18	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P046	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 80 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO ELBOW		% of Length Coverage 100%	Date 3/28/00	
Ind. No. N/A		Results NI	Indication Desc. / Exam Limitations / etc. N/A	
Remarks N/A				

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials JWB	Assistant Examiner N/A	ASNT Level N/A	Initials 	Non-Technical Review J. Eric Dyck	Date 3-29-00
SNC NDE Level II/III Review Samuel R. Rottler		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review egw		Date 3/30/00	

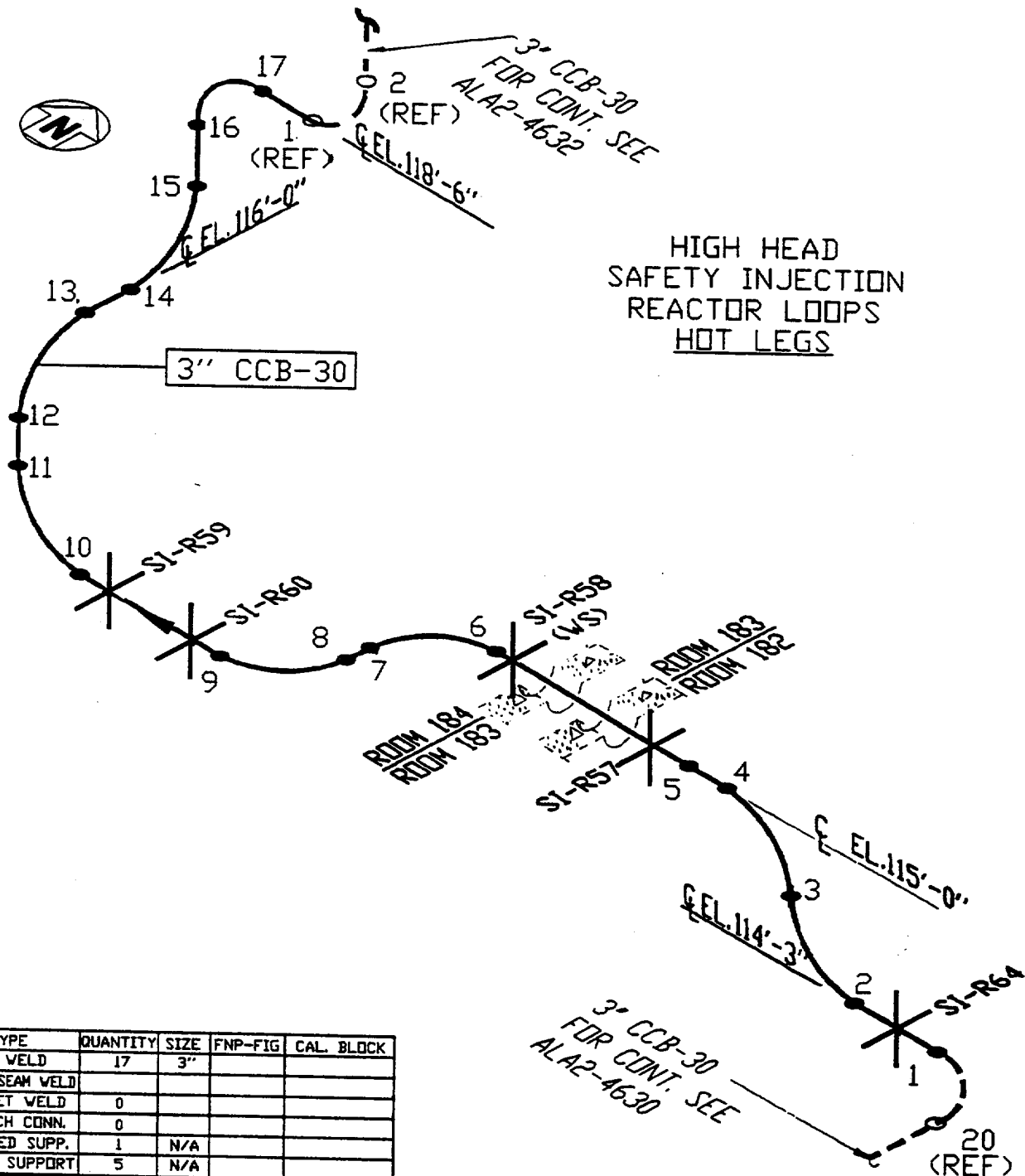
Figure 1

Revision 6

[illegible][illegible]

AUXILIARY
EL. 100'-0"

ALA2-4631



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	17	3"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	0			
WELDED SUPP.	1	N/A		
COMP. SUPPORT	5	N/A		

LINE NUMBER: Q-1-E21-CCB-30

BOUNDARY DIAGRAM D-351115 SH. 1

REFERENCE ISO'S D-514398 SH. 1

LINE SIZE: 3" CCB-30

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	APPR.1	APPR.2	APPR.3	APPR.4
REV.	DATE	BY	CHK'D	DESCRIPTION						

Southern Company Services, Inc. for E21-HIGH HEAD SAFETY INJECTION SYSTEM

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

196

0

CAD LAR24631
ACADIVY RAV-01

SHARED

FARLEY NUCLEAR PLANT
Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4631-16	Date 3/29/00	Sheet No. S00F1U219	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L007	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.438"	1T	80	2.0	0.38	1T	80	2.1	0.53
Ax. dB	43.0	Size	.25	Cal. Temp.	68°	2T	42	4.0	0.78	2T	60	4.2	1.06
Ref.	29.6	Frequency/Mode	5 / S	Cal. In	0915	3T	20	6.0	1.20				
Scan	43.6	"A" Dimension	0.2"	Cal. Chk.	1150	4T	12	8.0	1.50				
Reject	OFF	Nominal Angle	45	Cal. Out	1235	Calibration Remarks: NONE							
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976								
Mode	P/E	Cable Type	RG174	Reflector	HOLE								
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	15%/3.3								

Comp. Temp.: **72°** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **OR EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●			N/A														
5	●			N/A														
7	●			N/A														
8	●			N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 11.5"	Crown Width 0.75"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from 0.575" to NL 2 - from 0.575" to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL		
Primary Examiner JOHN W. BELL		Level II	Assistant Examiner N/A		Level N/A	Non-Technical Review <i>[Signature]</i>			Date 3-29-00	
SNC NDE Level II/III Review <i>[Signature]</i>			Date 3-29-00	Percentage of Code Coverage 100 %		ANII Review <i>[Signature]</i>			Date 3/30/00	

Figure 1

Revision 7

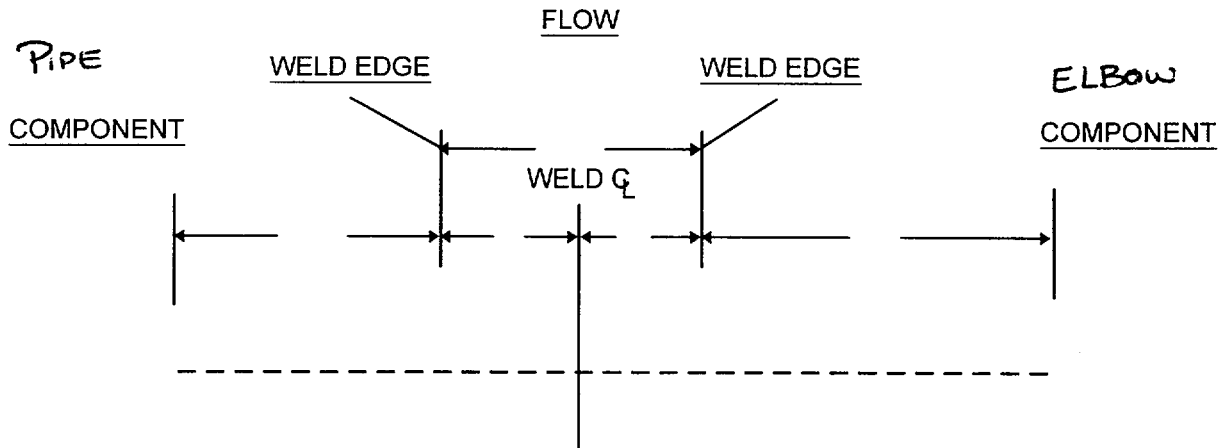
SHARED

Ultrasonic Weld Profile Record

FNP-0-NDE-100.35

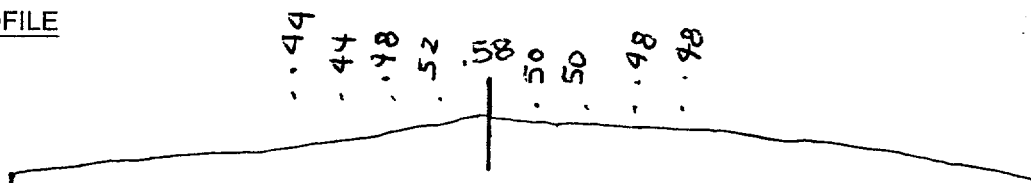
Southern Nuclear Operating Company

Unit 1	Weld Number ALA2-4631-16	Sheet Number S00F1U224	Date 3/29/00
ISO/Drawing Number ALA2-4631	Couplant/Batch Number SONOTRACE 40 / 94243	Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number 136K-472F <i>del 4.46</i>
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz
Weld Examination Record No. N/A	Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW	
Location LMAX OR EL WMAX WELD CL	Component Temp °F 72°	Thermometer S/N PTC 38081	



T. MEASUREMENTS

O.D. PROFILE



T. MEASUREMENT EACH .25 IN.

REMARKS:

NDE I/II/III Review <i>Danny Cards</i>	Level III	Date 3-29-00	Non-Technical Review <i>Eric Oyeach</i>	Date 3-29-00

Revision 1

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4631-16	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P047	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 72 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration PIPE TO ELBOW		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/29/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks N/A

Remarks: **NONE**

Primary Examiner JOSEPH D. FUNYAK	ASNT Level II	Initials <i>JD</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Joe Funyak</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Joe Funyak</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>LG Ward</i>		Date 3/30/00	

