



GE Nuclear Energy

GERIS 2000 Examination Summary Sheet

Project: TVA, Browns Ferry Nuclear Plant, Unit 3

System: Reactor Pressure Vessel

Weld ID: V-5-C

ASME Code Category: B-A

Calibration Sheets: G-004 C-001 mcd 1-26-94

Supporting Data: Examination Data Sheets E-19-00 thru E-19-03, Indication Data Sheets 19-001 thru 19-004, G-113, G-114, Indication Evaluation Sheets, Screen Prints, Exam Patch Location Map, Exam Coverage Plots, and GERIS 2000 Setup Records.

Examination Summary

The ultrasonic examination of weld V-5-C resulted in no recorded indications that exceed the allowable standards of IWB-3500, ASME Section XI, 1986 Edition, No Addenda.

The ASME Section XI required examination volume was examined with the GERIS 2000 System from the RPV inside surface utilizing Procedure No. GE-UT-700, Rev. 2. The total examination coverage was calculated to be 100%.

The GERIS 2000 utilizes an array of search units arranged to effectively examine the weld and adjacent base material parallel and perpendicular to the weld axis in two directions. The transducer package consisted of 0° longitudinal, 45° and 60° shear wave, and 70° refracted longitudinal (RL) wave search units.

The GERIS 2000 recorded indications with the 70° RL and 60° shear wave scans that were evaluated and found to be acceptable per the referencing Code section. Geometric indications from the flange radius were recorded with the 45° and 60° shear wave scans.

Fabrication records and previous examination results were reviewed prior to the completion of this examination summary.

| | |
|---|--|
| GERIS Analyst: <i>Jeresa Kimball</i> | GE Reviewer: <i>Clay M.D.</i> |
| LEVEL: <i>III</i> DATE: <i>12-14-93</i> | LEVEL: <i>III</i> DATE: <i>12/15/93</i> |
| UTILITY Review: <i>J. Woodly</i> | ANII Review: |
| TITLE: <i>III</i> DATE: <i>1/26/94</i> | TITLE: <i>Albert Ladd</i> DATE: <i>7/13/94</i> |



GE Nuclear Energy

GERIS 2000 Examination
Data Sheet

R1171

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Exam Data Sheet: E-19-00

Procedure No.: GE-UT-700
Revision No.: 2
FRR No.: N/A

| Patch | Data Sh. | Date | Start | Stop | Min X | Max X | Min Y | Max Y | Disk No. | Examiner |
|---------|----------|---------|-------|------|--------|--------|--------|--------|----------|----------|
| BF-046 | E-19-01 | 10/6/93 | 1013 | 1212 | 708.75 | 736.60 | 566.00 | 639.50 | 27A | ROF |
| BF-047A | E-19-02 | 10/6/93 | 1835 | 2017 | 708.75 | 736.5 | 639.50 | 678.00 | 27B | JCG |
| BF-047B | E-19-03 | 10/7/93 | 0201 | 0343 | 708.75 | 736.50 | 678.00 | 717.00 | 28A | ROF |
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Comments: N/A

Limitations: None

Analyst: Chesa Kimball
Level: III Date: 12-14-93

Reviewed By: R.O. Forman
Level: II Date: 12-15-93

21171



GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Cal. ID: C-001

Exam Data Sheet No.: E-19-01
Patch ID: BF-046
Ind. Data Sheet Series: 19-000

| Channel | Angle | Direction | Ind. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sheet |
|---------|-------|-----------|------|---------------|---------------|---------------|---------------|-----------------|
| 1 | 0 WM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 2 | 0 WM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 3 | 70 RL | 0 UP | 1 | 19-002 | ~ | ~ | ~ | ~ |
| 4 | 70 RL | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 5 | 70 RL | 180 DN | 1 | 19-001 | ~ | ~ | ~ | ~ |
| 6 | 70 RL | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 7 | 45 RS | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 8 | 45 RS | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 9 | 45 RS | 180 DN | NRI | ~ | ~ | ~ | ~ | ~ |
| 10 | 45 RS | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 11 | 60 RS | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 12 | 60 RS | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 13 | 60 RS | 180 DN | NRI | ~ | ~ | ~ | ~ | ~ |
| 14 | 60 RS | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 15 | 0 BM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 16 | 0 BM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
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Comments: N/A

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number
Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: Debra Kimball

Reviewed By: R.O. Foman

Level: III **Date:** 12-14-93

Level: II **Date:** 12-15-93

R1171



GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Cal. ID: C-001

Exam Data Sheet No.: E-19-02
Patch ID: BF-047A
Ind. Data Sheet Series: 19-000

| Channel | Angle | Direction | Ind. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sheet |
|---------|-------|-----------|------|---------------|---------------|---------------|---------------|-----------------|
| 1 | 0 WM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 2 | 0 WM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 3 | 70 RL | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 4 | 70 RL | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 5 | 70 RL | 180 DN | NRI | ~ | ~ | ~ | ~ | ~ |
| 6 | 70 RL | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 7 | 45 RS | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 8 | 45 RS | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 9 | 45 RS | 180 DN | NRI | ~ | ~ | ~ | ~ | ~ |
| 10 | 45 RS | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 11 | 60 RS | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 12 | 60 RS | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 13 | 60 RS | 180 DN | NRI | ~ | ~ | ~ | ~ | ~ |
| 14 | 60 RS | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 15 | 0 BM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 16 | 0 BM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
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Comments: N/A

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number
 Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: Jessica Kimball
 Level: III Date: 12-14-93

Reviewed By: R.O. Foman
 Level: II Date: 12-15-93

R1171



GE Nuclear Energy

GERIS 2000 Examination Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Cal. ID: C-001

Exam Data Sheet No.: E-19-03
Patch ID: BF-047B
Ind. Data Sheet Series: 19-000

| Channel | Angle | Direction | Ind. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sh. | Ind. Data Sheet |
|---------|-------|-----------|------|------------------|------------------|------------------|------------------|--------------------|
| 1 | 0 WM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 2 | 0 WM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 3 | 70 RL | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 4 | 70 RL | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 5 | 70 RL | 180 DN | 1 | 19-003 | ~ | ~ | ~ | ~ |
| 6 | 70 RL | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 7 | 45 RS | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 8 | 45 RS | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 9 | 45 RS | 180 DN | 5 | G-113 | ~ | ~ | ~ | ~ |
| 10 | 45 RS | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 11 | 60 RS | 0 UP | NRI | ~ | ~ | ~ | ~ | ~ |
| 12 | 60 RS | 90 CW | NRI | ~ | ~ | ~ | ~ | ~ |
| 13 | 60 RS | 180 DN | 1, 5 | 19-004 | G-114 | ~ | ~ | ~ |
| 14 | 60 RS | 270 CCW | NRI | ~ | ~ | ~ | ~ | ~ |
| 15 | 0 BM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
| 16 | 0 BM | N/A | NRI | ~ | ~ | ~ | ~ | ~ |
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Comments: 5 = Flange radius geometry

Data Sheet Codes: G-XXX; "G" = Geometry (may be typical), 6-XXX; "6" = Weld Sequence, XXX = Sheet Number

Indication Codes: 1 = Flaw, 2 = OD Surface, 3 = OD Attachment, 4 = Nozzle, 5 = Other

Analyst: Jessie Kimball

Reviewed By: R.O. Forman

Level: III Date: 12-14-93

Level: II Date: 12-15-93



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
 Weld ID: V-5-C
 Cal. ID: C-001

Exam Data Sheet No.: E-19-01
 Patch ID: BF-046
 Ind. Data Sheet No.: 19-001

Indication: 19-001 Channel: 5 Angle: 70 Direction: 180

| Amp. | X | 20% Min Y | TOF | 50% Min Y | TOF | @ Max Y | TOF | 50% Max Y | TOF | 20% Max Y | TOF | Remarks |
|-------|--------|-----------|-----|-----------|-----|---------|-------|-----------|-----|-----------|-----|---------|
| 23.7% | 724.35 | ~ | ~ | ~ | ~ | 574.95 | 20.24 | ~ | ~ | ~ | ~ | ~ |
| 28.6% | 724.60 | ~ | ~ | ~ | ~ | 574.70 | 18.16 | ~ | ~ | ~ | ~ | ~ |
| 10.5% | 724.85 | ~ | ~ | ~ | ~ | 574.70 | 18.32 | ~ | ~ | ~ | ~ | ~ |
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Comments: Thruwall size was determined by the PATT technique.

