TVA

WALL THICKNESS PROFILE SHEET

REPORT NO: R-P0228

PROJECT: WBN

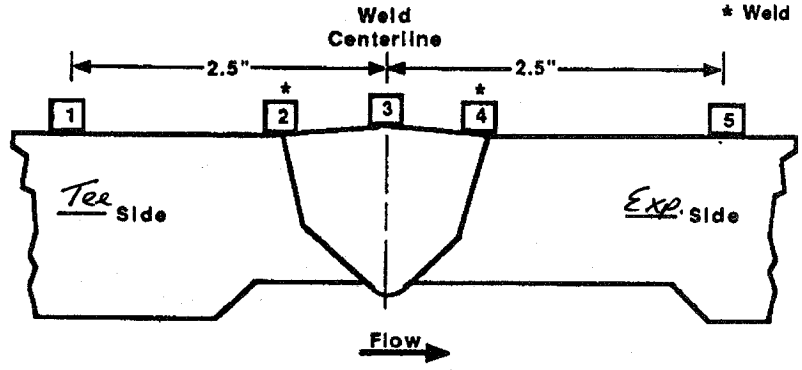
UNIT: 2

WELD NO: RCF-D145-05

SYSTEM: RCS

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

Position	0°	90°	180°	270°
1	.554	.601	.648	.562
2	.521	.541	.549	.545
3	.562	.542	.560	.557
4	.580	.532	.574	.709
5	.710	*	.677	*

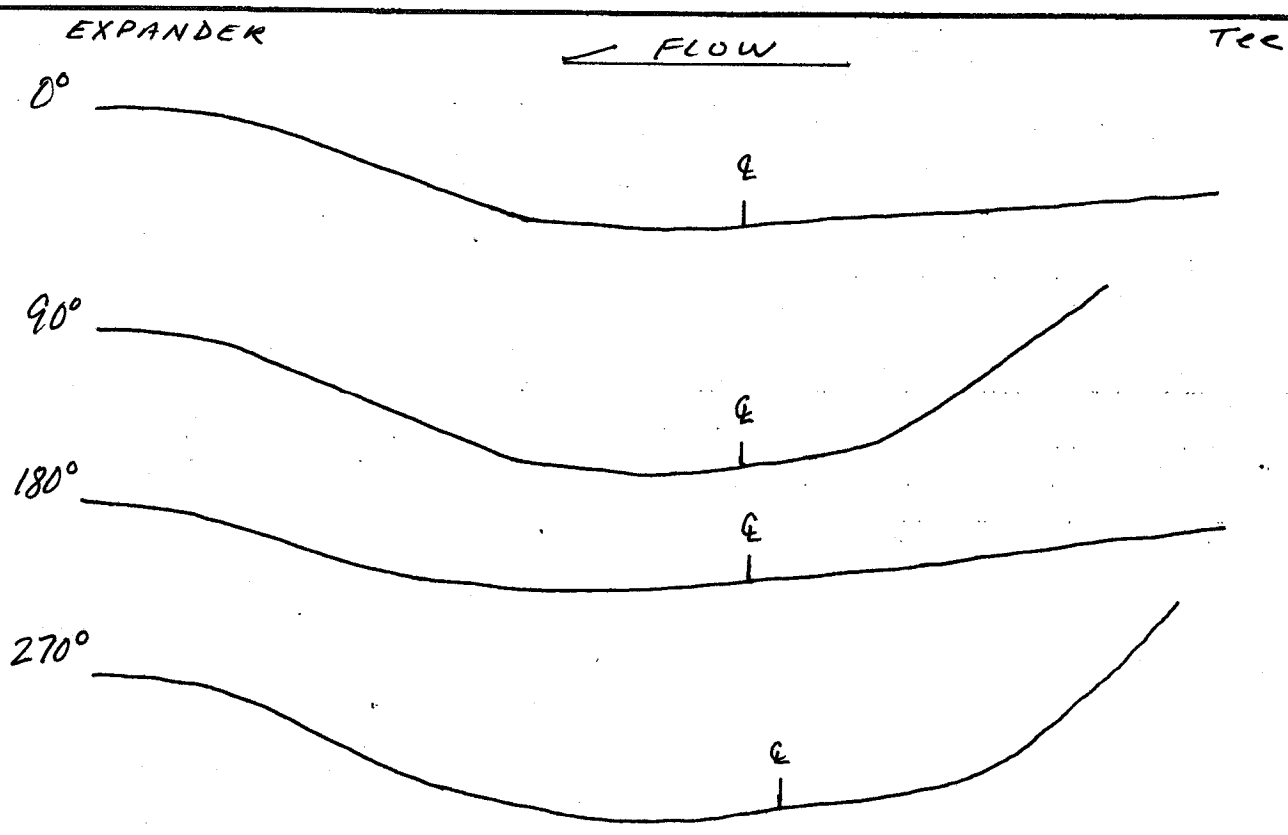


CROWN HEIGHT: FLUSH

CROWN WIDTH: .75

DIAMETER: 4.0

WELD LENGTH: 14.5



* unable to take thickness reading due to expander configuration.