Figure 1

Revision 6

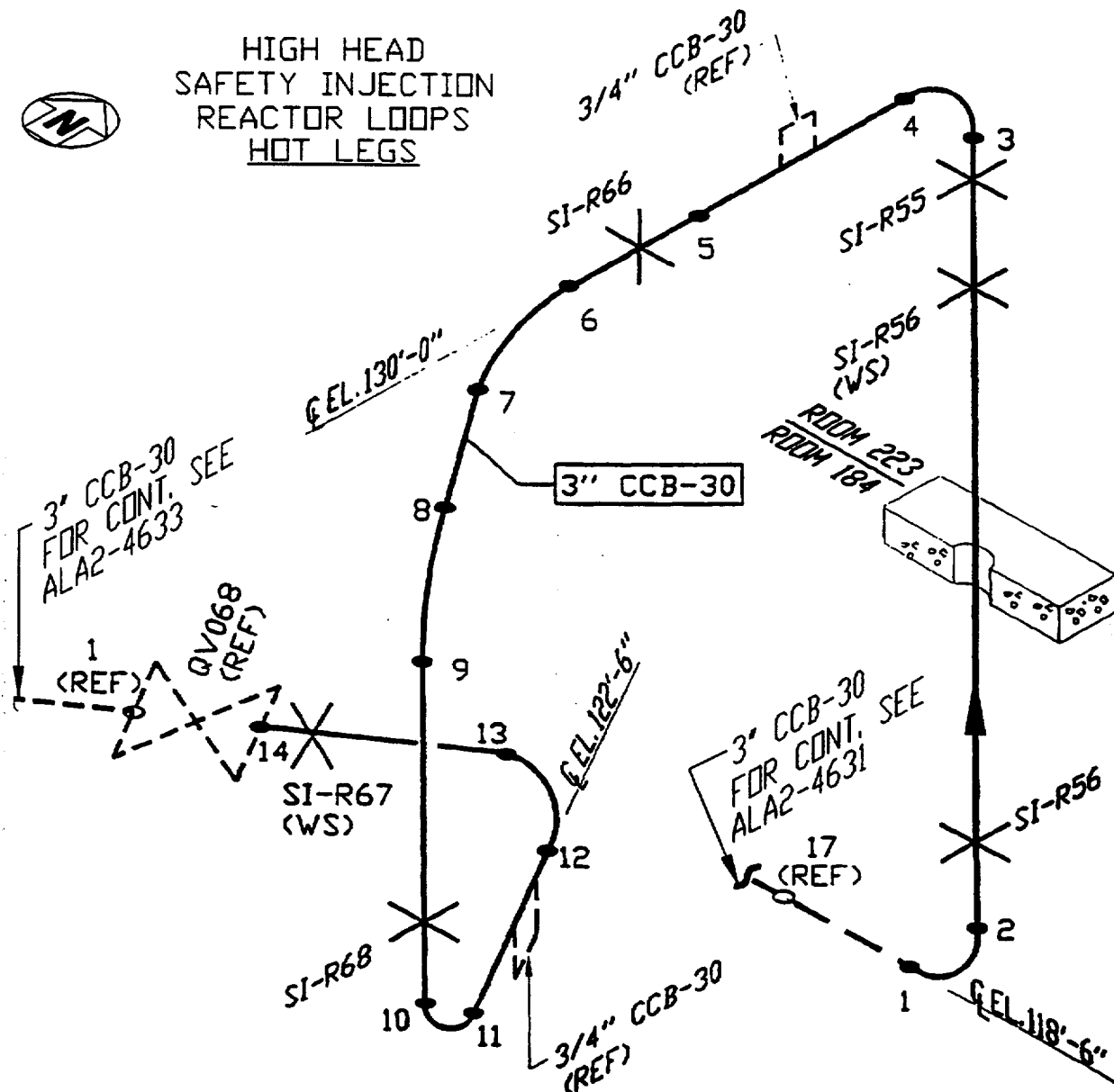
[illegible]

AUXILIARY
EL. 100'-0"

ALA2-4632



HIGH HEAD SAFETY INJECTION REACTOR LOOPS HOT LEGS



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	14	3"		
LONG SEAM WELD				
SOCKET WELD	0			
BRANCH CONN.	0			
WELDED SUPP.	2	N/A		
COMP. SUPPORT	5	N/A		

LINE NUMBER: Q-1-E21-CCB-30

BOUNDARY DIAGRAM D-351115 SH. 1

REFERENCE ISO'S D-514520 SH. 1

LINE SIZE: 3" CCB-30

0	3-26-98	DRW	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG			
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for

E21-HIGH HEAD SAFETY INJECTION SYSTEM

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

197

0

CAD LA24632
ACAD/DEV RAV-01

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4632-6	Date 3/29/00	Sheet No. S00F1U218	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A	Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L007	

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration			
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.438"	1T	80	2.0	0.38	1T	80	2.1	0.53
Ax. dB	29.6	Size	.25	Cal. Temp.	68°	2T	42	4.0	0.78	2T	60	4.2	1.06
Circ. dB	43.0	Frequency/Mode	5 / S	Cal. In	0915	3T	20	6.0	1.20				
Ref.	29.6	"A" Dimension	0.2"	Cal. Chk.	1025	4T	12	8.0	1.50				
Scan	43.6	Nominal Angle	45	Cal. Out	1235	Calibration Remarks: NONE							
Reject	OFF	Measured Angle	45	Ref. Blk. No.	4976								
Frequency	5.0	Cable Type	RG174	Reflector	HOLE								
Mode	P/E	Cable Length	45'	Amplitude/Sweep	15%/3.3								
Damping	500 OHMS												

Comp. Temp.: **72°** °F Configuration: **PIPE TO ELBOW** Wo Location **WELD CL** Lo Location **OR EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" <--	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 11.5"	Crown Width 0.75"	Total Length of Weld Examined				Extent of Perpendicular Scans (W)				Extent of Parallel Scans (L)										
		5 (L)	NL	2 (L)	NL	7 & 8 (W)	NL	5 - from	0.575"	to	NL	2 - from	0.575"	to	NL	From (5)	NL	to	(2)	NL
Primary Examiner JOHN W. BELL		Level II		Assistant Examiner N/A				Level N/A		Non-Technical Review <i>[Signature]</i>				Date 3-29-00						
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-29-00		Percentage of Code Coverage 100 %				ANII Review <i>[Signature]</i>				Date 3/30/00								

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4632-6	Sheet Number S00F1U223	Date 3/29/00		
ISO/Drawing Number ALA2-4632		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number <i>20440</i> 136K-472F		
Examiner JOHN W. BELL <i>John W Bell</i>		SNT Level II	Search Unit Manufacturer KBA	Size .25	
Examiner N/A		SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz	
Weld Examination Record No. N/A		Indication No. N/A	Component Configuration/Flow PIPE TO ELBOW		
Location LMAX OR EL WMAX WELD CL			Component Temp °F 72°	Thermometer S/N PTC 38081	
<u>FLOW</u>					
<u>T. MEASUREMENTS</u>					
<u>O.D. PROFILE</u>					
<u>T. MEASUREMENT EACH</u> .25 IN.					
REMARKS:					
NDE LII/III Review <i>Dan Card</i>		Level III	Date 3-29-00	Non-Technical Review <i>Eric Aycock</i>	
				Date 3-29-00	
Revision 1					

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4632-6	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P033
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K	
Component Configuration PIPE TO ELBOW		% of Length Coverage 100% % of Area Coverage 100%	Date 3/27/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A	Remarks NONE

Remarks: **NONE**

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>gwb</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>J. Eric Rycock</i>	Non-Technical Review <i>J. Eric Rycock</i>	Date 3-29-00
SNC/NDE Level II/III Review <i>Wang Cordis L III</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>cgward</i>		Date 3/30/00	

Figure 1

Revision 6

SHARED

FARLEY NUCLEAR PLANT Ultrasonic Calibration and Examination Record

FNP-0-NDE-100.31
Southern Nuclear Operating Company

Unit 1	Sketch/Component No. ALA2-4632-9	Date 3/29/00	Sheet No. S00F1U217	Page 1 of 1
Procedure/Rev./TCN FNP-0-NDE-100.31 / 7 / N/A		Couplant/Batch No. SONOTRACE 40 / 94243	Thermometer SN/Cal Due Date 38081 / 8/27/2000	Linearity Sheet No. S00F1L007

Instrument		Search Unit		Calibration Block		Axial Scan Calibration				Circ. Scan Calibration																																								
Instrument	STAVELEY	Transducer Mfg.	KBA	Cal. Blk. No.	APR-2	<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> <th>Cal. Refl.</th> <th>Signal Amp.</th> <th>Sweep Div.</th> <th>Wmax</th> </tr> <tr> <td>1T</td> <td>80</td> <td>2.0</td> <td>0.38</td> <td>1T</td> <td>80</td> <td>2.1</td> <td>0.53</td> </tr> <tr> <td>2T</td> <td>42</td> <td>4.0</td> <td>0.78</td> <td>2T</td> <td>60</td> <td>4.2</td> <td>1.06</td> </tr> <tr> <td>3T</td> <td>20</td> <td>6.0</td> <td>1.20</td> <td></td> <td></td> <td></td> <td></td> </tr> <tr> <td>4T</td> <td>12</td> <td>8.0</td> <td>1.50</td> <td></td> <td></td> <td></td> <td></td> </tr> </table>	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	1T	80	2.0	0.38	1T	80	2.1	0.53	2T	42	4.0	0.78	2T	60	4.2	1.06	3T	20	6.0	1.20					4T	12	8.0	1.50					Calibration Remarks: NONE			
Cal. Refl.	Signal Amp.	Sweep Div.	Wmax	Cal. Refl.	Signal Amp.		Sweep Div.	Wmax																																										
1T	80	2.0	0.38	1T	80		2.1	0.53																																										
2T	42	4.0	0.78	2T	60		4.2	1.06																																										
3T	20	6.0	1.20																																															
4T	12	8.0	1.50																																															
Serial No.	136K-472F	Serial No.	00B2J2	Thickness	.438"																																													
Ax. dB	29.6	Circ. dB	43.0	Cal. Temp.	68°																																													
Ref.	29.6	Size	.25	Cal. In	0915																																													
Scan	43.6	Frequency/Mode	5 / S	Cal. Chk.	1035																																													
Reject	OFF	Nominal Angle	45	Cal. Out	1235																																													
Frequency	5.0	Measured Angle	45	Ref. Blk. No.	4976																																													
Mode	P/E	Cable Type	RG174	Reflector	HOLE																																													
Damping	500 OHMS	Cable Length	45'	Amplitude/Sweep	15%/3.3																																													

