

TVA

WALL THICKNESS PROFILE SHEET

REPORT NO:

R-P0487

PROJECT: WATS BAR NUCLEAR

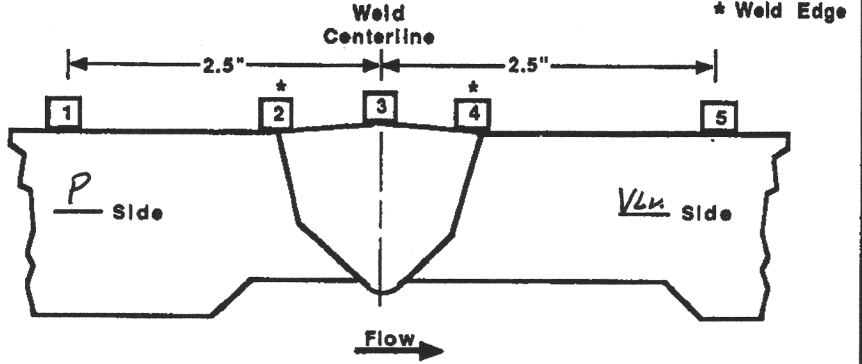
WELD NO: SIF-D196-10

UNIT: 2

SYSTEM: SIS

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

Position	0°	90°	180°	270°
1	1.029	.977	1.009	1.024
2	1.032	1.076	1.108	1.070
3	1.206	1.149	1.134	1.206
4	1.293	1.384	1.412	1.243
5	N/A	N/A	N/A	N/A



