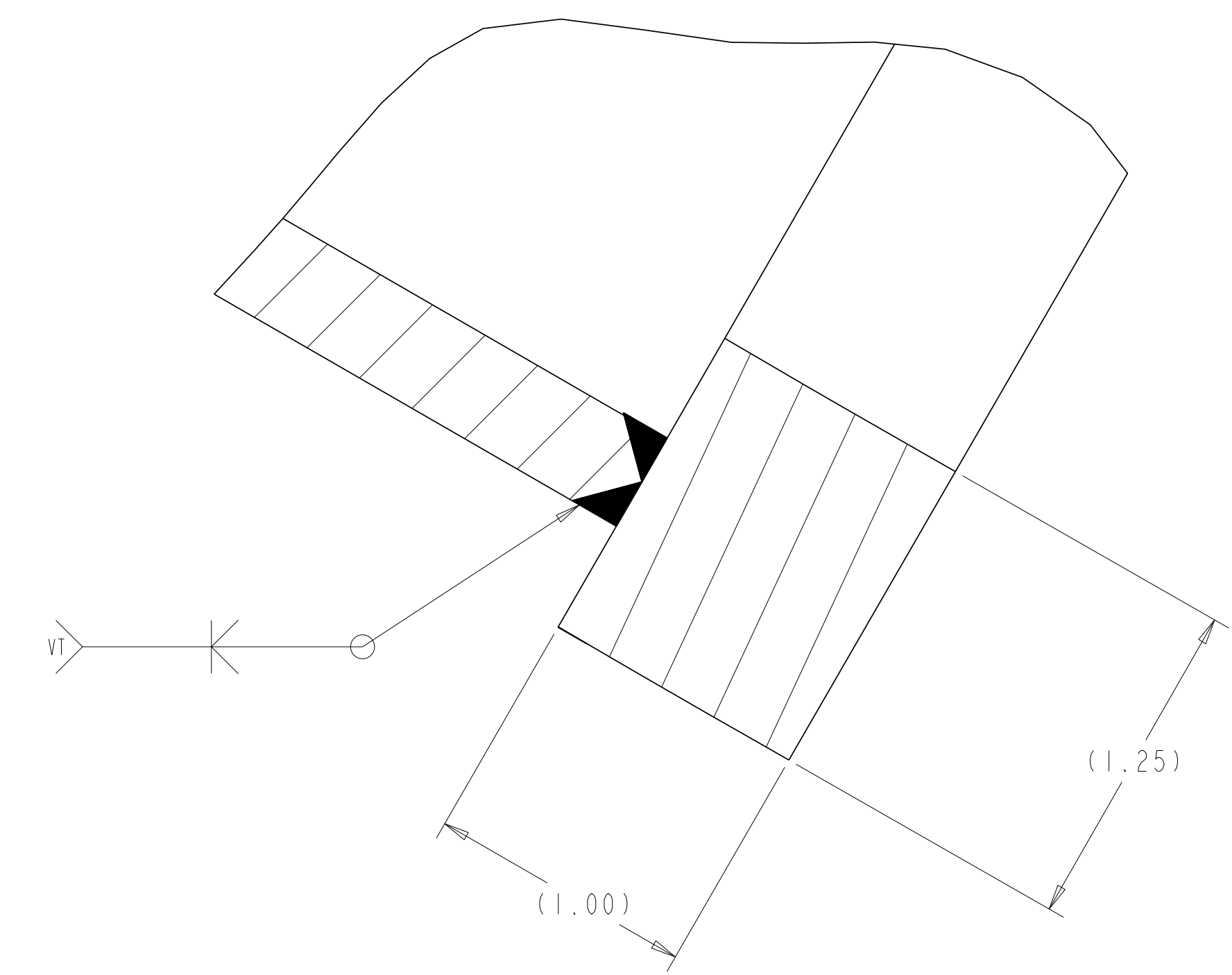