Comp. Temp.: **72** °F Configuration: **ELBOW TO PIPE** Wo Location **WELD CL** Lo Location **OR EL**

Scan Dir.	Results			Ind. No.	% DAC	Length			Reference Measurement			Sweep Position			Thickness			Notes:
	NI	NRI	RI			L1	Lmax	L2	W1	Wmax	W2	S1	Smax	S2	1" < --	C/L	-- > 1"	
2	●	○	○	N/A														
5	●	○	○	N/A														
7	●	○	○	N/A														
8	●	○	○	N/A														

Examination/Limitation Remarks: **BASE METAL SCAN PERFORMED WITH TRANSDUCER 00B5RV PER PROCEDURE.**

Total Length of Weld 11.5"	Crown Width 0.75"	Total Length of Weld Examined 5 (L) NL 2 (L) NL 7 & 8 (W) NL			Extent of Perpendicular Scans (W) 5 - from 0.575" to NL 2 - from 0.575" to NL			Extent of Parallel Scans (L) From (5) NL to (2) NL		
Primary Examiner JOHN W. BELL		Level II	Assistant Examiner N/A			Level N/A	Non-Technical Review <i>Eric Dyck</i>			Date 3-29-00
SNC NDE Level II/III Review <i>John W. Bell</i>		Date 3-29-00	Percentage of Code Coverage 100 %			ANII Review <i>E. G. Ward</i>			Date 3/30/00	

Figure 1

Revision 7

SHARED

Ultrasonic Weld Profile Record				FNP-0-NDE-100.35	
Southern Nuclear Operating Company					
Unit 1	Weld Number ALA2-4632-9	Sheet Number S00F1U222	Date 3/29/00		
ISO/Drawing Number ALA2-4632		Couplant/Batch Number SONOTRACE 40 / 94243		Instrument Manufacturer STAVELEY	
Material Type SS	Calibration Standard/Serial Number SS STEP / 800886	Model Number SONIC 136	Serial Number <i>pol 4.400</i> 136K-472F		
Examiner JOHN W. BELL <i>John W Bell</i>	SNT Level II	Search Unit Manufacturer KBA	Size .25		
Examiner N/A	SNT Level N/A	Serial Number 00B5RV	Frequency 5 MHz		
Weld Examination Record No. N/A		Indication No. N/A			
Component Configuration/Flow ELBOW TO PIPE					
Location LMAX OR EL WMAX WELD CL		Component Temp °F 72°		Thermometer S/N PTC 38081	

PIPE FLOW ELBOW

WELD EDGE WELD EDGE

COMPONENT WELD Q COMPONENT

T. MEASUREMENTS

O.D. PROFILE

T. MEASUREMENT EACH , 25 IN.

REMARKS:

NDE LII/III Review <i>Dan Cords</i>	Level III	Date 3-29-00	Non-Technical Review <i>J. Eric Dyck</i>	Date 3-29-00

Revision 1

SHARED

FNP-0-NDE-100.5

Farley Nuclear Plant

PT-F-Form 001

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4632-9	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P034	Page <u>1</u> of <u>1</u>
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration ELBOW TO PIPE		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/27/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks NONE

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CWK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>J. Edwin Quack</i>	Non-Technical Review <i>J. Edwin Quack</i>	Date 3-29-00
SNC NDE Level II/III Review <i>Dan Condo L/III</i>		Date 3-29-00	Percentage of Code Coverage 100 %	ANII Review <i>C. G. Ward</i>		Date 3/30/00	

Figure 1

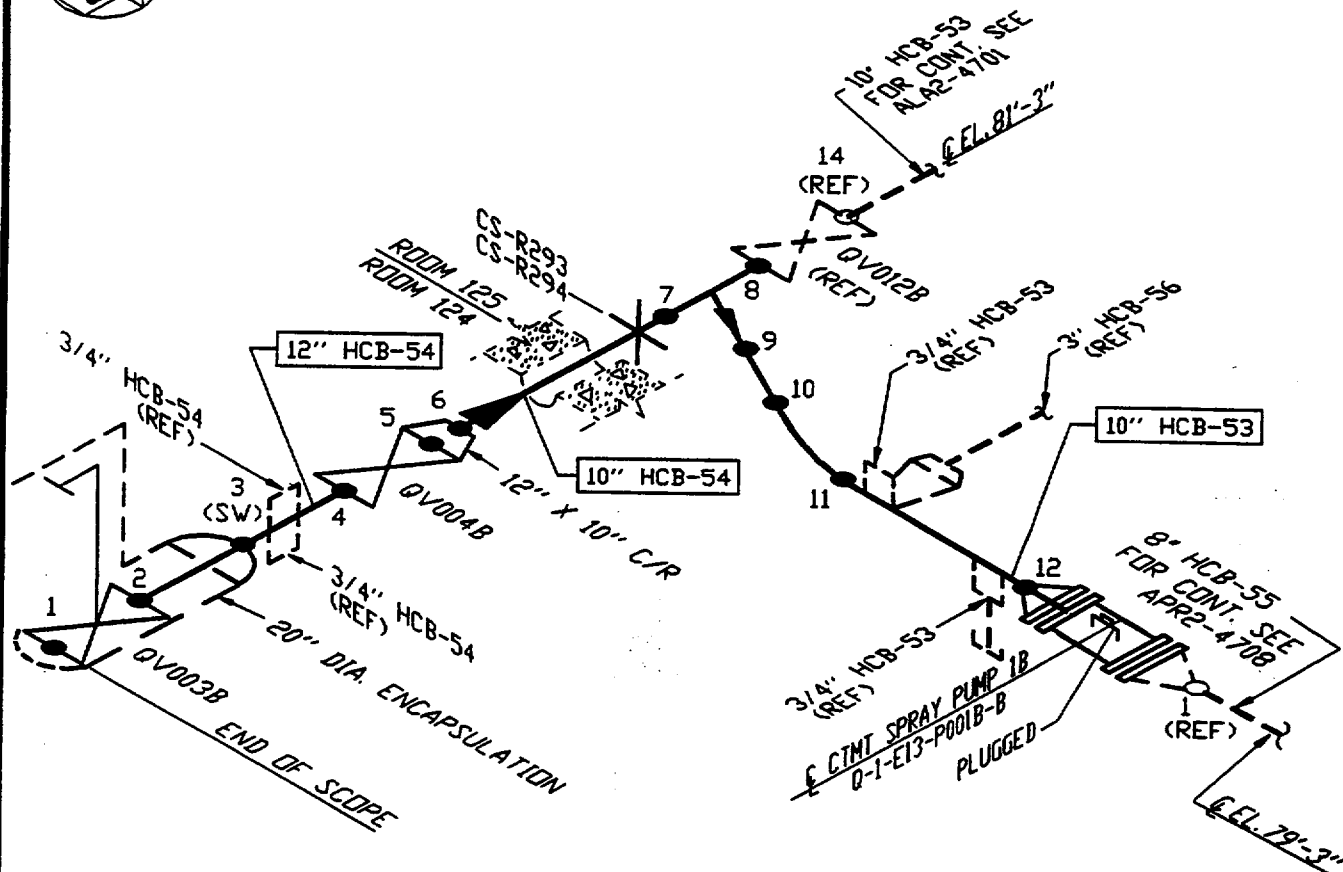
Revision 6

DRAWING ALA2-4702
CTMT SPRAY FROM CTMT SUMP TO SPRAY PUMP B

[illegible]

AUXILIARY
EL. 77'-0"CTMT SPRAY FROM
CTMT SUMP TO
SPRAY PUMP 2B

ALA2-4702



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	5	12"		
BUTT WELD	7	10"		
LONG SEAM WELD				
SEAL WELD	1	12"		
BRANCH CONN.	0			
WELDED SUPP.	N/A	N/A		
COMP. SUPPORT	2	N/A		

LINE NUMBER: Q-1-E13-HCB-54
Q-1-E13-HCB-53

LINE SIZE: 12" HCB-54; 10" HCB-54
10" HCB-53

BOUNDARY DIAGRAM D-351115 SH.3

REFERENCE ISO'S D-514082 SH.1

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG	DEV		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	

Southern Company Services, Inc. for E13-CONTAINMENT SPRAY SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER A-351192

SHEET 204 REV. 0

CAD LA24702
AUTOCAD JLB-01

FIGURE 2 SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4702-CS-R294	WOWA/STP N/A	Sheet No. S00F1V024
Hanger Type HYDRAULIC SNUBBER		Type Exam/Technique VT-3 / DIRECT	Exam Date 3/10/00
Examiner / Initial PAUL D'VALERIO		Level II	Tools TAPE MEASURE, RULER, FLASHLIGHT, MIRROR
Sig. <i>Paul D'Valerio</i>		Resolution ● 1/32" Division Scale	
Examiner / Initial N/A		Level N/A	
Sig.		1/32" Line (Gray Card)	
EXAMINATION LIST:		Acceptable/ Unacceptable	SKETCH (if applicable)
Deformation or structural degradation of fasteners, springs, clamps, or other support items.		Acceptable	
Missing, detached, or loosened support items.		Acceptable	
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.		Acceptable	
Improper hot or cold positions.		*	
Any crack or linear indication.		Acceptable	
Fluid loss or lack of fluid induction (hydraulic snubber only).		Acceptable	
Other Conditions:		Acceptable	
Comments: TYPE: GRINNEL SIZE: 2.5 EXAM: 38 S/N: 15759 STROKE: 5" ACTUAL STROKE: 3 1/8" PIN TO PIN: 19" NOTE: CS-R293 HAS BEEN COMBINED WITH CS-R294 *TO BE DETERMINED BY ENGINEERING			

* Stroke acceptable, see sketch.