EXAMINER: Jose Alejandro Jaramillo
LEVEL: II
DATE: 03-05-09

REVIEWED BY: [signature]
LEVEL: III DATE: 3-11-09

ANII: [signature]
DATE: 3/16/09

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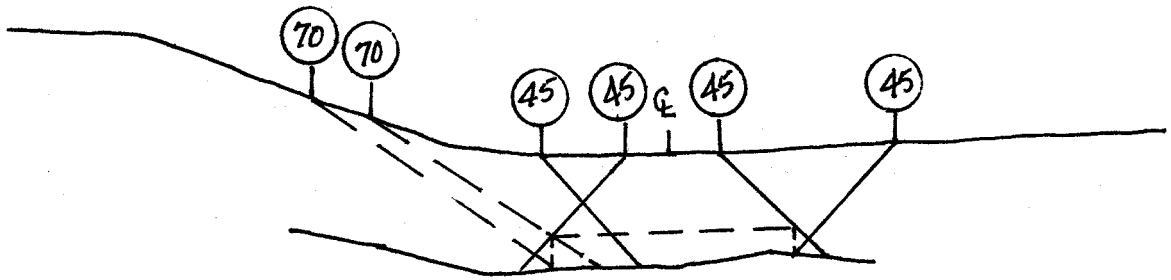
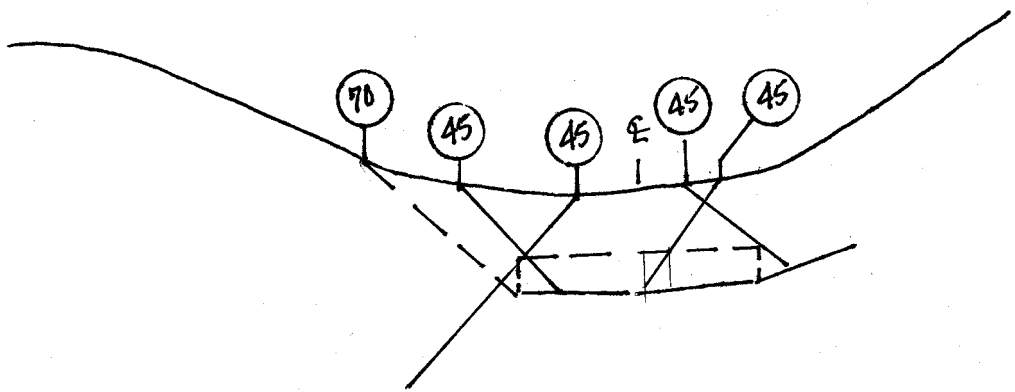
TVA Office of Nuclear Power	PROJECT: WBN SYSTEM: RCS UNIT: 2 WELD NO: RCF-D145-05	REPORT NO.: R-P0228

FLOW

Expander

Tee





Profile at 90° and 270° Scan 3 limitations due to Tee geometry.

BY: Jose Alejandro LEVEL: II DATE: 03-05-09 PAGE 6 OF 6

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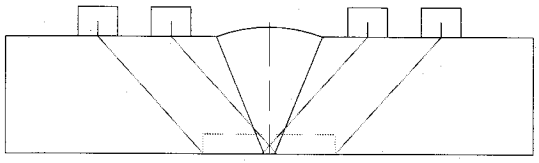
Attachment 3
(Page 1 of 1)

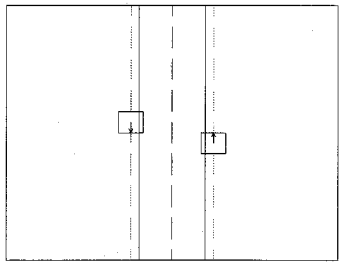
AUSTENITIC PIPING WELDS DUAL SIDE ACCESS - SUPPLEMENT 2

Required and obtained examination volume coverage work sheet

Below is a typical example of examination coverage plots although are not to be considered inclusive of all situations.

Typical example of a dual sided examination, generally the examination volume is the lower 1/3T of the weld metal and ¼ inch of the adjacent base material.





Weld # RCF-1)145-05 W=1.3 H=.2 L=14.5 ✓

Item	Description	Value
	REQUIRED EXAMINATION VOLUME	
1	Required examination volume in sq in. (width x height) for single scan stroke	.25
2	Number of scan directions (normally 4; i.e. upst,dnst, cw, & ccw))	4
3	Total scan volume in sq inches (Item 1 * Item 2)	1.04
4	Total length of weld	14.5
5	Total required examination volume in cubic inches (Item 3 * Item 4)	15.08
	OBTAINED EXAMINATION VOLUME	
6	Examination volume achieved (sq in for single scan stroke) in 1 axial scanning direction (i.e. upst) multiplied by the length of weld examined	2.25
7	Examination volume achieved (sq in for single scan stroke) in 1 axial scanning direction (i.e. dnst) multiplied by the length of weld examined	3.77
8	Examination volume achieved (sq in for single scan stroke) in 1 circumferential scanning direction (i.e. cw) multiplied by the length of weld examined	3.77
9	Examination volume achieved (sq in for single scan stroke) in 1 circumferential scanning direction (i.e. ccw) multiplied by the length of weld examined	3.77
10	Determine the achieved examination volume by adding Items 6, 7, 8. and 9	13.56
11	Examination volume percentage [(Item 10 / item 5) X 100]	(.899) = 90%

JA