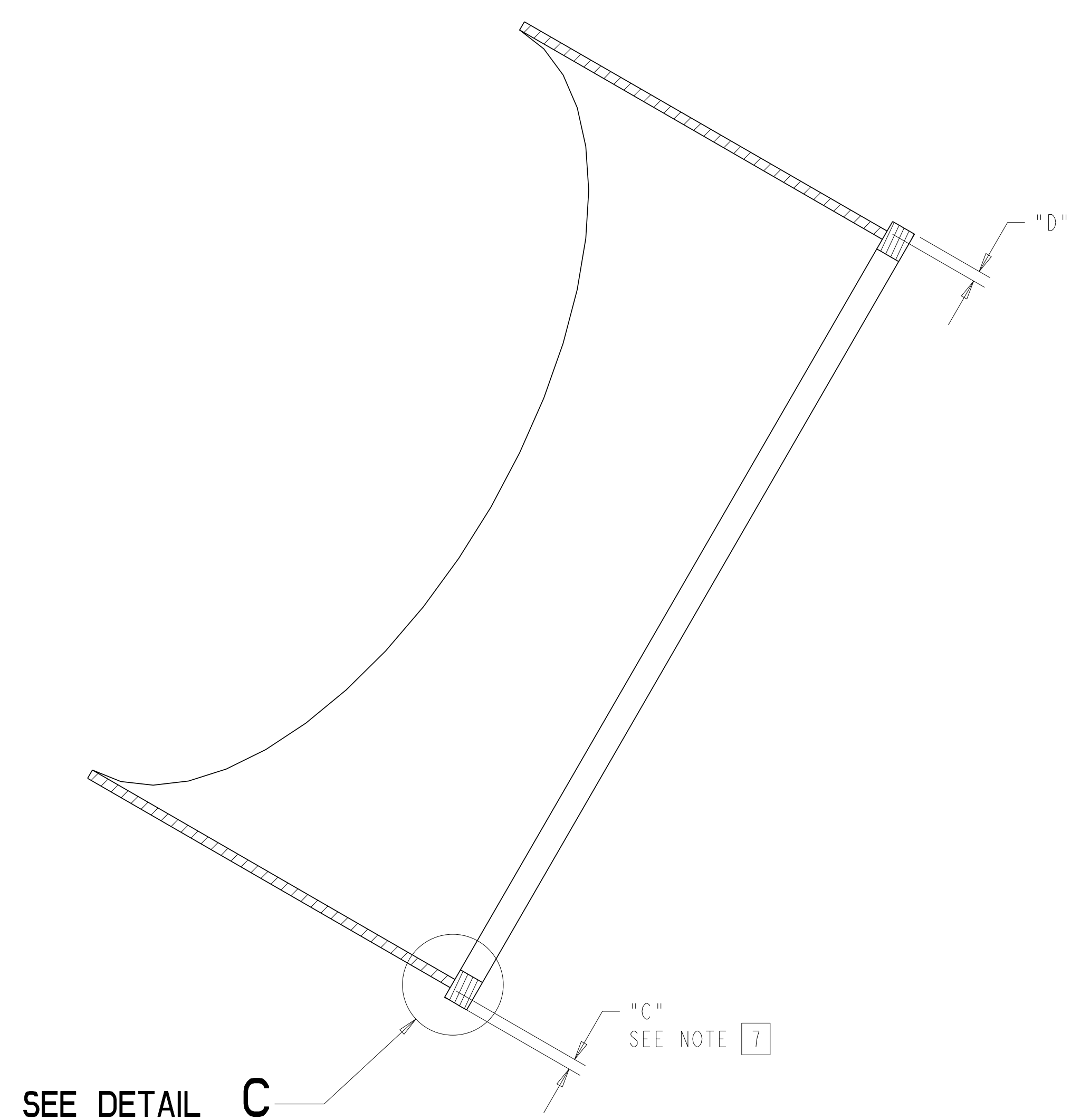