TW = 0.24 L = 0.75 S = 0.75 with clad

Analyst: Debra Kimball
 Level: III Date: 12-14-93

Reviewed By: R.O. Forman
 Level: II Date: 12-15-93

21171



GE Nuclear Energy

GERIS 2000 Indication Evaluation Sheet

Project: TVA, Browns Ferry Unit 3
Weld ID: V-5-C
Patch: BF-046

Exam Data Sheet No.: E-19-01
Ind. Data Sheet No.: 19-001
Indication: 19-001

Flaw Thruwall Dimension = 0.24
Flaw Length "l" = 0.75
Separation with clad "S" = 0.75
Surface Separation "S" = 0.56

T nominal = 6.38
Clad T nominal = 0.19

Flaw is acceptable by Table IWB-3510-1

ASME Section XI, 1986 Edition TABLE IWB-3510-1 for 4" to 12"

| a/l | Surface % | Subsurface % | Surface % | Subsurface % |
|------|-----------|--------------|-----------------|-----------------|
| 0.00 | 1.90 | 2 | ~ | ~ |
| 0.05 | 2.00 | 2.2 | ~ | ~ |
| 0.10 | 2.20 | 2.5 | ~ | ~ |
| 0.15 | 2.50 | 2.9 | 2.57 | 3.00 Y |
| 0.20 | 2.80 | 3.3 | ~ | ~ |
| 0.25 | 3.30 | 3.8 | ~ | ~ |
| 0.30 | 3.80 | 4.4 | ~ | ~ |
| 0.35 | 4.40 | 5.1 | ~ | ~ |
| 0.40 | 5.00 | 5.8 | ~ | ~ |
| 0.45 | 5.10 | 6.7 | ~ | ~ |
| 0.50 | 5.20 | 7.6 | ~ | ~ |
| | | | Allowed 2.57 | Allowed 3.00 |

a = 0.122
a/l value = 0.162
Y = 1.000

Flaw is Subsurface

Allowed a/t = 3.00%
a/t = 1.90%

Comments:

2111



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Cal. ID: C-001

Exam Data Sheet No.: E-19-01
Patch ID: BF-046
Ind. Data Sheet No.: 19-002

Indication: 19-002 Channel: 3 Angle: 70 Direction: 0

| Amp. | X | 20% Min Y | TOF | 50% Min Y | TOF | @ Max Y | TOF | 50% Max Y | TOF | 20% Max Y | TOF | Remarks |
|-------|--------|--------------|-----|--------------|-----|------------|-------|--------------|-----|--------------|-----|---------|
| 15.3% | 724.40 | ~ | ~ | ~ | ~ | 569.75 | 31.68 | ~ | ~ | ~ | ~ | ~ |
| 23.7% | 724.65 | ~ | ~ | ~ | ~ | 569.75 | 31.92 | ~ | ~ | ~ | ~ | ~ |
| 15.3% | 724.90 | ~ | ~ | ~ | ~ | 570.00 | 29.92 | ~ | ~ | ~ | ~ | ~ |
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Comments: No apparent tip signals.
Indication has no determinable thruwall and is acceptable to IWB-3510-1.

Analyst: Deessa Kimball
Level: III Date: 12-14-93

Reviewed By: R.O. Forman
Level: II Date: 12-15-93

R1171



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Cal. ID: C-001

Exam Data Sheet No.: E-19-03
Patch ID: BF-047B
Ind. Data Sheet No.: 19-003

Indication: 19-003 **Channel:** 5 **Angle:** 70 **Direction:** 180

| Amp. | X | 20% Min Y | TOF | 50% Min Y | TOF | @ Max Y | TOF | 50% Max Y | TOF | 20% Max Y | TOF | Remarks |
|-------|--------|--------------|-----|--------------|-----|------------|-------|--------------|-----|--------------|-----|---------|
| 13.5% | 724.10 | ~ | ~ | ~ | ~ | 709.45 | 28.96 | ~ | ~ | ~ | ~ | ~ |
| 17.3% | 724.35 | ~ | ~ | ~ | ~ | 709.70 | 30.56 | ~ | ~ | ~ | ~ | ~ |
| 9.9% | 724.60 | ~ | ~ | ~ | ~ | 709.70 | 30.56 | ~ | ~ | ~ | ~ | ~ |
| 16.3% | 724.85 | ~ | ~ | ~ | ~ | 708.70 | 23.20 | ~ | ~ | ~ | ~ | ~ |
| 14.4% | 725.10 | ~ | ~ | ~ | ~ | 708.70 | 23.12 | ~ | ~ | ~ | ~ | ~ |
| 10.5% | 725.35 | ~ | ~ | ~ | ~ | 709.20 | 26.48 | ~ | ~ | ~ | ~ | ~ |
| 19.6% | 725.60 | ~ | ~ | ~ | ~ | 709.95 | 32.56 | ~ | ~ | ~ | ~ | ~ |
| 25.2% | 725.85 | ~ | ~ | ~ | ~ | 709.95 | 32.32 | ~ | ~ | ~ | ~ | ~ |
| 25.2% | 726.10 | ~ | ~ | ~ | ~ | 709.70 | 30.56 | ~ | ~ | ~ | ~ | ~ |
| 25.2% | 726.35 | ~ | ~ | ~ | ~ | 709.70 | 30.88 | ~ | ~ | ~ | ~ | ~ |
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Comments: No apparent tip signals.
Indication has no determinable thruwall and is acceptable to IWB-3510-1.

Analyst: Debra Kimball
Level: III **Date:** 12-14-93

Reviewed By: Randall O. Forman
Level: II **Date:** 12-15-93

R1171



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3

Weld ID: V-5-C

Cal. ID: C-001

Exam Data Sheet No.: E-19-03

Patch ID: BF-047B

Ind. Data Sheet No.: G-113

Indication: G-113

Channel: 9

Angle: 45

Direction: 180

| Amp. | X | 20% Min Y | MP | 50% Min Y | MP | @ Max Y | MP | 50% Max Y | MP | 20% Max Y | MP | Remarks |
|-------|--------|--------------|----|--------------|----|------------|-------|--------------|----|--------------|----|---------|
| 39.1% | 723.40 | ~ | ~ | ~ | ~ | 714.50 | 10.70 | ~ | ~ | ~ | ~ | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
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Comments: Geometric indication due to flange radius.

Analyst: Dorena Kimball

Level: III **Date:** 12-14-93

Reviewed By: R.O. Forman

Level: II **Date:** 12-15-93



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
Weld ID: V-5-C
Cal. ID: C-001

Exam Data Sheet No.: E-19-03
Patch ID: BF-047B
Ind. Data Sheet No.: 19-004

Indication: 19-004

Channel: 13

Angle: 60

Direction: 180

| Amp. | X | 20% Min Y | MP | 50% Min Y | MP | @ Max Y | MP | 50% Max Y | MP | 20% Max Y | MP | Remarks |
|-------|--------|--------------|------|--------------|----|------------|------|--------------|----|--------------|------|---------|
| 18.5% | 724.29 | ~ | ~ | ~ | ~ | 709.20 | 3.14 | ~ | ~ | ~ | ~ | ~ |
| 23.7% | 724.54 | ~ | ~ | ~ | ~ | 709.20 | 3.14 | ~ | ~ | ~ | ~ | ~ |
| 25.2% | 724.79 | ~ | ~ | ~ | ~ | 709.20 | 3.11 | ~ | ~ | ~ | ~ | ~ |
| 19.6% | 725.04 | ~ | ~ | ~ | ~ | 709.20 | 3.11 | ~ | ~ | ~ | ~ | ~ |
| 26.9% | 725.29 | ~ | ~ | ~ | ~ | 709.20 | 3.07 | ~ | ~ | ~ | ~ | ~ |
| 18.5% | 725.54 | ~ | ~ | ~ | ~ | 709.20 | 3.14 | ~ | ~ | ~ | ~ | ~ |
| 32.4% | 725.79 | 708.45 | 2.52 | ~ | ~ | 709.45 | 3.47 | ~ | ~ | 709.70 | 3.66 | ~ |
| 50.2% | 726.04 | 708.45 | 2.56 | ~ | ~ | 708.70 | 2.74 | ~ | ~ | 709.95 | 3.92 | ~ |
| 44.3% | 726.29 | ~ | ~ | ~ | ~ | 708.70 | 2.78 | ~ | ~ | 709.70 | 3.66 | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
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| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |

Comments: Thruwall size was determined by the SPOT technique.
Same indication as seen with Ch. 5 (see 19-003).