Daniel Hartley 3/29/00

ANET REVIEW: *EGW* 3/29/00 Revision 3

Randy Cordes LIII 3-14-00

CUSTOMER

PROJECT NO.

DATE

DRAWN BY

REVISED BY

DATE

FIG. 200

1/82752

AS BUILT BY

FOR NO. 11-3072

HER. ENER. 1/1/1972

MECH. CO. 1/1/1972

1/82752

0'-CLEARANCE

PIPE SLEEVE

3'-4 1/2"

10" HCB-54

TP EXIST

PLAN VIEW 71'-3"

LOCATION PLAN

FOR REFERENCE ONLY

3'-0"

20'-6"

14

12

E

F

K

9

8

7

10

11

15

12

5

14

1

2

3

4

1

1

1

1

1

1

1

1

1

ITEM NO.	MATERIALS AND OPERATIONS	FIG. 200 SN#15759	QUAN.	SHIP.
1	M4x13#x0'-10 7/8' LG.	PDQ 39099	1	
2	M4x13#x5'-9' LG.	PDQ 39099	1	
3	1/4"x3"x3' S.T.x0'-10 7/8' LG.	HT 61171	1	
4	1"x10"x1'-0" LG.	HT X30217	1	
5	3/4"x7 1/2" HILTI KWIKS		4	
6	2 1/2" CYL. 5" STROKE FIG. 200 OPT. 2 CPS-3 3/16"		1	
7	1 1/2" SCH. 40 PIPE x 1'-2 3/8' LG.		1	
8	1/4"x2"x2" S.T. x 1'-4' LG.	PDY 63096	2	
9	1/4"x2"x2" S.T. x 0'-10 3/4' LG.	PDY 63096	2	
10	1/4"x2"x2" S.T. x 0'-6 1/2' LG.	PDY 63096	1	
11	1/4"x2"x2" S.T. x 0'-2 3/8' LG.	PDY 63096	2	
12	1/2"x5'x0'-8' C/S PLATE	PDY 60881	1	
13	1"x1 1/4"x7 3/4' LG. C/S PLATE	HT# 48427	1	
14	1"x1 1/4"x3' LG. C/S PLATE		1	
15	1/2" HILTI KWIK		2	

D-175376

D-176750

D-176580

CS-R293

CS-R294

3292

3293

F. DWG'S

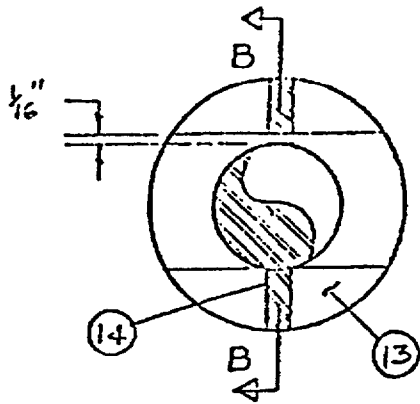
PIPE

MARK NO.

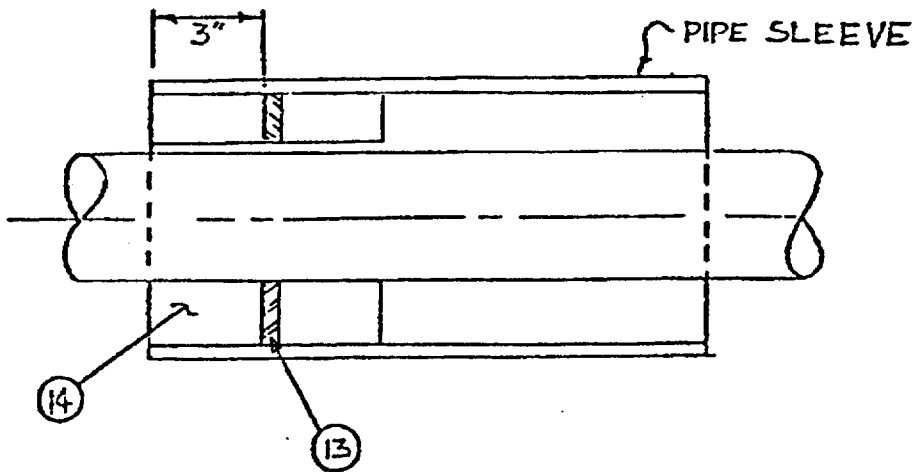
SKETCH NO.

ISO.

82



VIEW A-A



VIEW B-B

SEE REF. DWG'S
 D-175376 REV 7
 D-176750 REV. 6
 D-176580 REV. 16

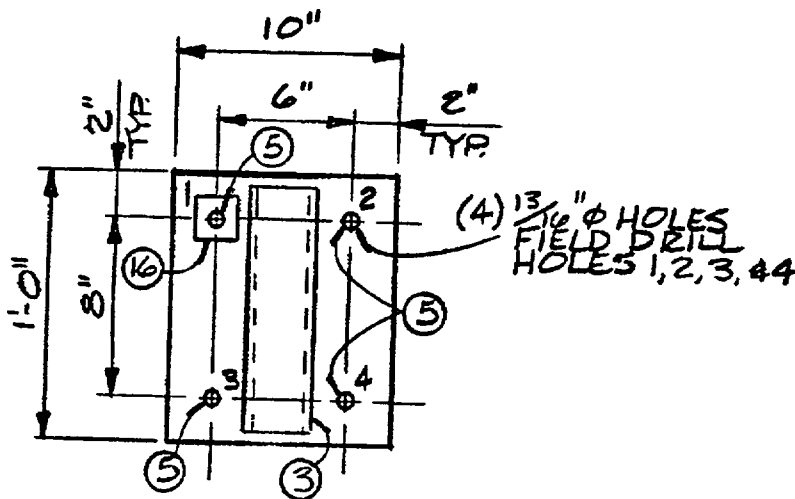
MARK NO. CS-R293
 CS-R294

ISO. B2
 SKETCH NO. 3293 &
 3294

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.

ITEM NO.	DESCRIPTION	QUAN.
*16	PLATE 1/8"x2"x0'-2" LG. C/S	1

* NEW ITEM



SECTION C-C
(LH4, WEST)

NOTE: CS-R293 HAS BEEN
COMBINED W/ CS-R294.

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CAD B5280822.DWG

R14DYY2

CJS - 01

REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	APPR.5
0	2/3/00	CJS	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW				

Southern Company Services, Inc. for ALABAMA POWER COMPANY

FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DWG. NO. B-528082 SH. 2 REV. 0
MARK NO. CS-R293 & -R294 SH. 1 OF 2
SKETCH NO. 1-3292 & -3293

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.

CAD B5280823.DWG

R14DVY2 CJS - 01

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0	2/3/00	CJS	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW				
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	APPR.5

Southern Company Services, Inc. for ALABAMA POWER COMPANY

FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DWG. NO. B-528082 SH. 3 REV. 0
MARK NO. CS-R293 & -R294 SH. 2 OF 2
SKETCH NO. 1-3293 & -3294

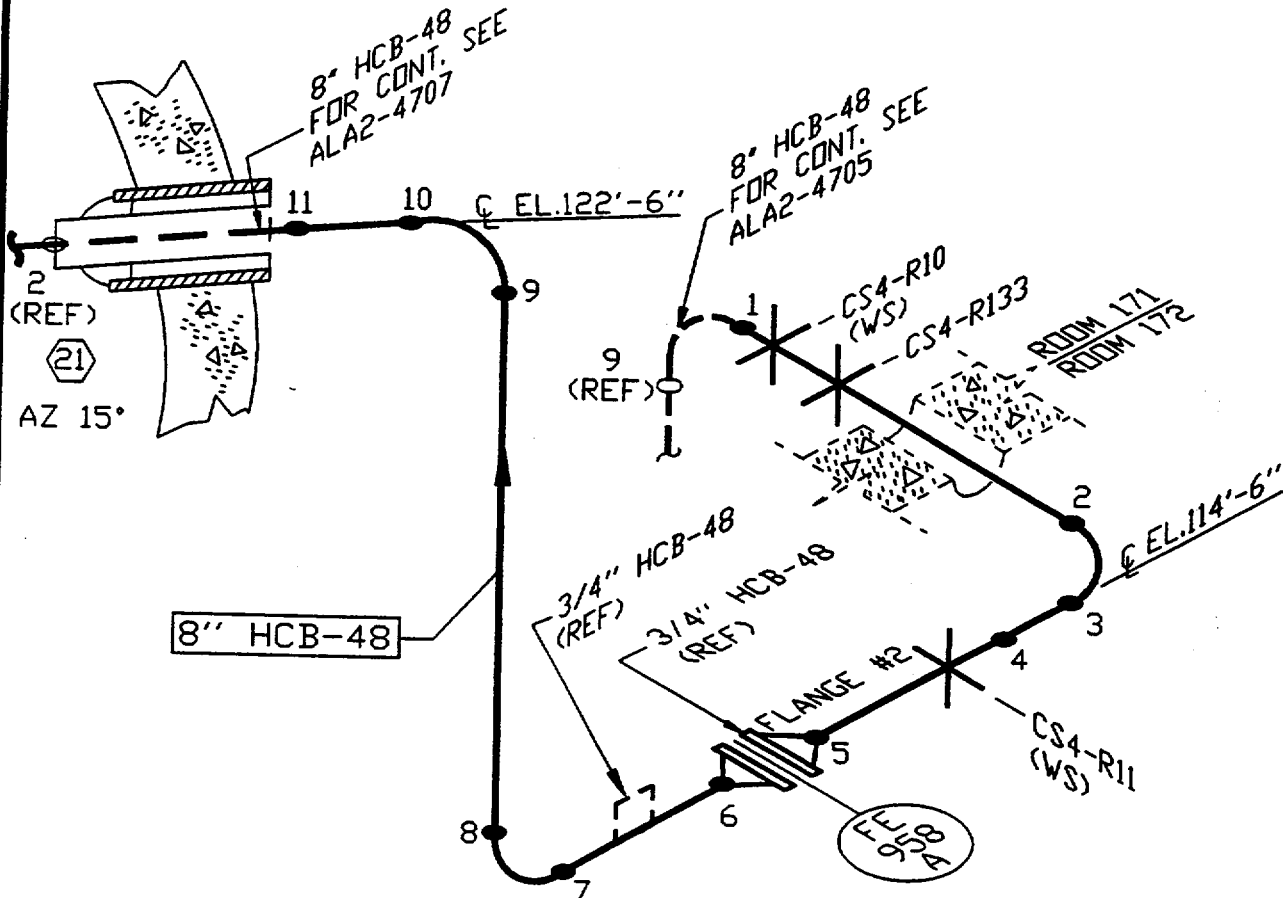
[illegible]

