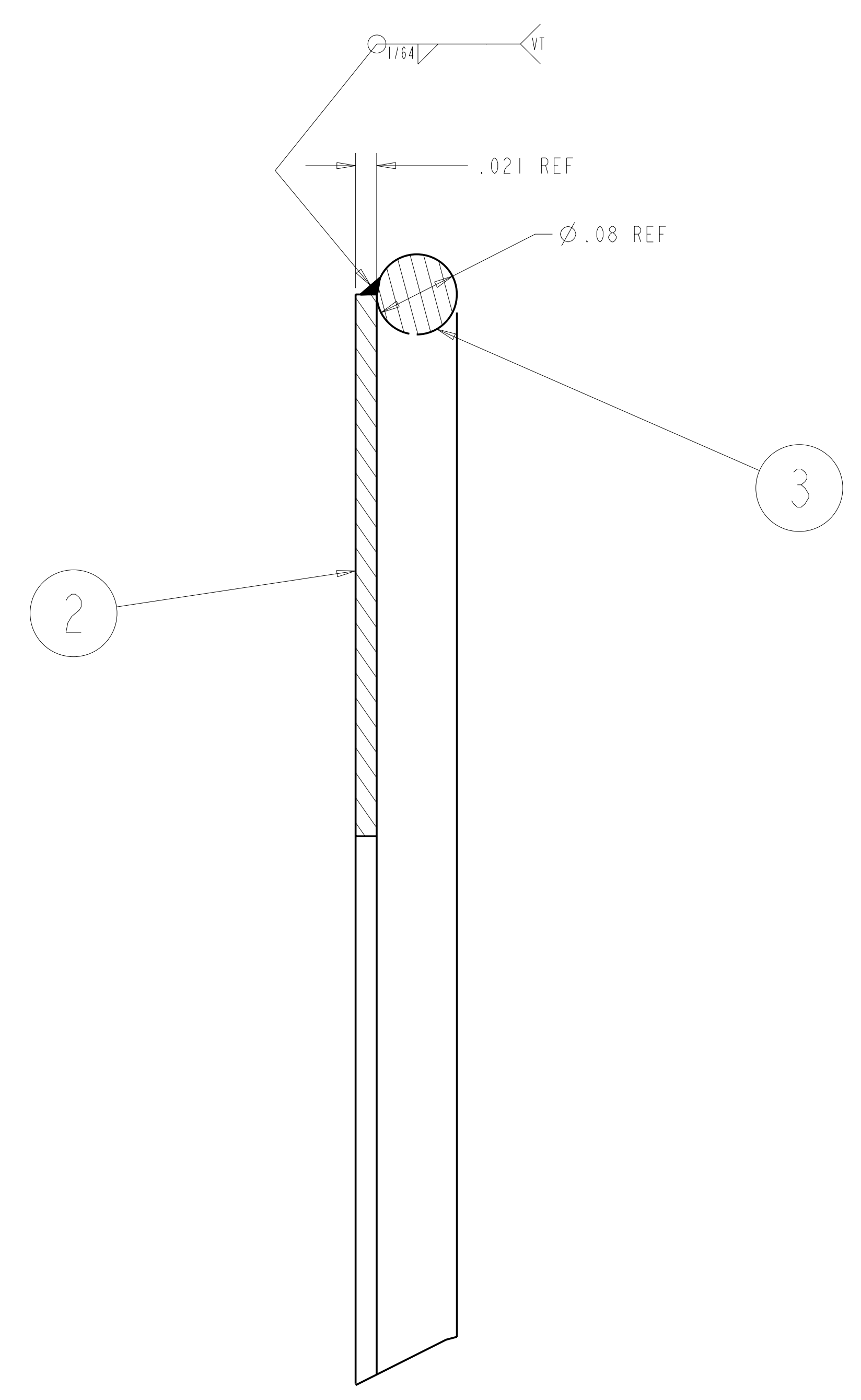
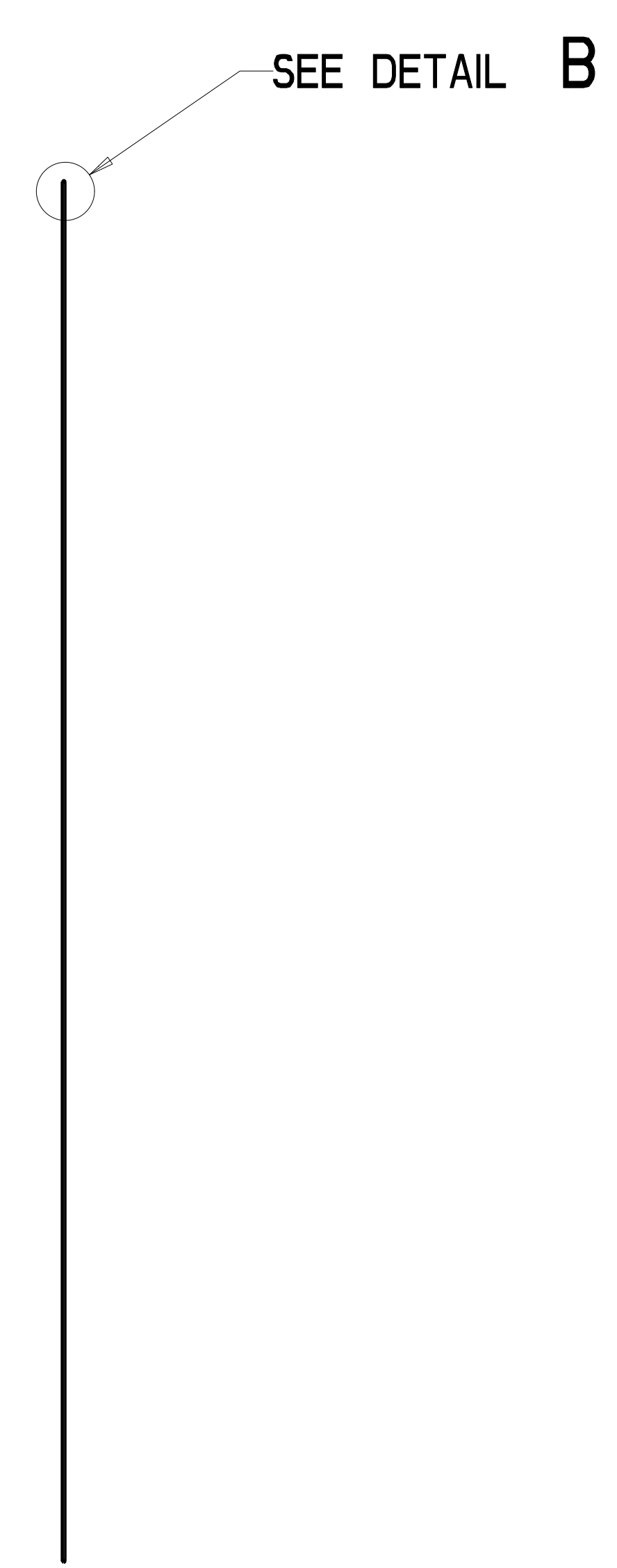