TW = 0.28 L = 2.00 S = 1.23 with clad

Analyst: Drewa Kimball
Level: III Date: 12-14-93

Reviewed By: R.O. Forman
Level: II Date: 12-15-93



GE Nuclear Energy

GERIS 2000 Indication Evaluation Sheet

Project: TVA, Browns Ferry Unit 3
Weld ID: V-5-C
Patch: BF-047B

Exam Data Sheet No.: E-19-03
Ind. Data Sheet No.: 19-004
Indication: 19-004

Flaw Thruwall Dimension = 0.28
Flaw Length "I" = 2.00
Separation with clad "S" = 1.23
Surface Separation "S" = 1.04

T nominal = 6.38
Clad T nominal = 0.19
% of Allowable = 0.95

Flaw is acceptable by Table IWB-3510-1

ASME Section XI, 1986 Edition TABLE IWB-3510-1 for 4" to 12"

| a/l | Surface % | Subsurface % | Surface % | Subsurface % |
|------|-----------|--------------|-----------------|-----------------|
| 0.00 | 1.90 | 2 | ~ | ~ |
| 0.05 | 2.00 | 2.2 | 2.08 | 2.32 Y |
| 0.10 | 2.20 | 2.5 | ~ | ~ |
| 0.15 | 2.50 | 2.9 | ~ | ~ |
| 0.20 | 2.80 | 3.3 | ~ | ~ |
| 0.25 | 3.30 | 3.8 | ~ | ~ |
| 0.30 | 3.80 | 4.4 | ~ | ~ |
| 0.35 | 4.40 | 5.1 | ~ | ~ |
| 0.40 | 5.00 | 5.8 | ~ | ~ |
| 0.45 | 5.10 | 6.7 | ~ | ~ |
| 0.50 | 5.20 | 7.6 | ~ | ~ |
| | | | Allowed 2.08 | Allowed 2.32 |

a = 0.140
a/l value = 0.070
Y = 1.000

Flaw is Subsurface

Allowed a/t = 2.32%
a/t = 2.19%

Comments:

21171



GE Nuclear Energy

GERIS 2000 Indication Data Sheet

Project: TVA, Browns Ferry, Unit 3
 Weld ID: V-5-C
 Cal. ID: C-001

Exam Data Sheet No.: E-19-03
 Patch ID: BF-047B
 Ind. Data Sheet No.: G-114

Indication: G-114 Channel: 13 Angle: 60 Direction: 180

| Amp. | X | 20% Min Y | MP | 50% Min Y | MP | @ Max Y | MP | 50% Max Y | MP | 20% Max Y | MP | Remarks |
|--------|--------|-----------|----|-----------|----|---------|-------|-----------|----|-----------|----|---------|
| 449.3% | 723.79 | ~ | ~ | ~ | ~ | 716.95 | 12.53 | ~ | ~ | ~ | ~ | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
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| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
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| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
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| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |
| ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ | ~ |

Comments: Geometric indication due to flange radius.

Analyst: Deesa Kimball
 Level: III Date: 12-14-93

Reviewed By: R.O. Foiman
 Level: II Date: 12-15-93

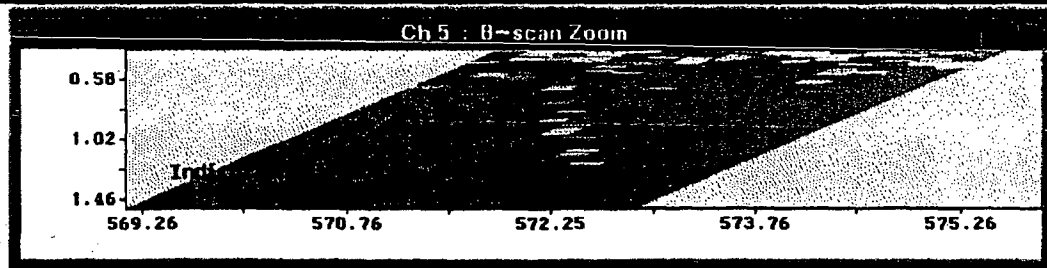
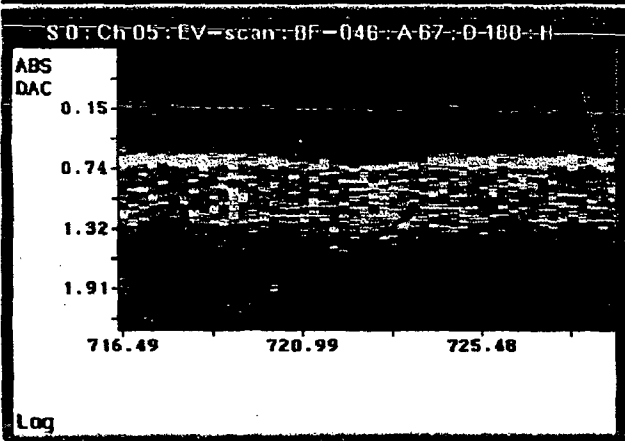
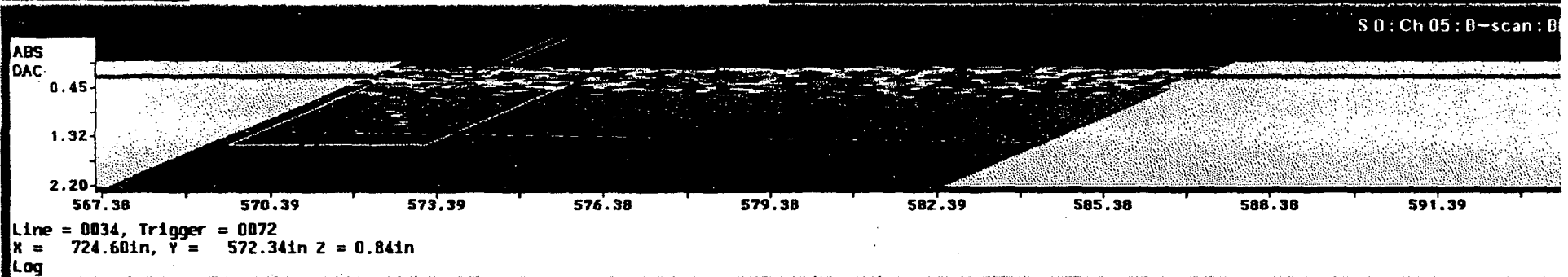
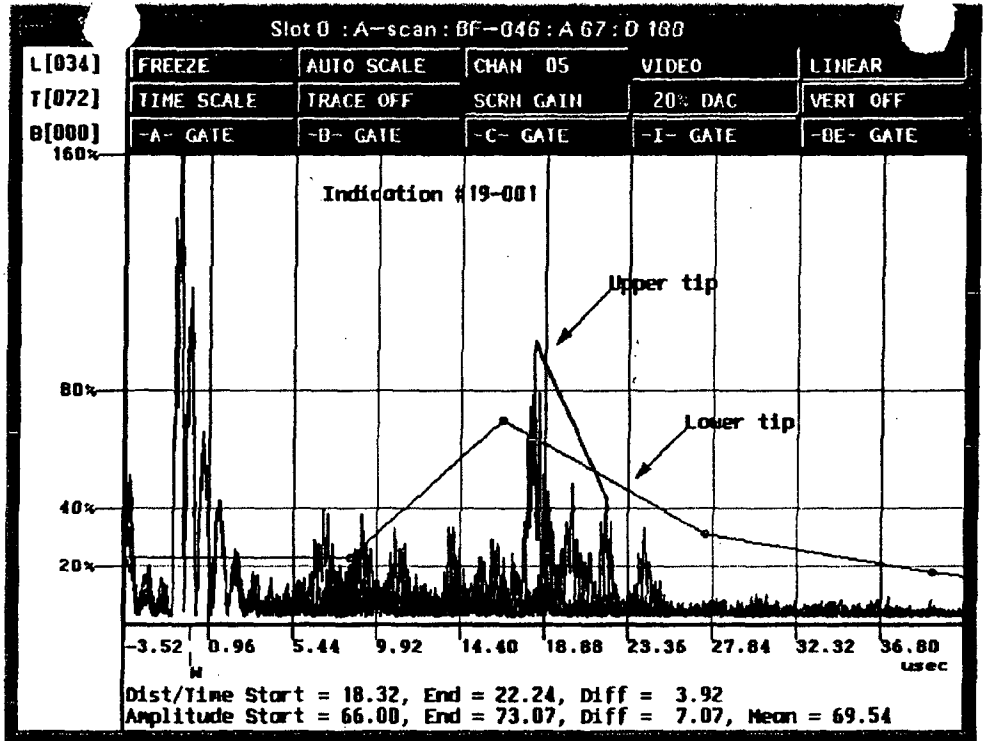
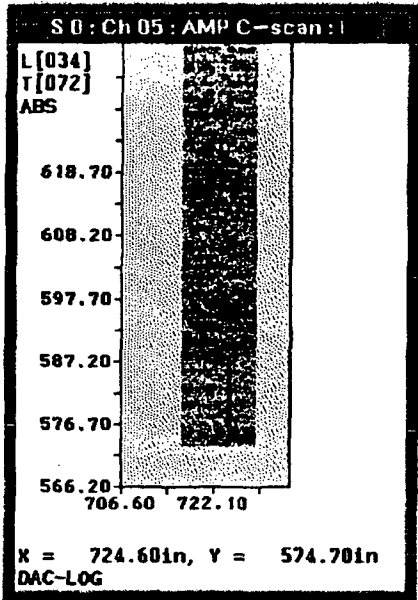
S 0 : Scale