AUXILIARY
EL. 100'-0"

FNP-1-M-097

ALA2-4706

CTMT SPRAY PUMP 1A DISCHARGE



TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	11	8"		
LONG SEAM WELD				
SOCKET WELD	0	N/A		
BRANCH CONN.	0	N/A		
WELDED SUPP.	2	N/A		
COMP. SUPPORT	3	N/A		

LINE NUMBER: Q-1-E13-HBC-48

BOUNDARY DIAGRAM D-351115 SH.3

REFERENCE ISO'S D-514083 SH.1

LINE SIZE: 8" HCB-48

D-514080 SH.1

REV.	DATE	BY	CHK'D	DESCRIPTION	LDT	DLG	APP.1	APP.2	APP.3	APP.4
0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0						

Southern Company Services, Inc. for

E13-CONTAINMENT SPRAY SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

208

0

CAD LAR24706
AUTO CAD JLB-02

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2
SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4706-CS4-R11	WOW/ASTP N/A	Sheet No. S00F1V025
Hanger Type TWO DIRECTIONAL RESTRAINT W/ATTACH	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/10/00
Examiner / Initial PAUL D'VALERIO Sig. <i>Paul D'Valerio</i>	Level II	Resolution ● 1/32" Division Scale	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A	Level	1/32" Line (Gray Card)	
Sig.			
EXAMINATION LIST:	Acceptable/ Unacceptable	SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.	Acceptable		
Missing, detached, or loosened support items.	Acceptable		
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.	N/A		
Improper hot or cold positions.	N/A		
Any crack or linear indication.	Acceptable		
Fluid loss or lack of fluid induction (hydraulic snubber only).	N/A		
Other Conditions:	N/A		
Comments: PLANT IN MODE 6 AT EXAM TIME			
<i>Danny A. Soffins III 3-16-2000</i>		<i>ANTI REVIEW: Cgk/und 3/14/00</i>	

Revision 3

SHARED

FNP-0-NDE-100.5

Farley Nuclear Plant

PT-F-Form 001

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4706-CS4-R11 (WS)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P032	Page 1 of 1
<u>Thermometer</u> Mfg. / Ser. No. PTC / 38081 Cal. Due Date 8/27/2000 Surface Temp. 78 °F		<u>Penetrant Materials</u> Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 98A10K 93D12K 96J08K		
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100%	% of Area Coverage 100%	Date 3/22/00
Ind. No. N/A	Results NI	Indication Desc. / Exam Limitations / etc. N/A		Remarks NONE

Remarks: **NONE**

Primary Examiner CLYDE KIEHL	ASNT Level II	Initials <i>CK</i>	Assistant Examiner N/A	ASNT Level N/A	Initials <i>[Signature]</i>	Non-Technical Review <i>[Signature]</i>	Date 3-25-00
SNC NDE Level II/III Review <i>[Signature]</i>		Date 3-27-00	Percentage of Code Coverage 100 %	ANII Review <i>[Signature]</i>		Date 3/27/00	

Figure 1

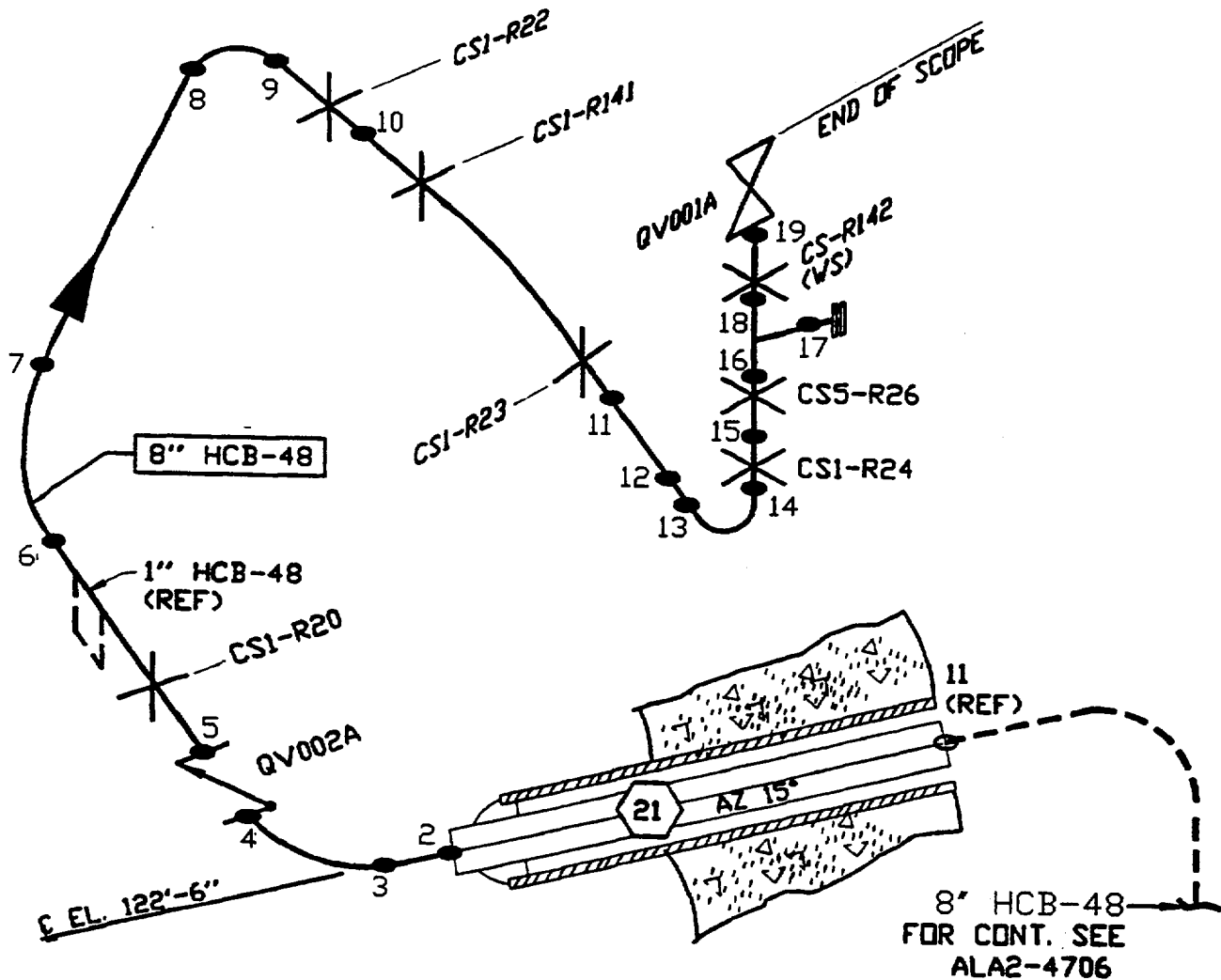
Revision 6

DRAWING ALA2-4707
CTMT SPRAY PUMP 1A DISCHARGE

[illegible]

CTMT
EL. 105'-6"

ALA2-4707

CTMT SPRAY PUMP
1A DISCHARGE

TYPE	QUANTITY	SIZE	FNP-FIG	CAL. BLOCK
BUTT WELD	18	8"		
SOCKET WELD	0			
BRANCH CONN.	0			
WELDED SUPP.	1	N/A		
COMP. SUPPORT	7	N/A		

LINE NUMBER: Q-1-E13-HCB-48

BOUNDARY DIAGRAM D-351115 SH.3

REFERENCE ISO'S D-514080 SH.1

LINE SIZE: 8" HCB-48

0	3-26-98	HSK	JAR	ISSUED PER REA 96-1295 REV.0	LDT	DLG		
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4

Southern Company Services, Inc. for

E13-CONTAINMENT SPRAY SYS

ALABAMA POWER COMPANY
JOSEPH M. FARLEY NUCLEAR PLANT
UNIT 1

SCS DRAWING NUMBER

SHEET

REV.

A-351192

209

0

CAD: LA24707
ACAD: RAV-01

SHARED

FNP-0-NDE-100.23

RTYPE: L1.09

FIGURE 2
SUPPORT EXAMINATION RECORD VT-3

FARLEY NUCLEAR PLANT

SOUTHERN NUCLEAR OPERATING COMPANY

Plant/Unit Farley / 1	System/Support No. ALA2-4707-CS1-R20	WOWA/STP N/A	Sheet No. S00F1V003
Hanger Type SWAY STRUT	Type Exam/Technique VT-3 / DIRECT	Procedure/Rev. FNP-0-NDE-100.23 / 3	Exam Date 3/7/00
Examiner / Initial SCOTT R. ERICKSON Sig. <i>Scott R. Erickson</i>	Level II	Resolution ● 1/32" Division Scale 1/32" Line (Gray Card)	Tools FLASHLIGHT, MIRROR, SCALE
Examiner / Initial N/A Sig.	Level N/A		
EXAMINATION LIST:		SKETCH (if applicable)	
Deformation or structural degradation of fasteners, springs, clamps, or other support items.			
Missing, detached, or loosened support items.			
Arc strikes, weld spatter, paint scoring, roughness, or general corrosion on close tolerance machined or sliding surfaces.			
Improper hot or cold positions.			
Any crack or linear indication.			
Fluid loss or lack of fluid induction (hydraulic snubber only).			
Other Conditions:			
Comments:			
<i>Danny Cordes LIII 3-11-2000</i>			
<i>ANTI REVIEW: C. G. Ward 3/15/00</i>			