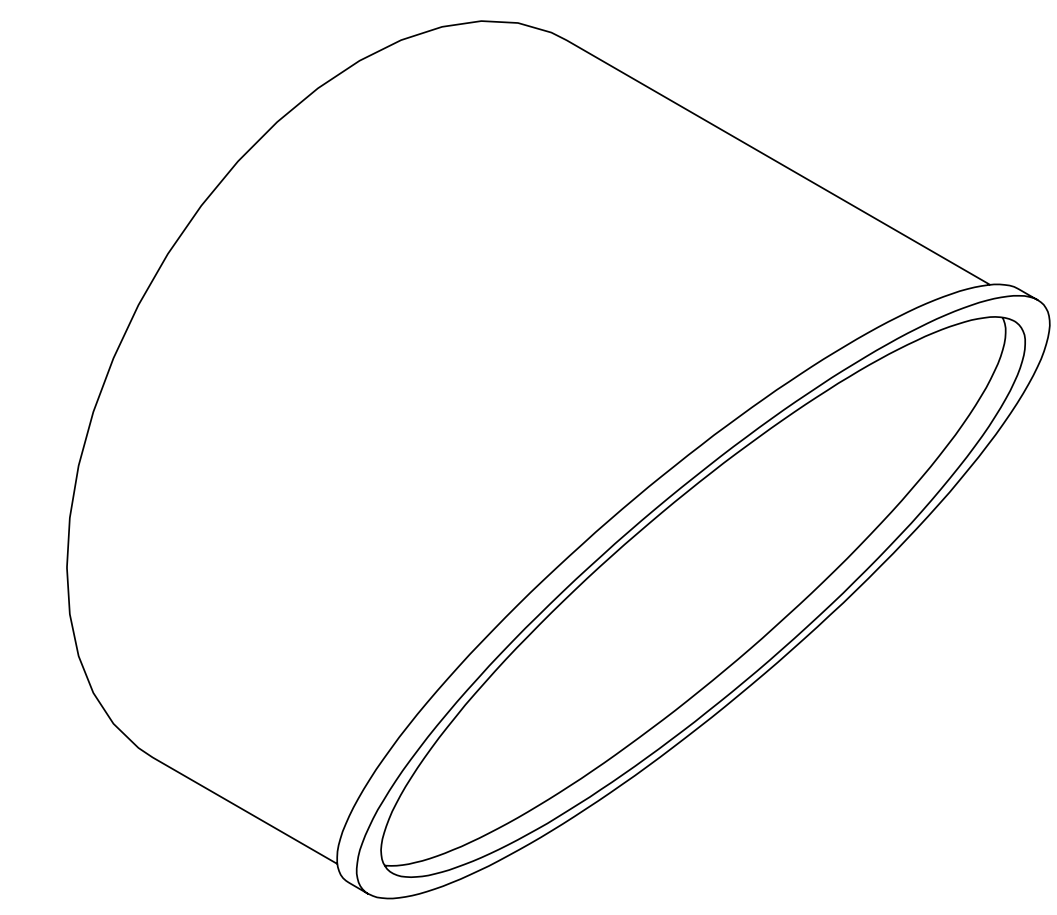
- NOTES:
- INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 - DIMENSION ARE IN INCHES.
 - REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL END STOCK WELDMENT ARE DEFINED IN THE DRAWINGS, MODELS, AND STATEMENT OF WORK NCSX-SOW-121-02.
 - GEOMETRY OF VACUUM VESSEL END STOCK WELDMENT IS DEFINED IN CAD MODELS/FILES SEI203-005.ASM, SEI203-013.PRT AND SEI203-015.PRT.
 - WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.
 - WELD INSPECTIONS SHALL BE PERFORMED BY VISUAL EXAMINATION: ALL WELDS ARE TO BE VISUALLY INSPECTED IN ACCORDANCE WITH ARTICLE 9, SECTION V OF THE ASME CODE. WELDS DESIGNATED WITH A "VT" IN THE REFERENCE AREA OF A WELD SYMBOL SHALL ALSO BE VISUALLY EXAMINED WITH 8X MAGNIFICATION, IN ACCORDANCE WITH ARTICLE 6, SECTION V OF THE ASME CODE. THE ACCEPTANCE CRITERIA FOR THE VISUALLY INSPECTED WELDS IS GIVEN IN AWS D1.6, PARAGRAPH 6.29.1. ALL WELDS THAT DO NOT MEET THE STATED ACCEPTANCE CRITERIA SHALL BE DOCUMENTED, REPAIRED AND RE-INSPECTED. VISUAL WELD INSPECTION SHALL BE DONE BY INSPECTORS CERTIFIED TO PERFORM VISUAL INSPECTION OF WELDS IN ACCORDANCE WITH AWS QCI OR SNT-TC-1A, LEVEL II OR LEVEL III.
 - DIMENSION "A" = "B" ± .03 AND DIMENSION "C" = "D" ± .03.