32.3
36.6
41.0
45.3
49.7
54.0
58.4
62.7
67.1
71.4
75.8
80.1
84.5
88.8
93.2

100%
50%
20%

DAC

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tor3/19-001



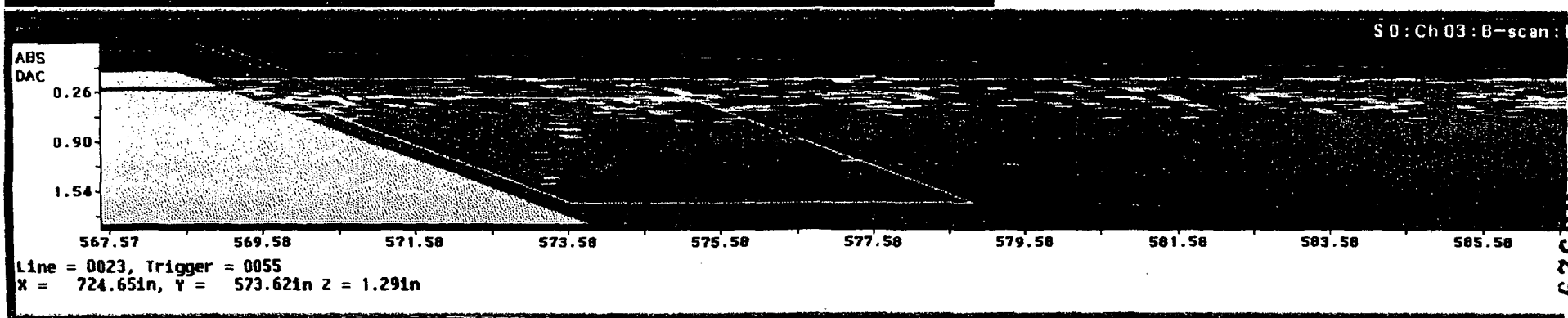
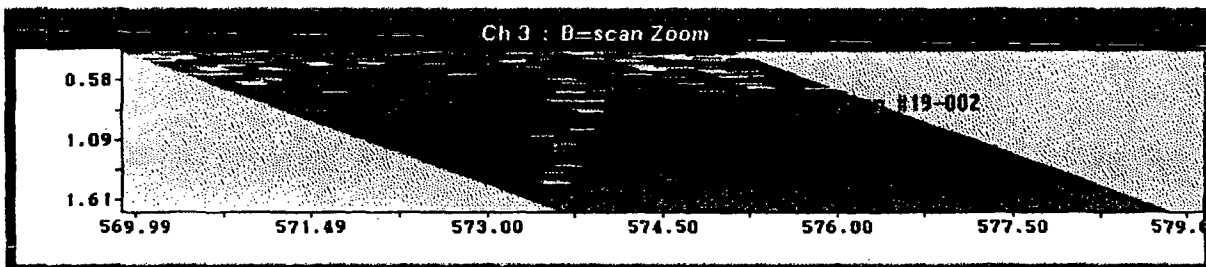
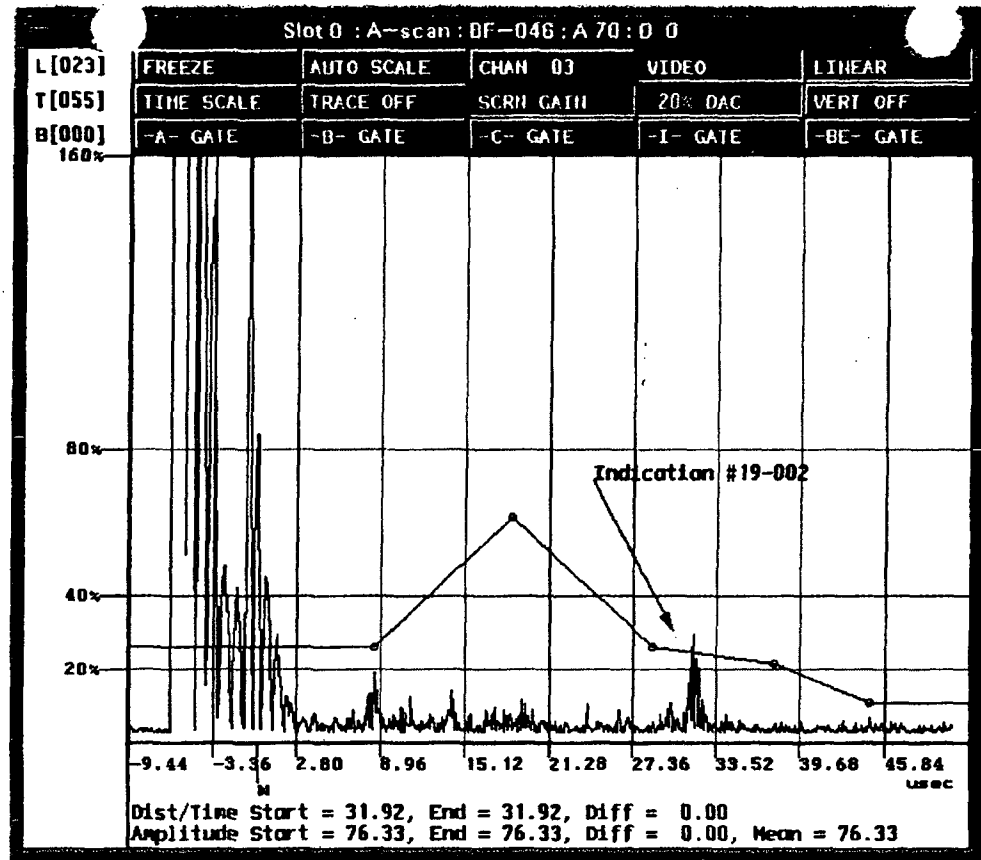
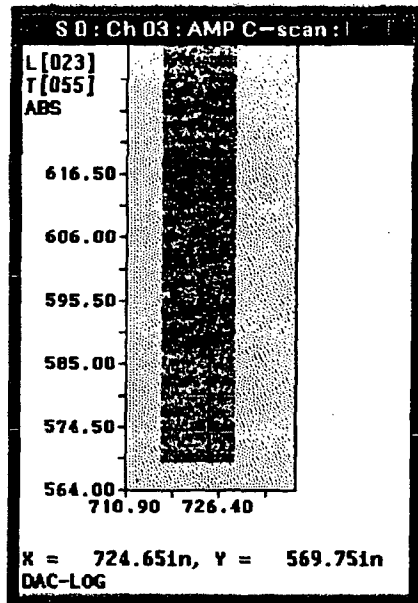
21171
14 OF 21
00328

S 0 : Scale

32.3
36.6
41.0
45.3
49.7
54.0
58.4
62.7 100%
67.1 50%
71.4 20%
75.8
80.1
84.5
88.8
93.2