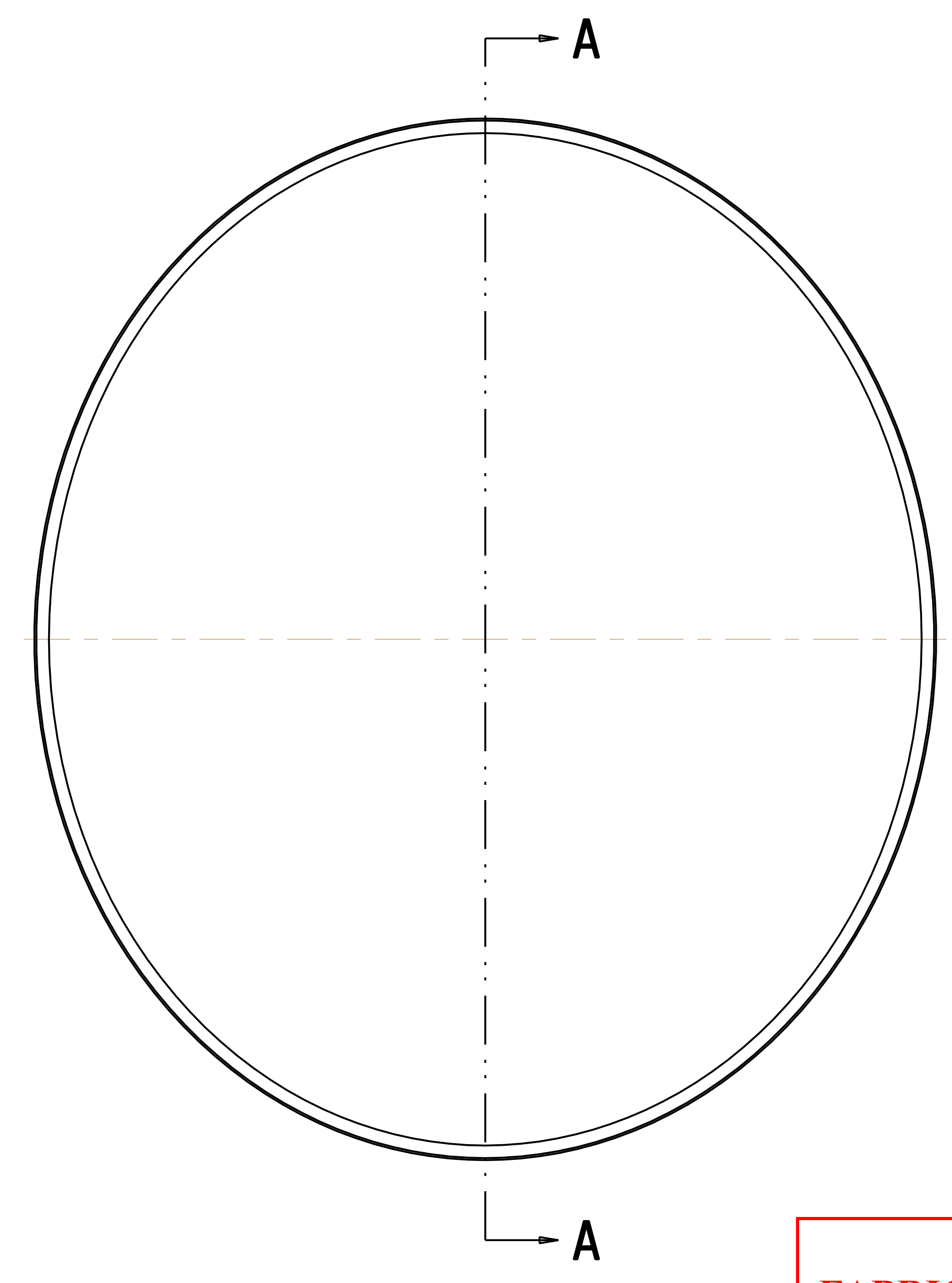
- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
  2. DIMENSION ARE IN INCHES.
  3. REQUIREMENTS FOR FABRICATING THE SPOOL SEAL WELDMENT ARE DEFINED IN THE DRAWINGS, MODELS, AND NCSX-SOW-121-02-00.
  4. GEOMETRY OF SPOOL SEAL WELDMENT IS DEFINED IN CAD MODELS/FILES SE1203-008.ASM, SE1203-017.PRT AND SE1203-018.PRT.
  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 QCI OR SNT-TC-1A, LEVEL II OR LEVEL III.