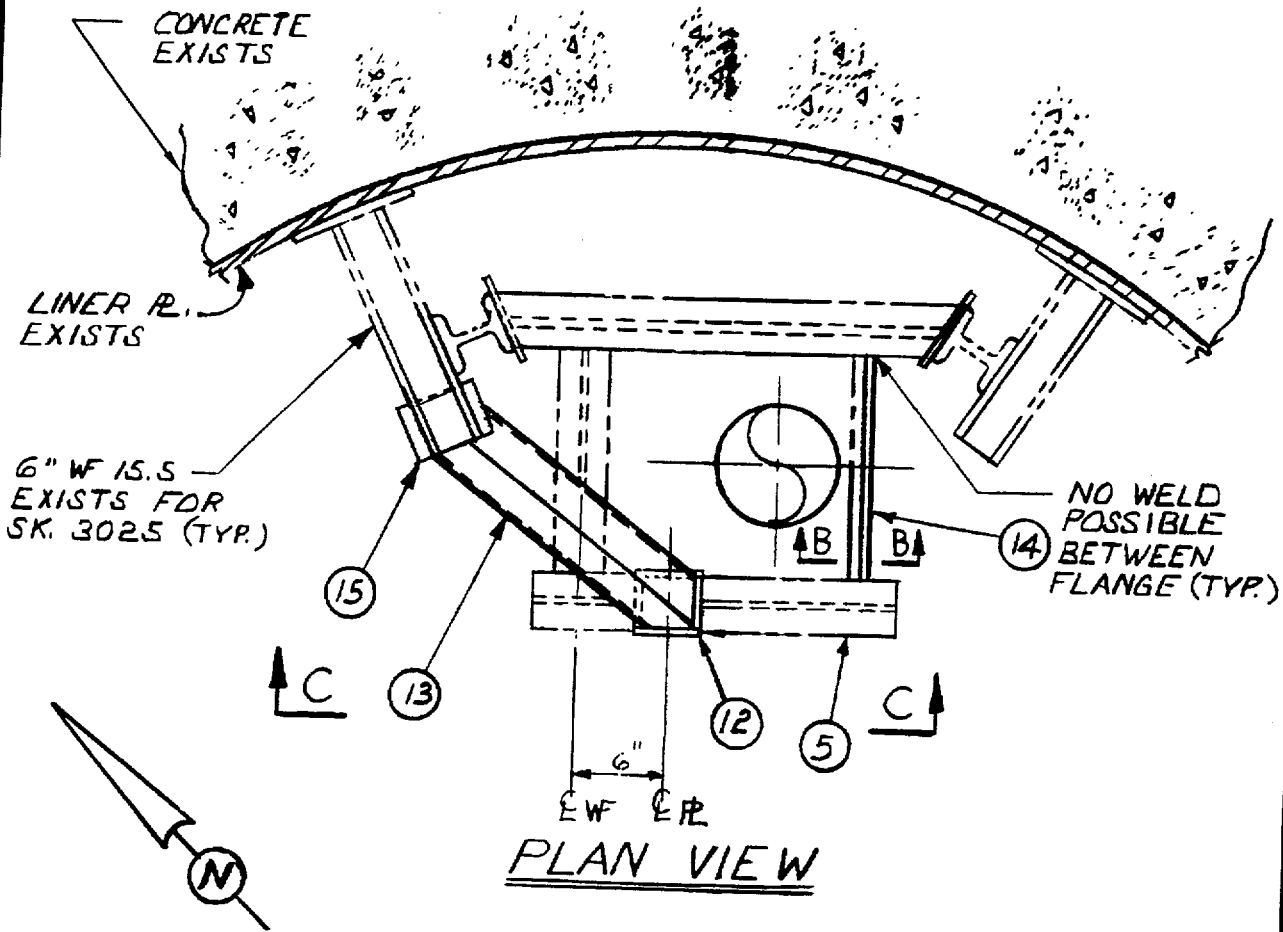
Revision 3

RTYPE: L1.09

SOUTHERN NUCLEAR OPERATING COMPANY

ANTI REVIEW: LGW and 3/25/00

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.



NOTE: PLATES FOR CS5-R26 ARE
TO ATTACHED BEFORE ITEM NO. 4

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CAD B5280808.DWG

R140VY2 RVL - 01

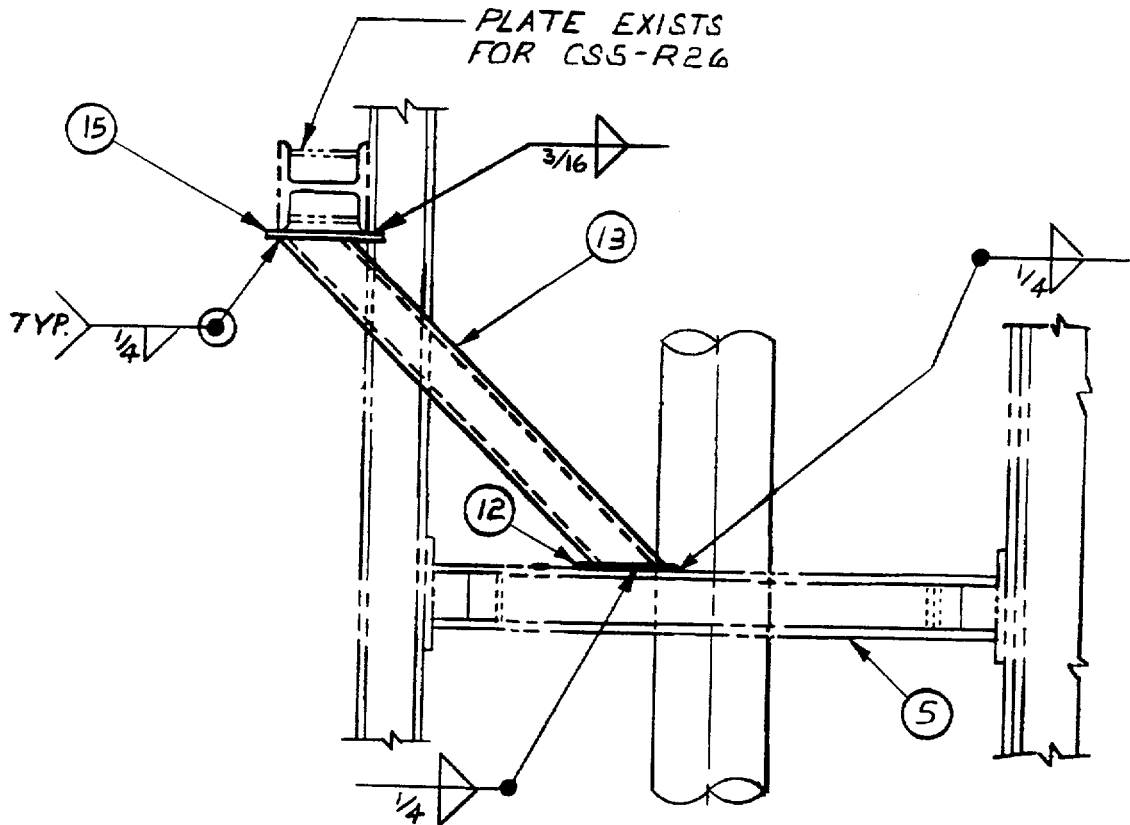
0	2/8/00	RVL	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW				
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR. 1	APPR. 2	APPR. 3	APPR. 4	APPR. 5

Southern Company Services, Inc. FOR ALABAMA POWER COMPANY

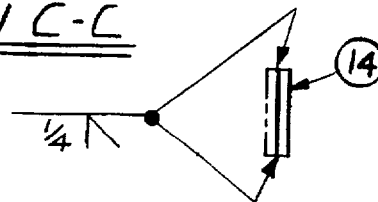
FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DVG. NO. B-528080 SH. 8 REV. 0
MARK NO. CS-R142 SH. 1 OF 5
SKETCH NO. 3141

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.



SECTION C-C



SECTION B-B

CAD B5280809.DWG

R140VY2

RVL - 01

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REV.	DATE	BY	CHK'D	DESCRIPTION	APPR. 1	APPR. 2	APPR. 3	APPR. 4	APPR. 5
0	2/8/00	RVL	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW				

Southern Company Services, Inc. FOR ALABAMA POWER COMPANY

FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DWG. NO. B-528080 SH. 9 REV. 0
MARK NO. CS-R142 SH. 2 OF 5
SKETCH NO. 3141 A

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.

ITEM NO.	QTY.	DESCRIPTION	MATERIALS
1-11	-	Exist	
12	1	3/8" x 6" x 6" C.S. Plate	ASTM A-36
13	1	T.S. 4" x 4" x 1/4" (CUT TO SUT)	ASTM A-500
14	1	1" x 5 1/2" x 23 5/8" C.S. Plate	ASTM A-36
15	1	3/8" x 7" x 7" C.S. Plate	ASTM A-36
3	8	Traceable Stainless Steel Lugs 1" x 2 1/2" x 2 3/4" Long	ASTM A-240, TYPE 304

CAD 52808010.DWG

R140VY2 RVL- 01

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0	2/8/00	RVL	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW					
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR. 1	APPR. 2	APPR. 3	APPR. 4	APPR. 5	

Southern Company Services, Inc. FOR ALABAMA POWER COMPANY

FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DWG. NO. B-528080 SH.10 REV. 0
MARK NO. CS-R142 SH. 3 OF 5
SKETCH NO. 3141 B

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.

CAD 52808011.DWG

R14DVY2

RVL - 01

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0	2/8/00	RVL	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW				
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR. 1	APPR. 2	APPR. 3	APPR. 4	APPR. 5

Southern Company Services, Inc. FOR ALABAMA POWER COMPANY

FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DVG. NO. B-528080 SH. 11 REV. 0
MARK NO. CS-R142 SH. 4 OF 5
SKETCH NO. 3141C

NOTE:
FOR NOTES & REFERENCES SEE SHEET 1.