DAC

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21171
15 of 21
4 00329

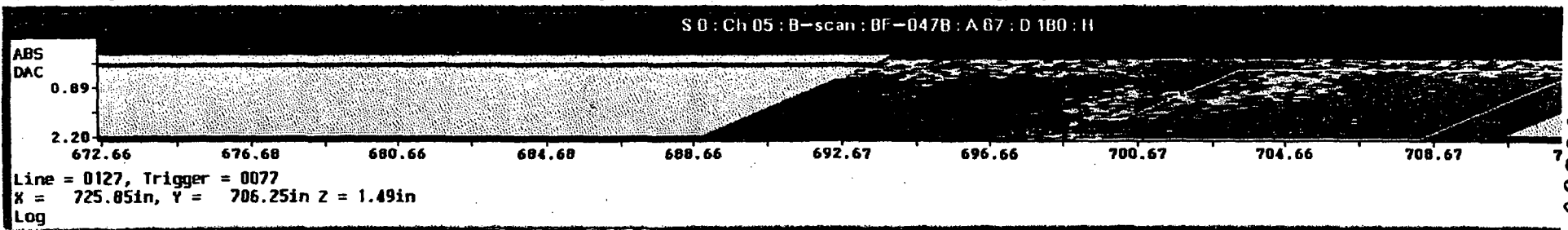
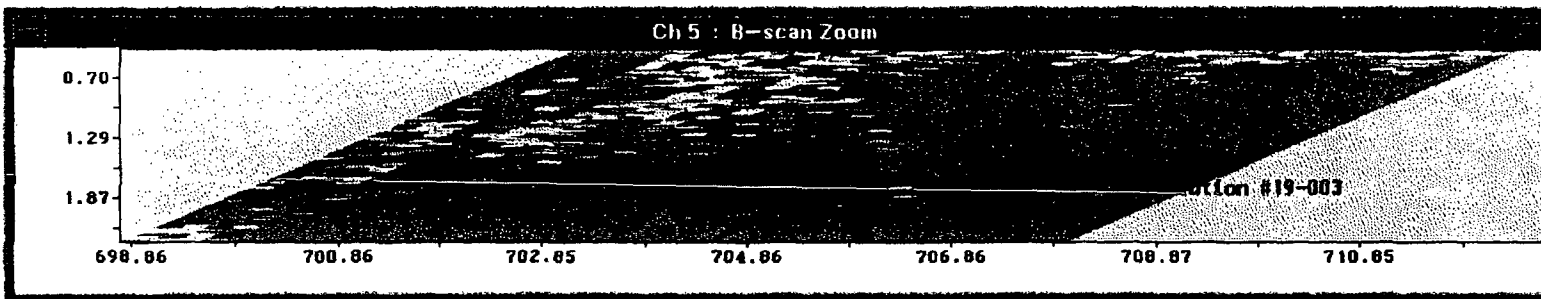
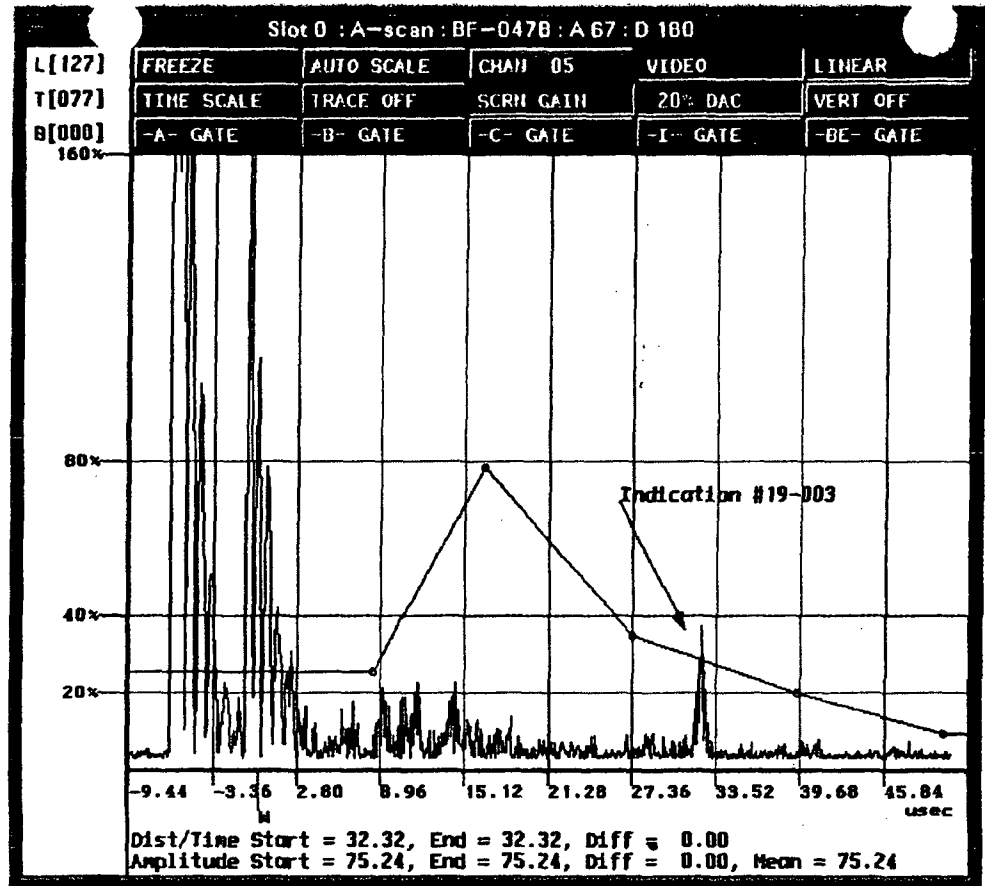
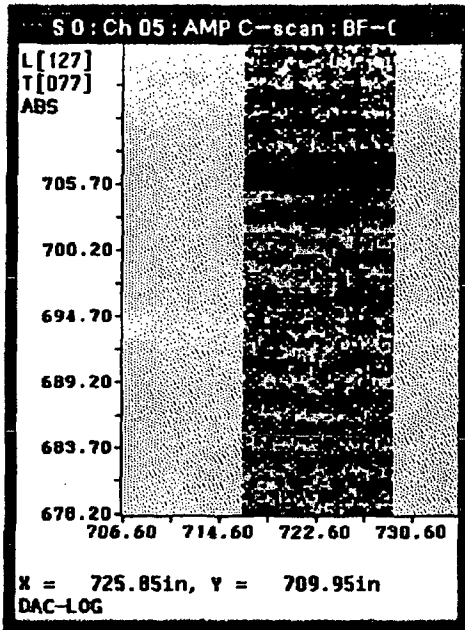
S 0 : Scale

32.3
36.6
41.0
45.3
49.7
54.0
58.4
62.7
67.1
71.4
75.8
80.1
84.5
88.8
93.2

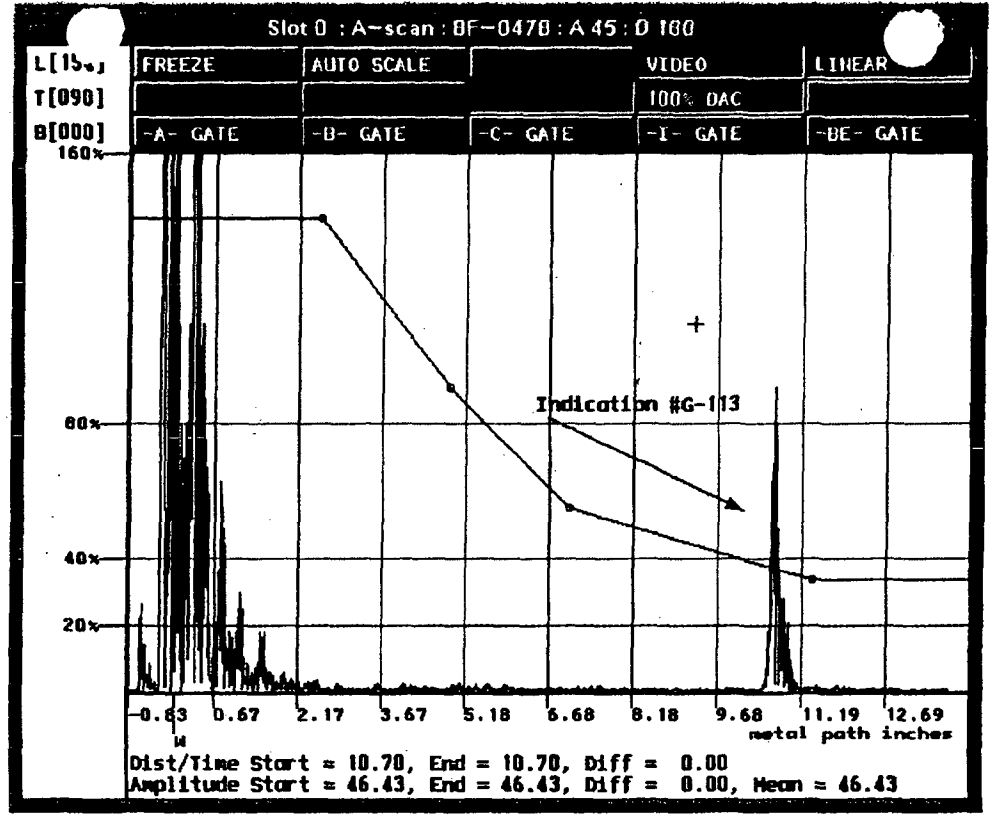
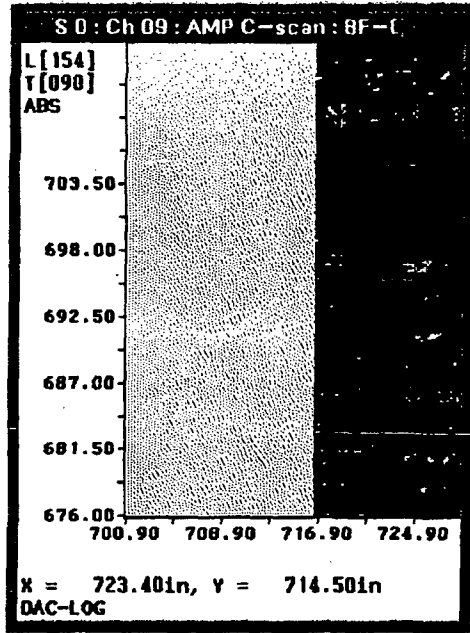
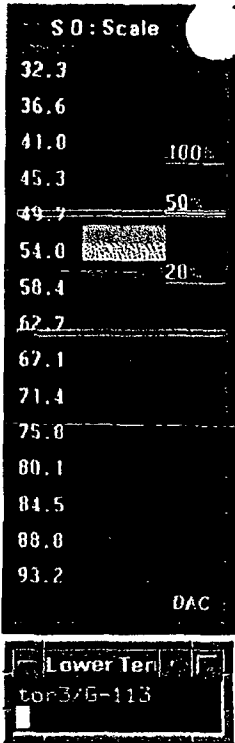
100%
50%
20%

