



-1-2-3 VVSA ASSEMBLY STATION 1 PHASE 3
 SCALE .09

ECN-5251 approved alternate welding detail to permit orbital welding for connecting heating and cooling tubes. See sketch.

RELEASED FOR FABRICATION / INSTALLATION

PPPL Drafting:

- NOTES
- DRAWING PREPARED IN ACCORDANCE WITH ASME Y14.100-2004.
 - INTERPRET DIMENSIONS AND TOLERANCES PER ASME Y14.5M-1994.
 - DIMENSIONS ARE IN INCHES
 - MAGNETIC PERMEABILITY NOT TO EXCEED 1.02 AS TESTED BY A SEVERN INDICATOR. AVAILABLE FROM:
 SEVERN ENGINEERING
 AUBURN, ALABAMA 36830
 WWW.SEVERENGINEERING.COM
 - WELDING SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF PPPL PROCEDURE ENG-037. VISUAL WELD INSPECTION SHALL BE PERFORMED IN ACCORDANCE WITH THE ACCEPTANCE CRITERIA OF AWS D1.1 SECTION 6.
 - ASSEMBLE PER THIS DRAWING AND SPECIFICATION NCSX-CSPEC-185-01.

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

WELDING ENGINEER
 APPROVED G. GETTELFINGER DATE: 10/2006

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SCALE NOTED

TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS :
 XX DECIMALS ± .01
 XXX DECIMALS ± .005
 ANGLES ±0'15"
 BREAK SHARP EDGES .06 MAX
 FINISH .125 UNLESS OTHERWISE SPECIFIED

DES: P GORANSON 10/06
 DRW: MT BROWN 10/06

UT-BATTELLE
 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

VVSA ASSEMBLY STATION 1 PHASE 3

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PPPL DRFT J SIEGEL 10/06

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VERSION NO. 3
 PLANT ORNL
 BLDG 5700
 FL 3
 SHT 1
 OF 1
 TYPE A
 CLASS U

RELEASE LEVEL Fabrication

SEI21-009

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