CAD 52808012.DWG

R140VY2

RVL - 01

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0	2/8/00	RVL	JAR	APPROVED PER ABN 00-1-1668, REV. 0	DEW				
REV.	DATE	BY	CHK'D	DESCRIPTION	APPR.1	APPR.2	APPR.3	APPR.4	APPR.5

Southern Company Services, Inc. FOR ALABAMA POWER COMPANY

FARLEY NUCLEAR PLANT UNIT 1
CONTAINMENT SPRAY SYSTEM - E13
HANGER INFORMATION

SCS DWG. NO. B-528080 SH.12 REV. 0
MARK NO. CS-R142 SH. 5 OF 5
SKETCH NO. 3141 D

ITT Grinnell

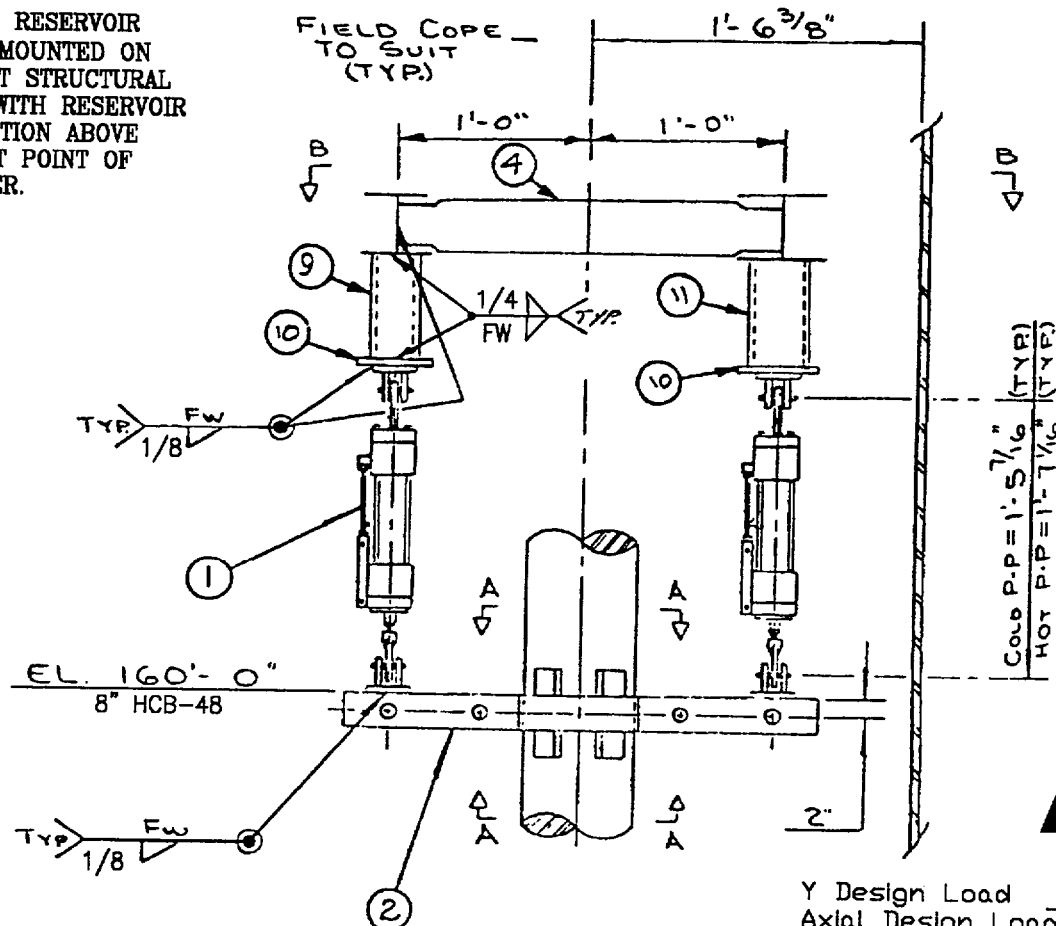
CUSTOMER ALABAMA POWER CO.
 ORDER OR CONT. NO. P.O. #FP-222
 JOB NAME FARLEY NUC. STA. UNIT #1

CHECK BY JRZ DATE 6-4-06
 DRAWN BY EJS DATE 6-7-06

REV.	1	2	3	4	5
ENG	110	111	112	113	114
DATE	8-21-03	9-11-03	1-21-04		

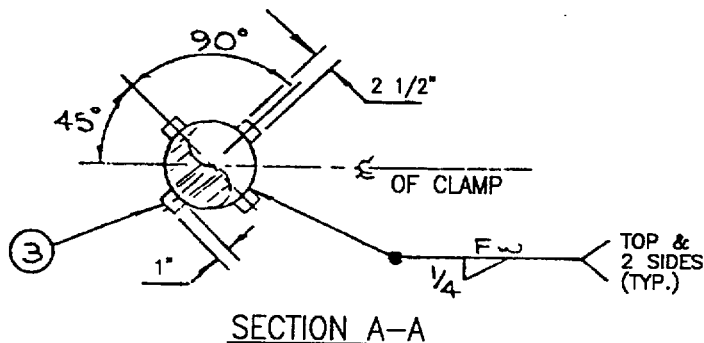
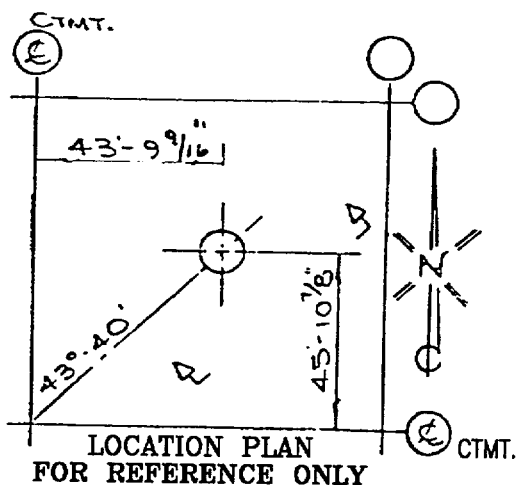
NOTE:

REMOTE RESERVOIR
 TO BE MOUNTED ON
 NEAREST STRUCTURAL
 STEEL WITH RESERVOIR
 CONNECTION ABOVE
 HIGHEST POINT OF
 CYLINDER.



ABDS

Y Design Load = 7000#
 Axial Design Load = 0
 Lat'l. Design Load = 0
 ISO. #: 80
 Prob. #: 4A
 Critical:



"AS-BUILT"

FOR MATERIALS AND OPERATIONS SEE SKETCH NO. 3141 B REV. _____

SHEET 1 OF 5

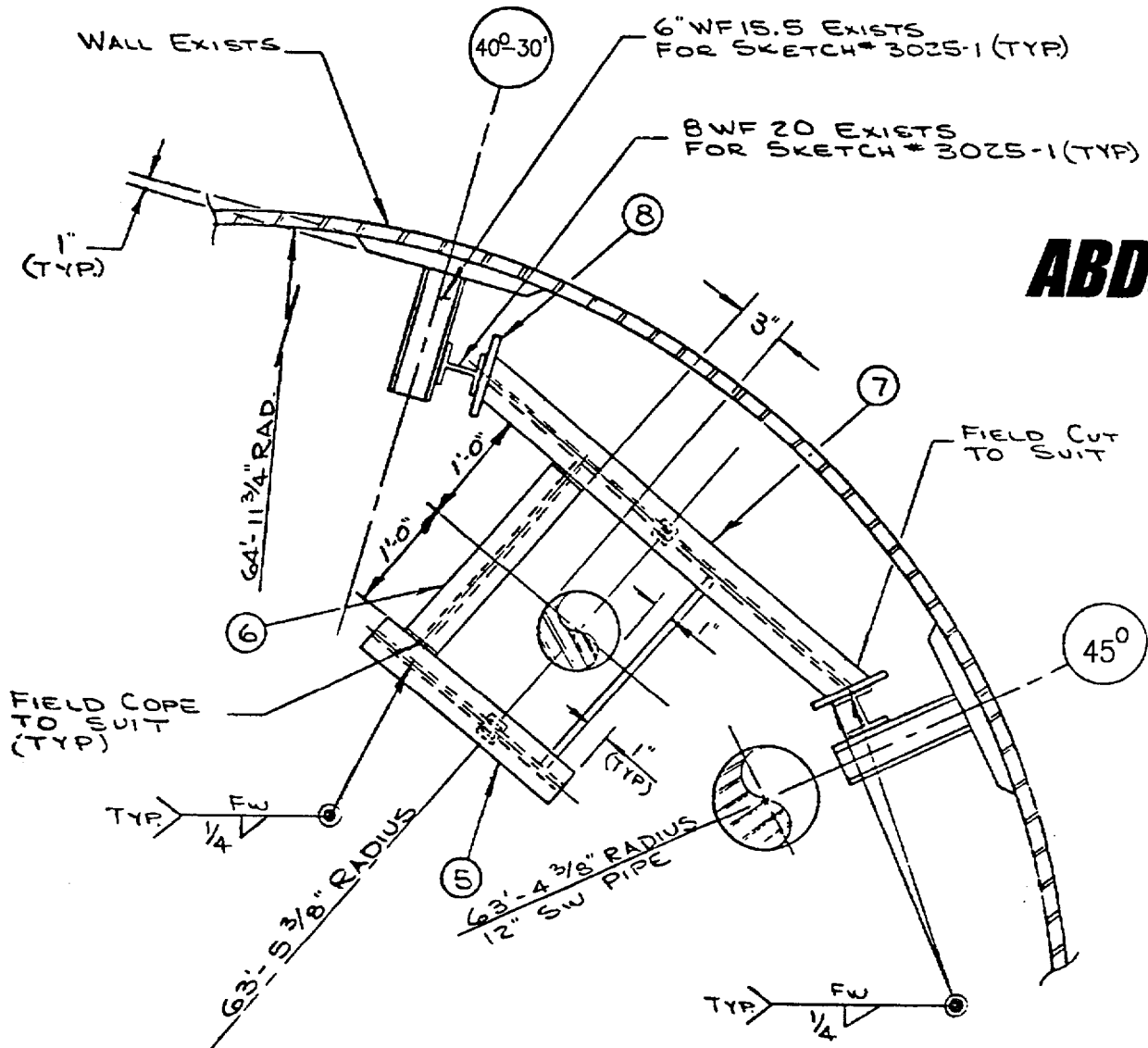
DRW'G. NO'S. PIPE: D-175378 MARK NO. CS-R142 SKETCH NO. 3141 REV. _____ ISO. NO. 80
 STEEL: D-176154