DAC

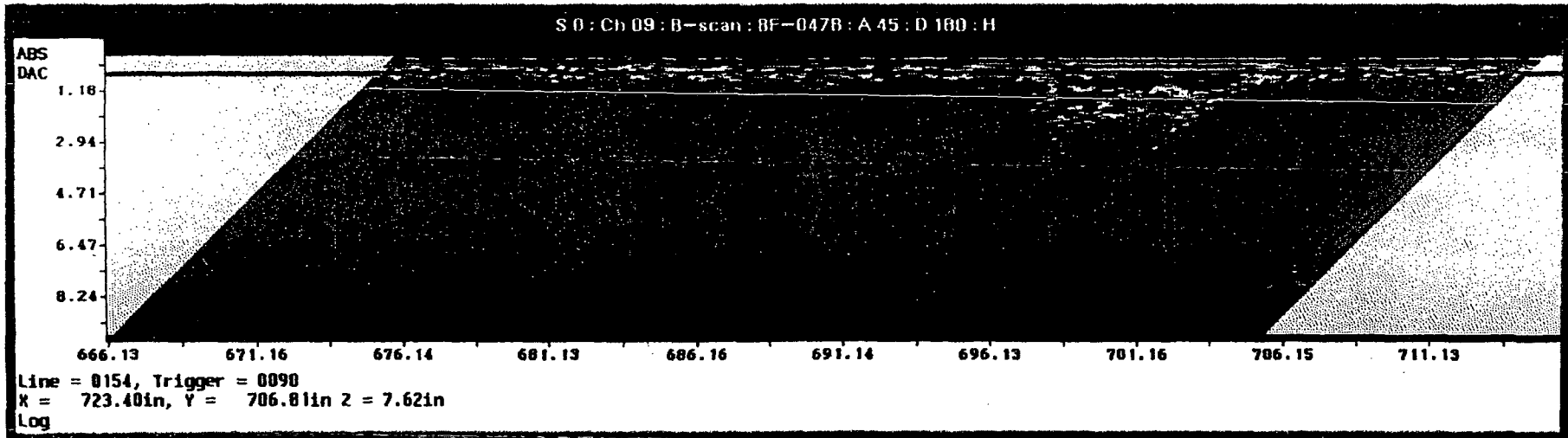
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16 OF 21
00330



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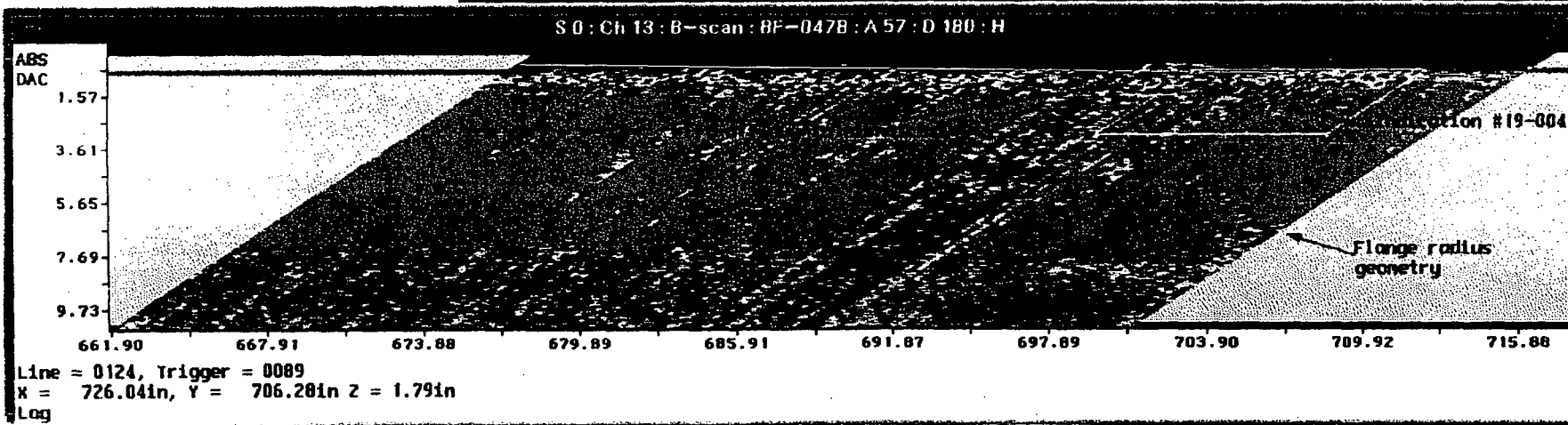
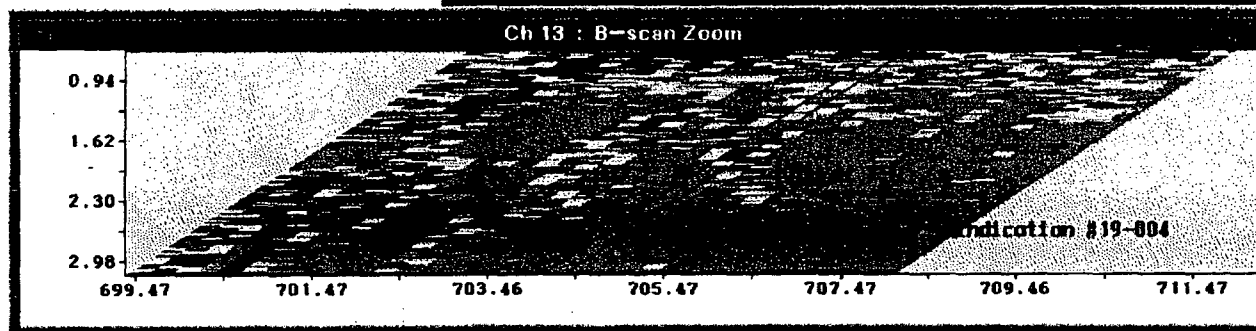
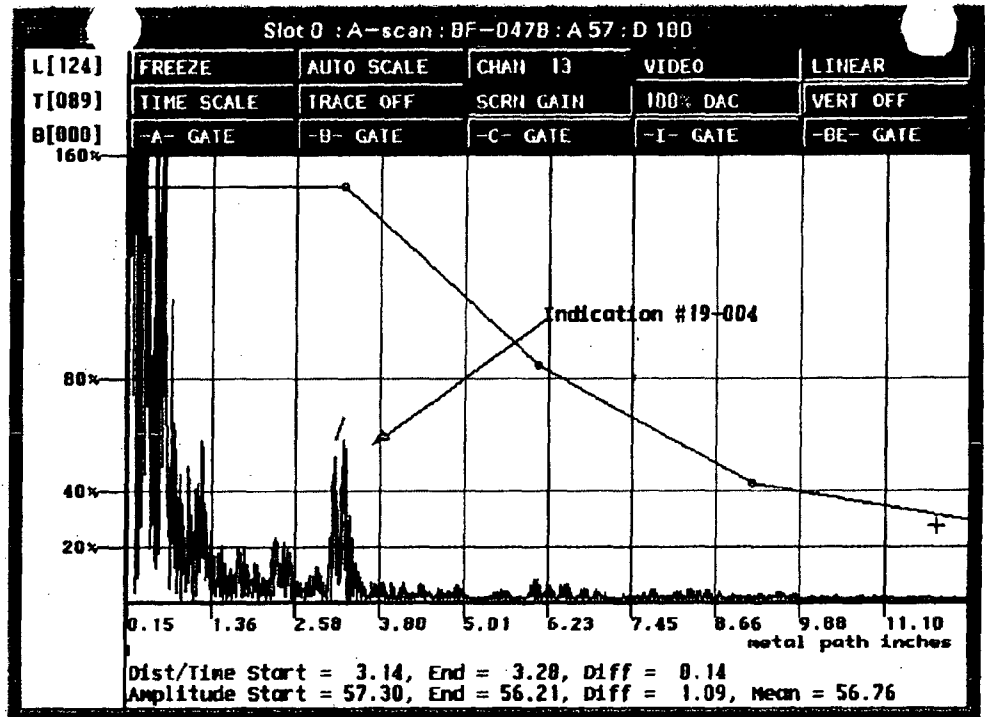
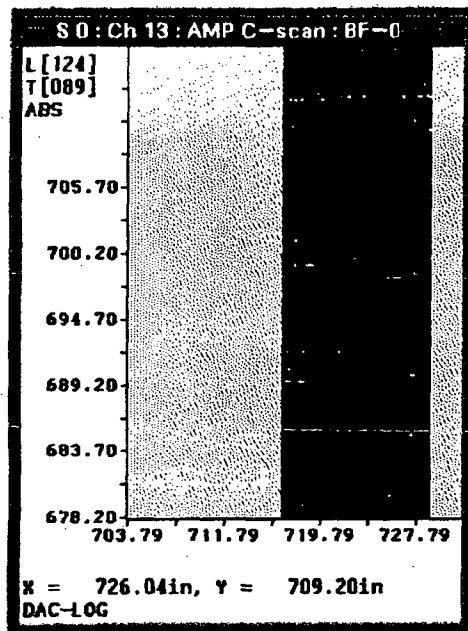
R1171
17 of 21
00331

