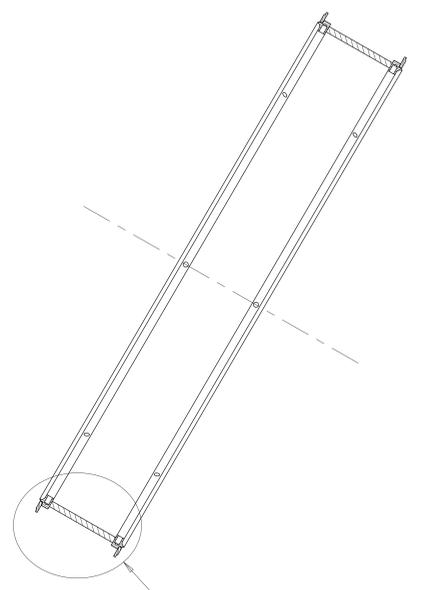


DETAIL X
SCALE 2.00

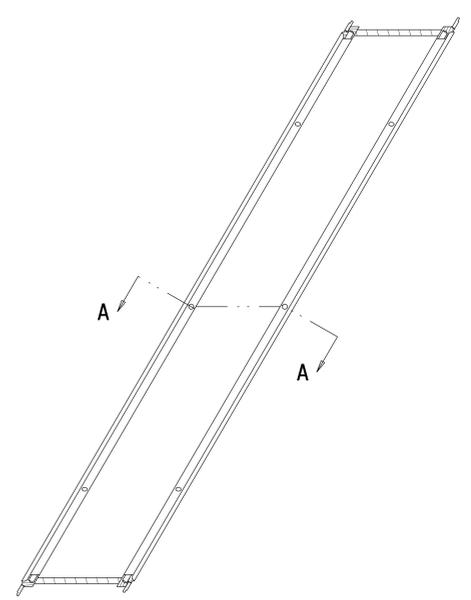


SECTION A-A
SEE DETAIL X

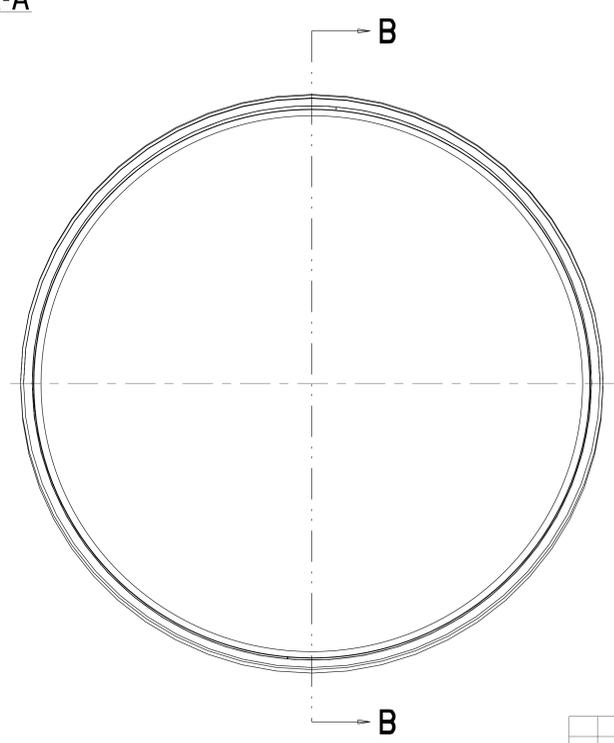
- NOTES:**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE SPOOL PIECE ASSEMBLY SEAL WELDMENT ARE DEFINED IN THE DRAWINGS, MODELS, AND STATEMENT OF WORK NCSX-SOW-121-02.
 4. GEOMETRY OF SPOOL PIECE ASSEMBLY SEAL WELDMENT IS DEFINED IN CAD MODELS/FILES SE1203-006.ASM, SE1203-002.ASM AND SE1203-008.ASM.
 5. 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.
 6. 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 QC1 OR SNT-TC-1A, LEVEL II OR LEVEL III.
 7. FLATNESS SHOWN IS IN FREE, UNCONSTRAINED CONDITION. FLATNESS SHALL BE 0.015 WITH THE FLANGE CLAMPED DOWN TO A FLAT REFERENCE SURFACE.



ISOMETRIC VIEW
SCALE 0.13



SECTION B-B



SCALE 0.25

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

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

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

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE AS NOTED
 TOLERANCES UNLESS OTHERWISE SPECIFIED
 FRACTIONS ± .01
 XX DECIMALS ± .01
 XXX DECIMALS ± .005
 ANGLES ± 0°15'
 BREAK SHARP EDGES .06 MAX
 FINISH .125 UNLESS OTHERWISE SPECIFIED

DES: P. L. GORANSON 27MAR04
 DRW: G. FORTIER 28MAR04
 CHK: G. LOVETT 6APR04
 SECT: :
 DEPT: :
 PE: :
 CR: :
 PJ: :
 RED: :
 PPPL DRFT: J. SIEGEL 7/27/04
 VERSION NO. 0
 PLANT X-10
 BLDG 5700
 FL 3
 SHT 1
 OF 1
 TYPE I
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 REV I

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 Oak Ridge National Laboratory
 managed for the DEPARTMENT OF ENERGY under
 U.S. GOVERNMENT contract DE-AC05-00OR22725
 UT-BATTELLE, LLC, Oak Ridge, Tennessee
 PROJECT NAME
NATIONAL COMPACT STELLARATOR EXPERIMENT
VACUUM VESSEL JOINT R&D
SPOOL PIECE SEAL
WELDMENT
 SE1203-006

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