ITT Grinnell

ENG BY VLS DATE 6-7-75
 CHECK BY JRZ DATE 6-9-75
 DRAWN BY EJS DATE 6-4-75

CUSTOMER ATLANTA FWP CO.
 ORDER OR CONT. NO. P.O. #FWP-222
 JOB NAME FARLEY NUC. STA. UNIT #1

REV.	1	2	3	4	5
ENG					
DATE	<u>6-21-75</u>				



ABDS

SECTION B-B

"AS-BUILT"

FOR MATERIALS AND OPERATIONS SEE SKETCH NO. 3141 B REV. _____

SHEET 2 OF 5

DRW'G. NO'S. PIPE: D-175378 MARK NO. CS-R142 SKETCH NO. 3141 A REV. _____ ISO. NO. 80
 STEEL: D-176154

ITT Grinnell

PIPE HANGER DEPARTMENT

ENG BY _____ DATE _____

CHECK BY _____ DATE _____

DRAWN BY SS DATE 1-2-79

CUSTOMER ALABAMA PWR. CO.
 ORDER OR CONT. NO. P.O.#FNP-222
 NAME FARLEY NUC. STA. UNIT #1

REV.	1	2	3	4	5
ENG					
DATE					

SEISMIC SHOCK & SWAY SUPPRESSOR CONSISTING OF: ONE

- 1 2 1/2" Cylinder, 5" Stroke, Fig. 200, Option #2, _____ 2
 Hydraulic Shock & Sway Suppressor, Load=3,500#, Cold
 Piston Setting=2 11/16", Hot Piston Setting=4 5/16",
 per PH-74, w/Manifold System/Sketch# 3141-C
- 2 H.S. 40, "A", Carbon Steel, A-36, 8 5/8" O.D. Pipe, _____ 1
 Developed Length/Half Clamp=2'-9 11/16", E=1'-0",
 F=1"x5", G=1"x6", S=1 3/4", K=3 7/16", TW=122#
- 3 Traceable Stainless Steel Lugs/Sketch 3141-D, TW=16# _____ 8
- 4 1"x6" Carbon Steel Plate, 1'-11 5/8" long, TW=40# _____ 1
- 5 6" Wide Flange @ 15.5#/ft., 1'-9 3/4" long, TW=28# _____ 1
- 6 6" Wide Flange @ 15.5#/ft., 2'-11 5/8" long, TW=31# _____ 1
- 7 6" Wide Flange @ 15.5#/ft., 3'-1 1/4" long, TW=48# _____ 1
- 8 1/2"x8" Carbon Steel Plate, 0'-8" long, TW=9# _____ 1
- 9 1/2"x4"x4" Structural Tubing, 1'-0 1/4" long, TW=21# _____ 1
 HT# 23139
- 10 1/2"x5 3/8" Carbon Steel Plate, 0'-5 3/8" long, TW=9# _____ 2
 P.O. Y-63376
- 11 1/2"x4"x4" Structural Tubing, 1'-0 1/16" long, TW=21# _____ 1
 HT# 23139

SEISMIC ASSEMBLY SKETCH & ENGINEERING _____ 1
 BUNDLE & TAG _____ 1
 MARK# CS-R142

Apply Dimetecote #6 Primer To All Above Material
 Except Threads, Which Shall Be Greased.

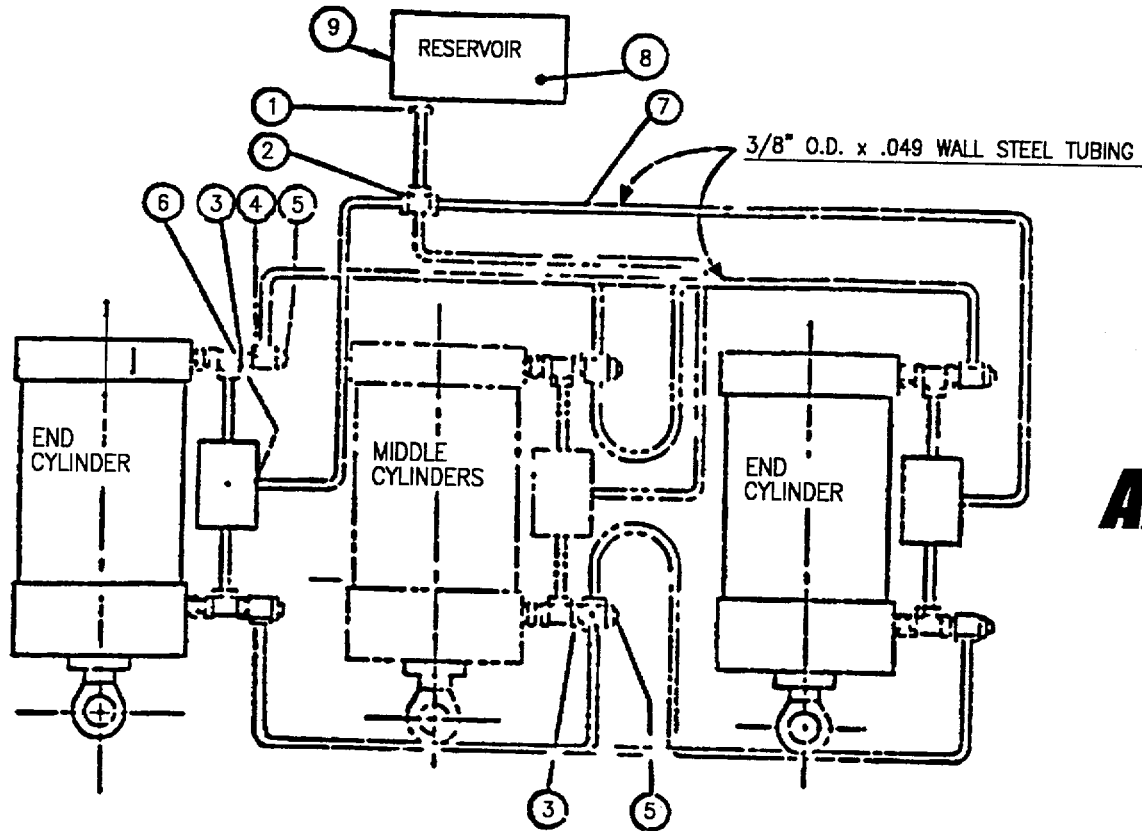
ABDS

FOR MATERIALS AND OPERATIONS SEE SKETCH NO. 3141 REV. _____

SHEET 3 OF 5

EF. DRW'G. NO'S. PIPE: D-175378 MARK NO. CS-R142 SKETCH NO. 3141 B REV. _____ ISO. NO. 80
 STEEL: D-176154

ITT Grinnell



ABDS

ITEM NO.	MATERIALS AND OPERATIONS	QUAN.	SHIP.
	MANIFOLDING LAYOUT CONSISTING OF:	ONE	
1	Swagelok Male Connector #S600-1-8	1	
2	Swagelok Union Tee #S600-3	1	
3	Swagelok Male Adapter #S601-4-6	4	
4	Swagelok Union Tee #S600-3	4	
5	Swagelok Plug #S600P	4	
6	Swagelok Male Connector #S600-1-4	1	
7	Ft. of 3/8" x .049 Wall St. Hyd. Tubing	25	
8	Gallon(s) G.E. Silicone Fluid SF-1154	1	
9	Oil Lite Reservoir B-770-1	1	
	MK. # CS-R142		

ABDS

FOR MATERIALS AND OPERATIONS SEE SKETCH NO. _____ REV. _____

SHEET 4 OF 5

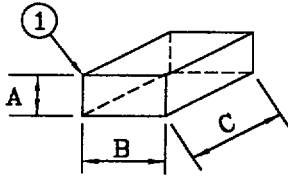
REF. DRW'G. NO'S. PIPE: D-175378 MARK NO. CS-R142 SKETCH NO. 3141C REV. _____ ISO. NO. 80
STEEL: D-176154

ITT Grinnell

CUSTOMER BARLEY NUC STA. UNIT #1
ORDER OR CONT No P.O. #FIP-222
JOB NAME BARLEY NUC STA. UNIT #1

CHECK BY WES DATE 6-9-75
DRAWN BY WES DATE 6-9-75

REV	1	2	3	4	5
ENG	DATE				



Mark Number	Sketch Number	"A"	"B"	"C"	QUAN.
CS-R142	3141	1"	2 1/2"	2 3/4"	8

ABDS

[illegible]

FOR MATERIALS AND OPERATIONS SEE SKETCH NO. _____ REV. _____

SHEET 5 OF 5

TF. DRW'G. NO'S. PIPE: D-175378 MARK NO. CS-R142 SKETCH NO. 3141 D REV. ISO. NO. 80
STEEL: D-176154

SHARED

FNP-0-NDE-100.5

PT-F-Form 001

Farley Nuclear Plant

Liquid Penetrant Examination Record

Southern Nuclear Operating Company

Unit 1	Component Number ALA2-4707-CS-R142 (WS)	Procedure/Rev./TCN FNP-0-NDE-100.5 / 6 / N/A	Sheet No. S00F1P005
Thermometer Mfg. / Ser. No. PTC / 38180 Cal. Due Date 8/27/2000 Surface Temp. 75 °F		Penetrant Materials Manufacturer MAGNAFLUX Cleaner/Remover SKC-S Penetrant SKL-SP Developer SKD-S2 Type SKC-S Batch 96J05K 93D12K 93J02P	
Component Configuration WELDED ATTACHMENT		% of Length Coverage 100 % of Area Coverage 100	Date 3/15/00
Ind. No.	Results	Indication Desc. / Exam Limitations / etc.	Remarks
NA	NI	NA	NA

Remarks:

Primary Examiner JOHN W. BELL	ASNT Level II	Initials <i>gwb</i>	Assistant Examiner N/A	ASNT Level N/A	Initials	Non-Technical Review <i>Lynda Duke</i>	Date 3-16-00
SNC NDE Level II/III Review <i>Wayne Carls L/III</i>		Date 3-16-00	Percentage of Code Coverage 100 %	ANII Review <i>gwb</i>		Date 3/17/00	

Figure 1

Revision 6