S 0 : Scale

| | |
|------|------|
| 32.3 | |
| 36.6 | |
| 41.0 | |
| 45.3 | |
| 49.7 | 100% |
| 54.0 | 50% |
| 58.4 | |
| 62.7 | 20% |
| 67.1 | |
| 71.4 | |
| 75.8 | |
| 80.1 | |
| 84.5 | |
| 88.8 | |
| 93.2 | |

DAC

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to 3/19-004



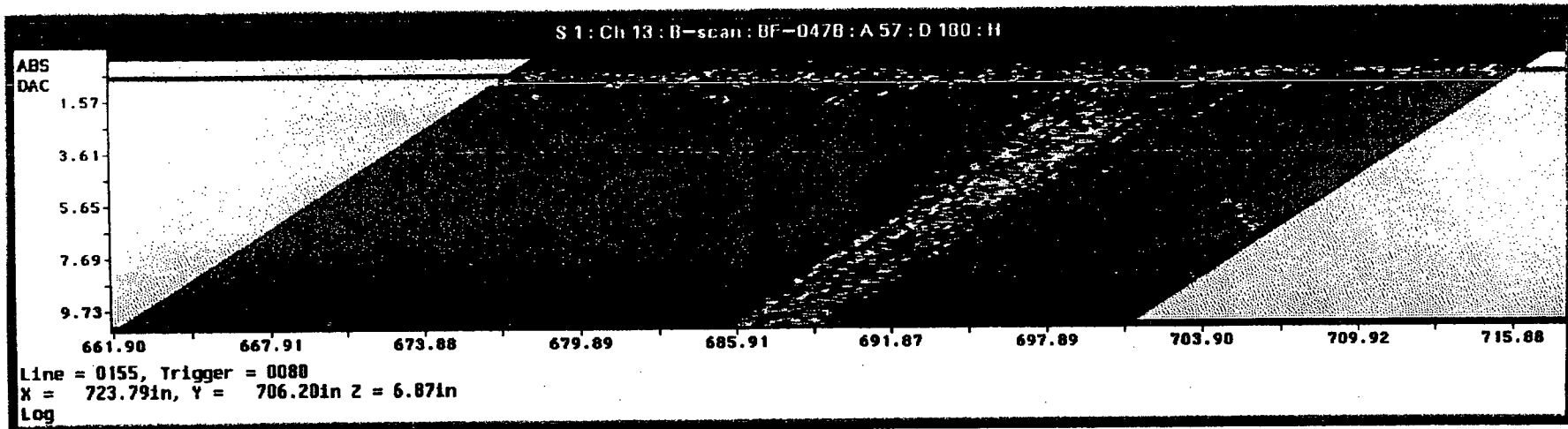
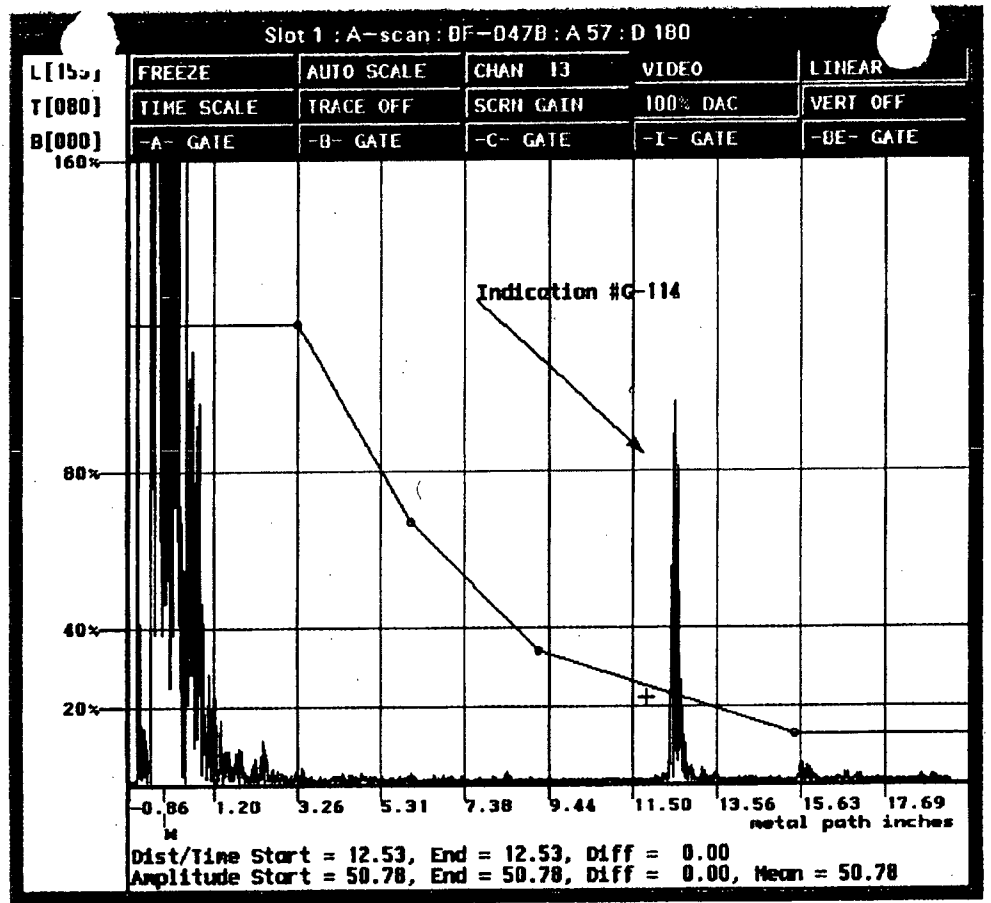
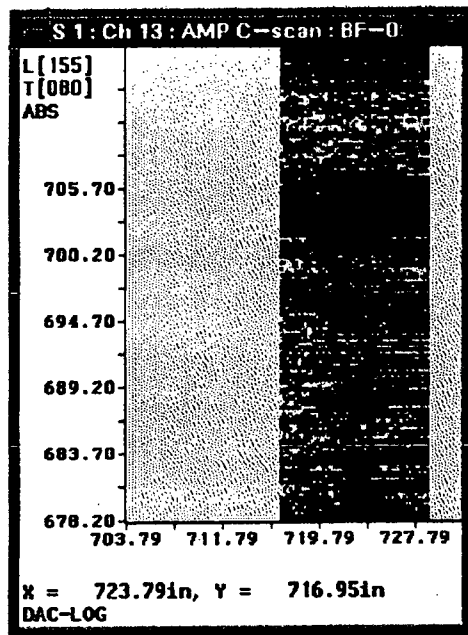
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S 1 : Scale