**DETAIL B**  
 SCALE 10.000



**SECTION A-A**



SCALE 0.250

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

REV	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
1	SE1203-018	VVFWJ SPOOL PIECE WELD WIRE .080 DIA.		INCONEL	UNS N06625	3
1	SE1203-017	VVFWJ SPOOL PIECE SEAL .021 THICK		INCONEL	UNS N06625	2
1	SE1203-008	VVFWJ SPOOL SEAL WELDMENT		--	--	1

← NEXT ASSEMBLY

PARTS LIST

NO REPRESENTATION OR WARRANTY, EXPRESSED OR IMPLIED, IS MADE AS TO THE ACCURACY, COMPLETENESS OR USEFULNESS OF THE INFORMATION OR STATEMENTS CONTAINED IN THESE DRAWINGS, OR THAT THE USE OR DISCLOSURE OF ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS MAY NOT INFRINGE PRIVATE RIGHTS OF OTHERS. NO LIABILITY IS ASSUMED WITH RESPECT TO THE USE OF, OR FOR DAMAGES RESULTING FROM THE USE OF, ANY INFORMATION, APPARATUS, METHOD OR PROCESS DISCLOSED IN THESE DRAWINGS. DRAWINGS MADE AVAILABLE FOR INFORMATION TO BIDDER ARE NOT TO BE USED FOR OTHER PURPOSES, AND ARE TO BE RETURNED UPON REQUEST OF THE FORWARDING CONTRACTOR.

**P** THIS DRAWING PRODUCED ON PRO-ENGINEER

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	DRNL	DOE	DATE

SCALE AS NOTED  
 TOLERANCES UNLESS OTHERWISE SPECIFIED  
 FRACTIONS :  
 XX DECIMALS ± .01  
 XXX DECIMALS ± .005  
 ANGLES ± 0°15'  
 BREAK SHARP EDGES .06 MAX  
 FINISH :25 UNLESS OTHERWISE SPECIFIED

DES: P. GORANSON 27MAR04  
 DRW: G. FORTIER 28MAR04  
 CHK: G. LOVETT 6APR04  
 SECT :  
 DEPT :  
 PE :  
 CR :  
 PJ :  
 RD :  
 PPPL DRFT :  
 PPPL WELD ENGR - R. Parsells 4/10/04

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**NATIONAL COMPACT STELLARATOR EXPERIMENT**

SPOOL SEAL WELDMENT

VERSION NO.	PLANT ORNL	BLDG 5700	FL 3	SHT OF 1	TYPE D	CLASS U
RELEASE LEVEL	Fabrication		SE1203-008		REV 0	

SE1203-008