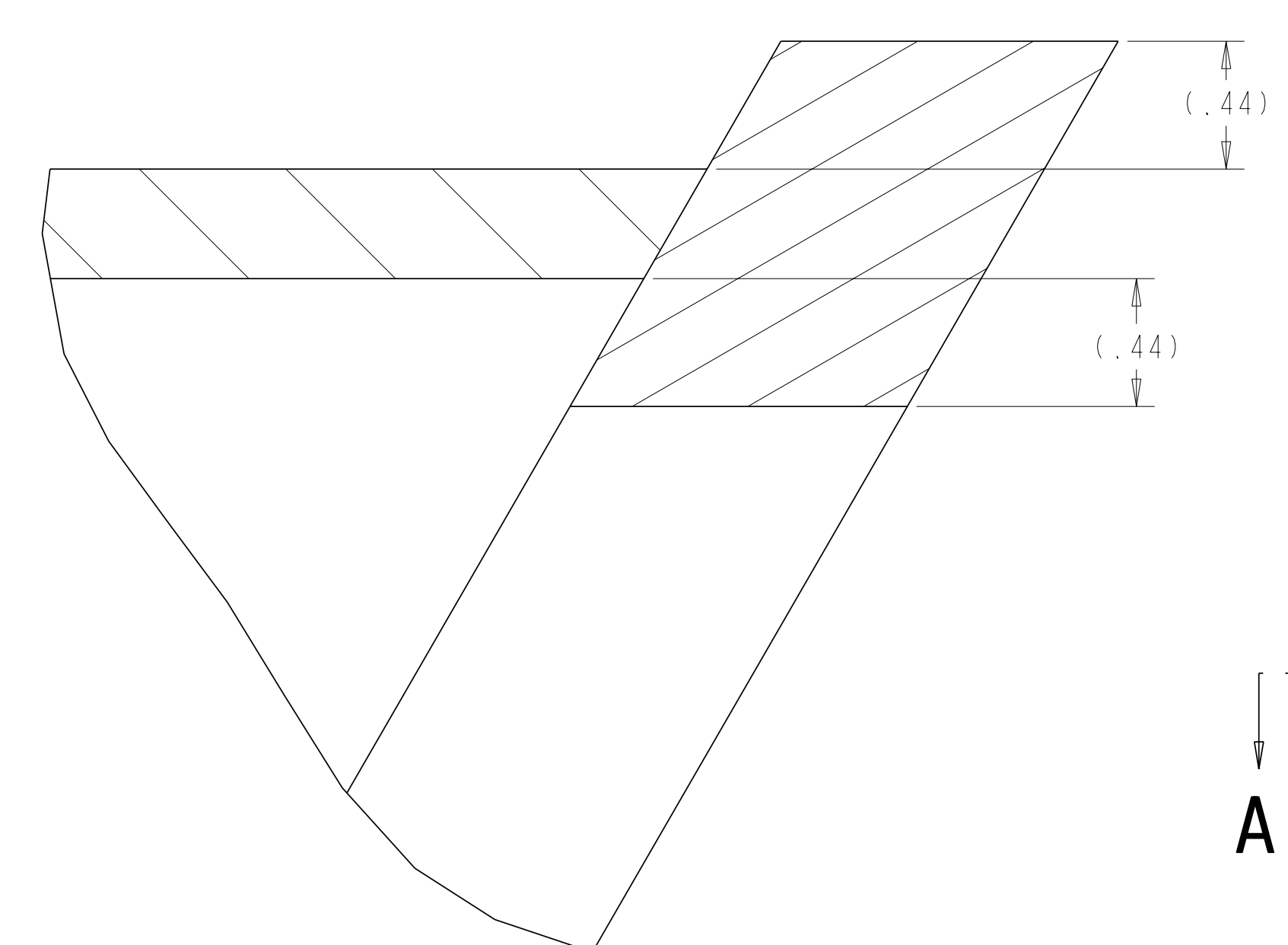
DETAIL C
SCALE 2.00



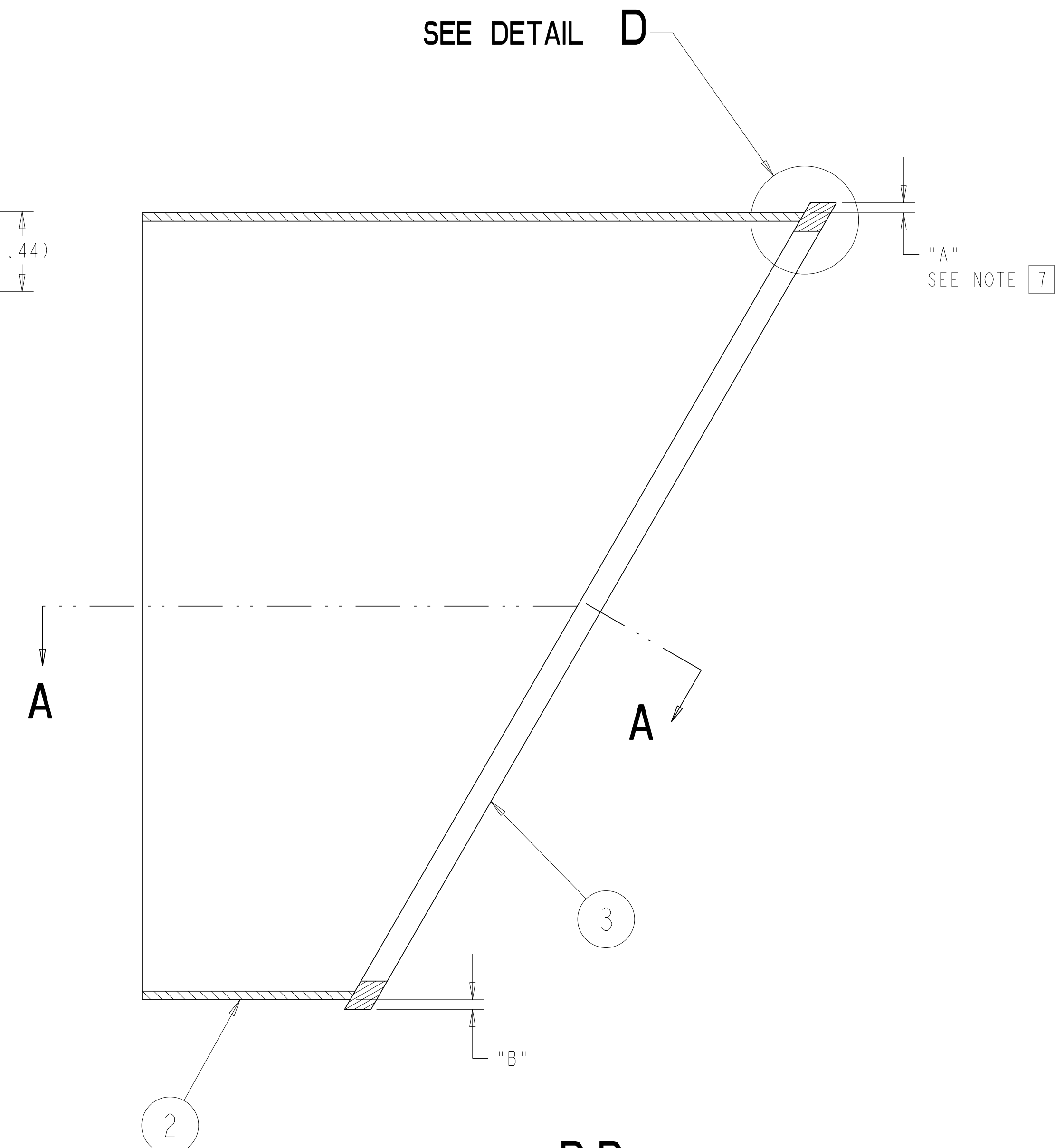
SECTION A-A



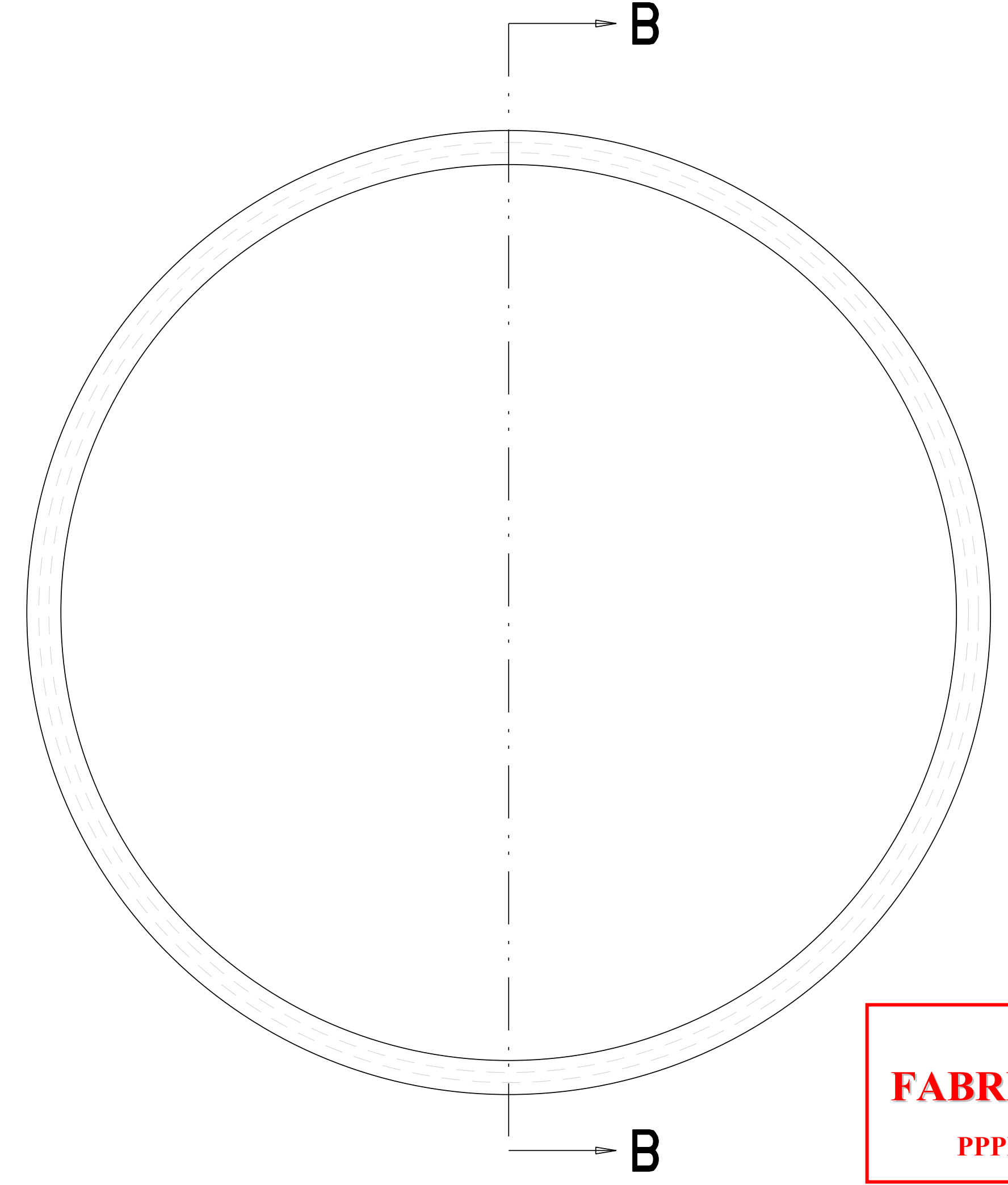
ISOMETRIC VIEW
SCALE 0.13



DETAIL D
SCALE 2.00



SECTION B-B



**RELEASED FOR
FABRICATION / INSTALLATION**
PPPL Drafting:

WELDING ENGINEER
APPROVED R. PARSELLS DATE: 8/3/04

1
SCALE 0.25

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
1	PER ECN #4882 GENERAL REVISION	GHJ	7/27/04	MJC								

next assy	AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
AEI203-003							

SCALE AS NOTED	DES: P. L. GORANSON	DRW: G. FORTIER	CHK: G. LOVETT	SECT: :	DEPT: :	PE: :	CR: :	PJ: :	RD: :	FINISH: :
TOLERANCES UNLESS OTHERWISE SPECIFIED	PPPL DRFT J. SIEGEL	7/27/04	VERSION NO. 0	PLANT X-10	BLDG 5700	FL 3	SHT 1	OF 1	TYPE D	CLASS U
FRACTIONS ± .01			RELEASE LEVEL							
XX DECIMALS ± .005			Fabrication							
XXX DECIMALS ± 0.015										
ANGLES ± 0.15°										
BREAK SHARP EDGES .06 MAX										
FINISH .125 UNLESS OTHERWISE SPECIFIED										

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