32.3
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49.7 100%
54.0 50%
58.4
62.7 20%
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71.3
75.8
80.1
84.5
88.8
93.2

DAC

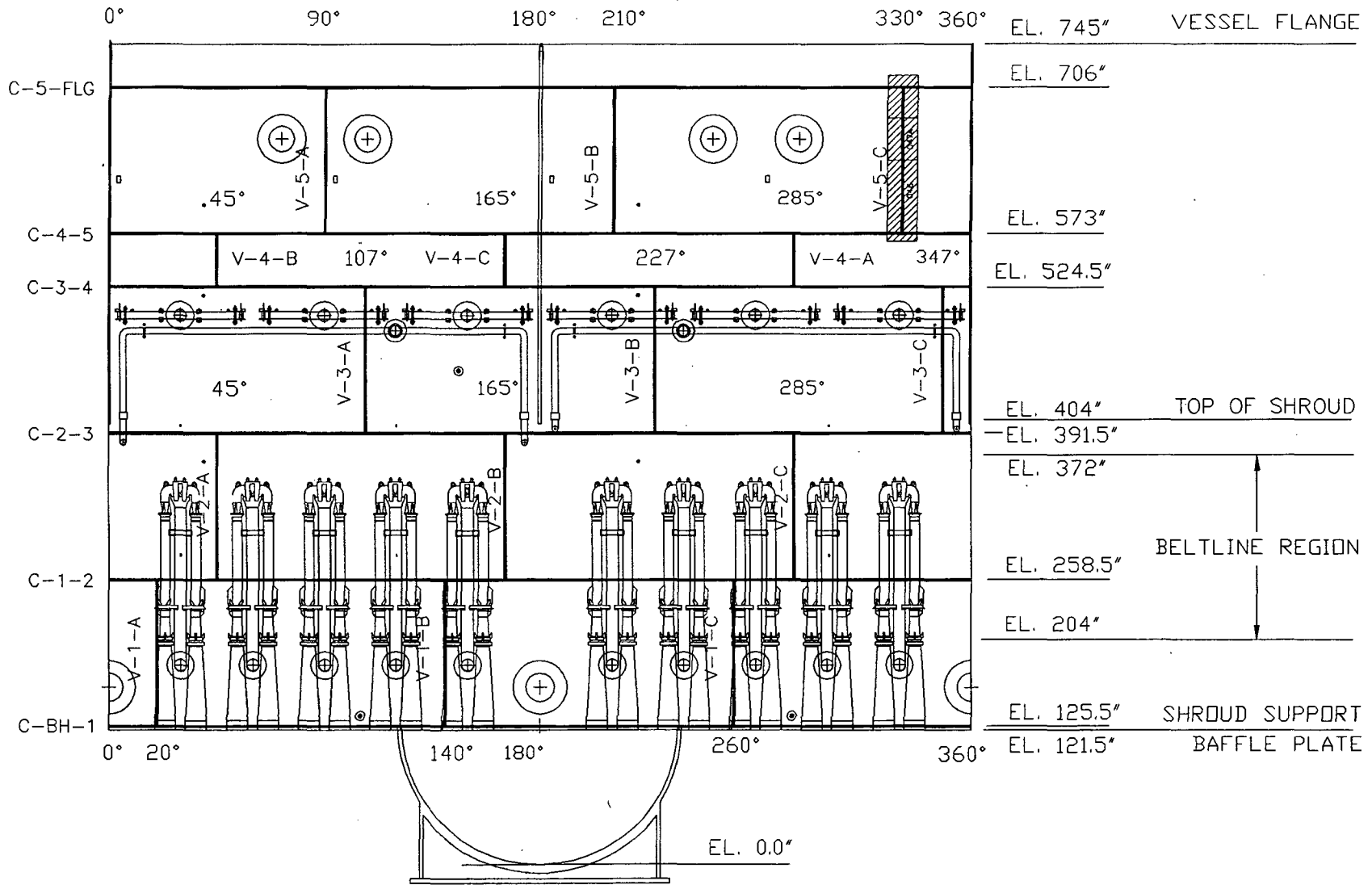
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21171
19 OF 21
00333

BROWNS FERRY UNIT-3 WELD LOCATIONS

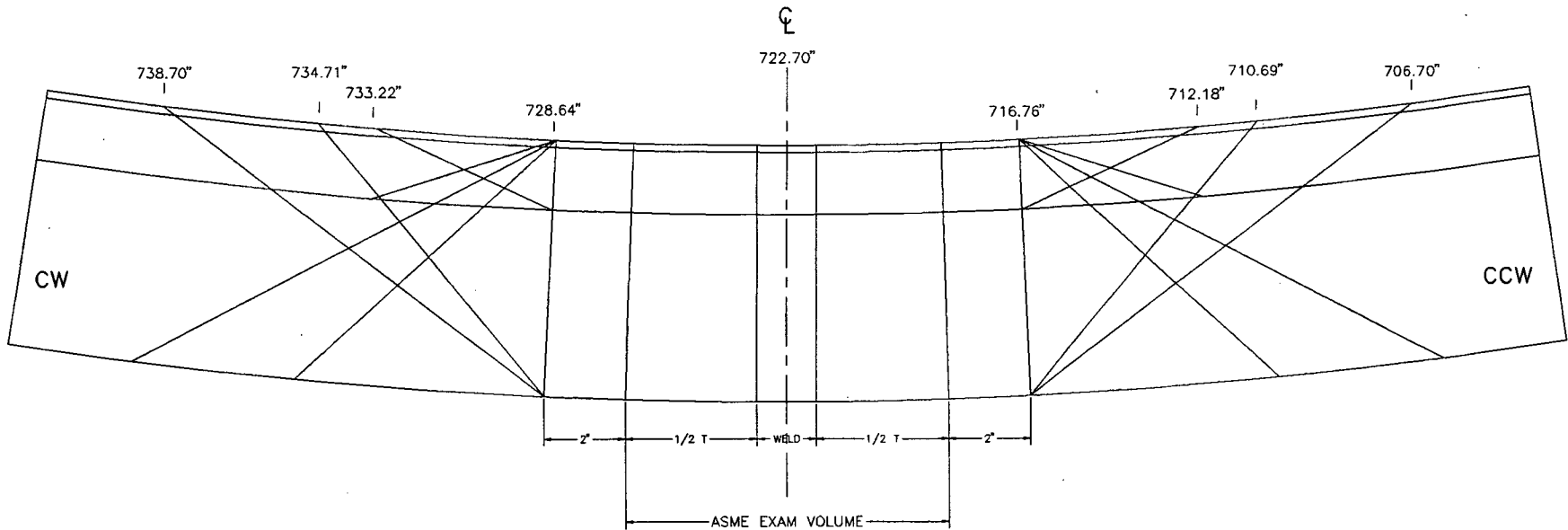


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20 of 21

| | | | | |
|-------------------|---------------------|---|----------|-------|
| GE NUCLEAR ENERGY | BROWNS FERRY UNIT 3 | VESSEL ROLLOUT & AS SCANNED PATCH LOCATIONS | BF-3-VMA | REV 0 |
|-------------------|---------------------|---|----------|-------|



Nominal Clad T = 3/16"
 Nominal Base Metal T = 6 3/8"
 1 Degree = 2.19"

| CH. | ANGLE | DIR. | MIN X | MAX X |
|-----|--------|------|--------|--------|
| 1 | 0 W | 0 | 716.76 | 728.64 |
| 2 | 0 W | 90 | 716.76 | 728.64 |
| 3 | 70 UP | 0 | 716.76 | 728.64 |
| 4 | 70 CW | 90 | 712.18 | 728.64 |
| 5 | 70 DN | 180 | 716.76 | 728.64 |
| 6 | 70 CCW | 270 | 716.76 | 733.22 |
| 7 | 45 UP | 0 | 716.76 | 728.64 |
| 8 | 45 CW | 90 | 710.69 | 728.64 |
| 9 | 45 DN | 180 | 716.76 | 728.64 |
| 10 | 45 CCW | 270 | 716.76 | 734.71 |
| 11 | 60 UP | 0 | 716.76 | 728.64 |
| 12 | 60 CW | 90 | 706.70 | 728.64 |
| 13 | 60 DN | 180 | 716.76 | 728.64 |
| 14 | 60 CCW | 270 | 716.76 | 738.70 |
| 15 | 0 BM | 0 | 716.76 | 738.70 |
| 16 | 0 BM | 90 | 706.70 | 728.64 |

00335

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210E21