CROWN HEIGHT: Flush

DIAMETER: 10.0

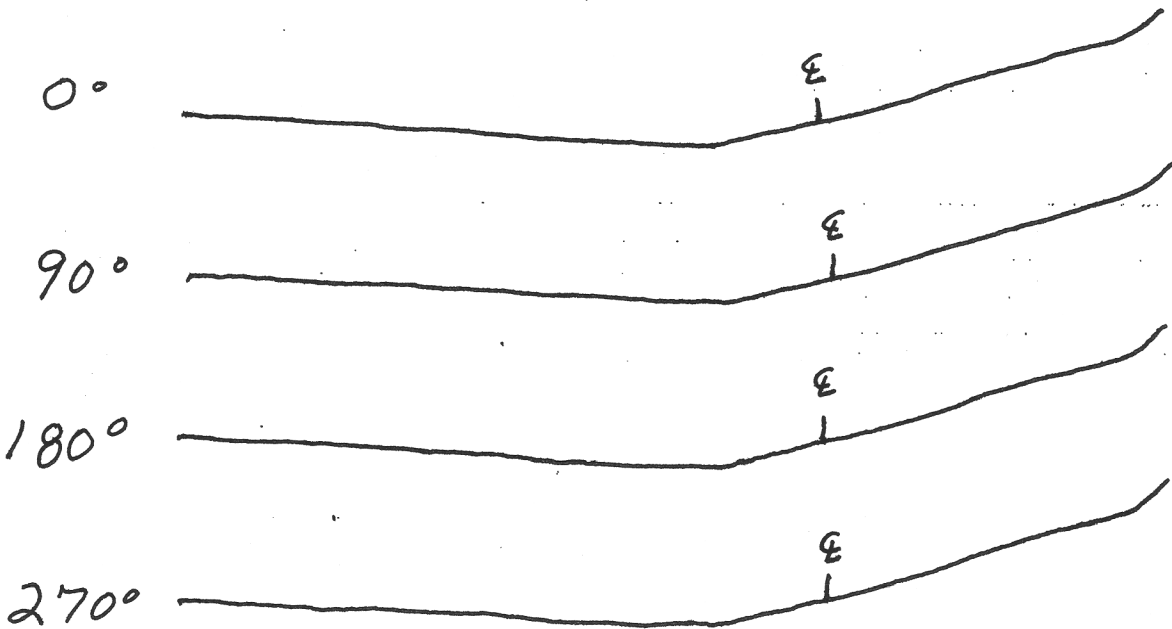
CROWN WIDTH: 1.0

WELD LENGTH: 35.625

PIPE

FLOW

VALVE



EXAMINER: [Signature]  
LEVEL: BL  
DATE: 6-16-09

REVIEWED BY: [Signature]  
LEVEL: ILL DATE: 6-18-09

ANII: [Signature]  
DATE: 7/2/09  
PAGE 5 OF 6

TVA

Office of Nuclear Power

PROJECT: WATTS BAR NUCLEAR SYSTEM: SIS

UNIT: 2 WELD NO: SIF-D196-10

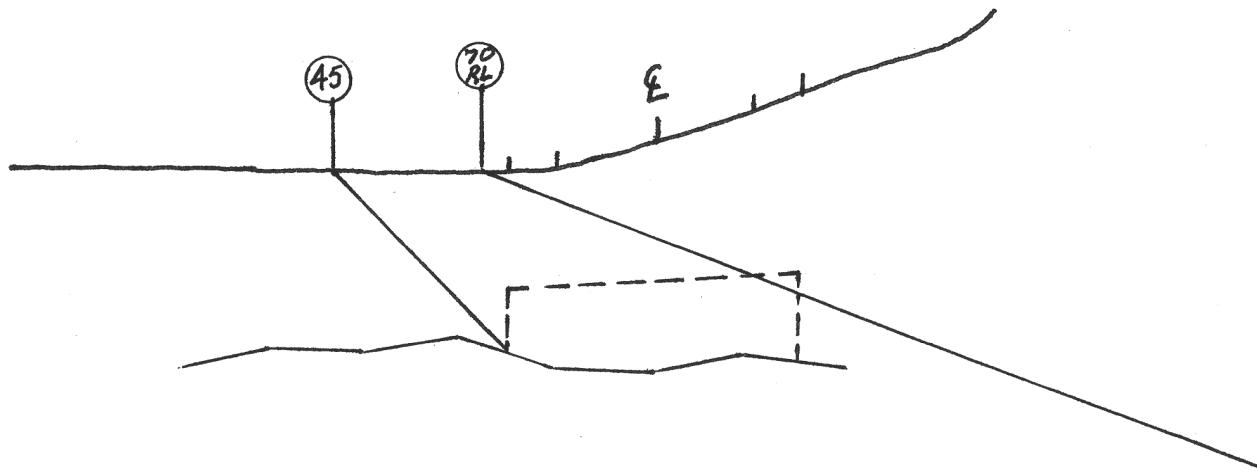
REPORT NO.:

R-P0487

PIPE

FLOW →

VALVE



Plot shown represents primary angle of 45°, phased array angles used 25°-70° RL angles used 40°-70°

BY: *John Kim*

LEVEL: II

DATE: 6-16-09

PAGE 6 OF 6

R-PO487

TVA Procedure  
N-GP-31

Attachment 3

SIF - D196-10

Item 1	Required examination Volume in sq. in. (width x height)	1.5	0.44	0.66 sq. in.
Item 2	Number of scan directions	4 directions		
Item 3	Total Scan volume in sq. in.	2.64 sq. in.		
Item 4	Total length of weld	36.625 inches		
Item 5	Total required exam volume in cubic inches	96.69 cu. in.		
Item 6	Exam volume achieved (sq. in.) in direction 1 X length of weld achieved	0	0	0 cu. in.
Item 7	Exam volume achieved (sq. in.) in direction 2 X length of weld achieved	0.62	36.625	22.7075 cu. In.
Item 8	Exam volume achieved (sq. in.) in direction 3 X length of weld achieved	0.66	36.625	24.1725 cu. In.
Item 9	Exam volume achieved (sq. in.) in direction 4 X length of weld achieved	0.66	36.625	24.1725 cu. In.
Item 10	Determined the achieved exam volume add 6, 7, 8 & 9	71.0525 cu. in.		
Item 11	Exam volume percentage item 10/item 5 x 100	73.48485 %		

.25 x .1

one sided due to valve

JPN 6-17-09

*Janzi* II

**INFORMATION ONLY**