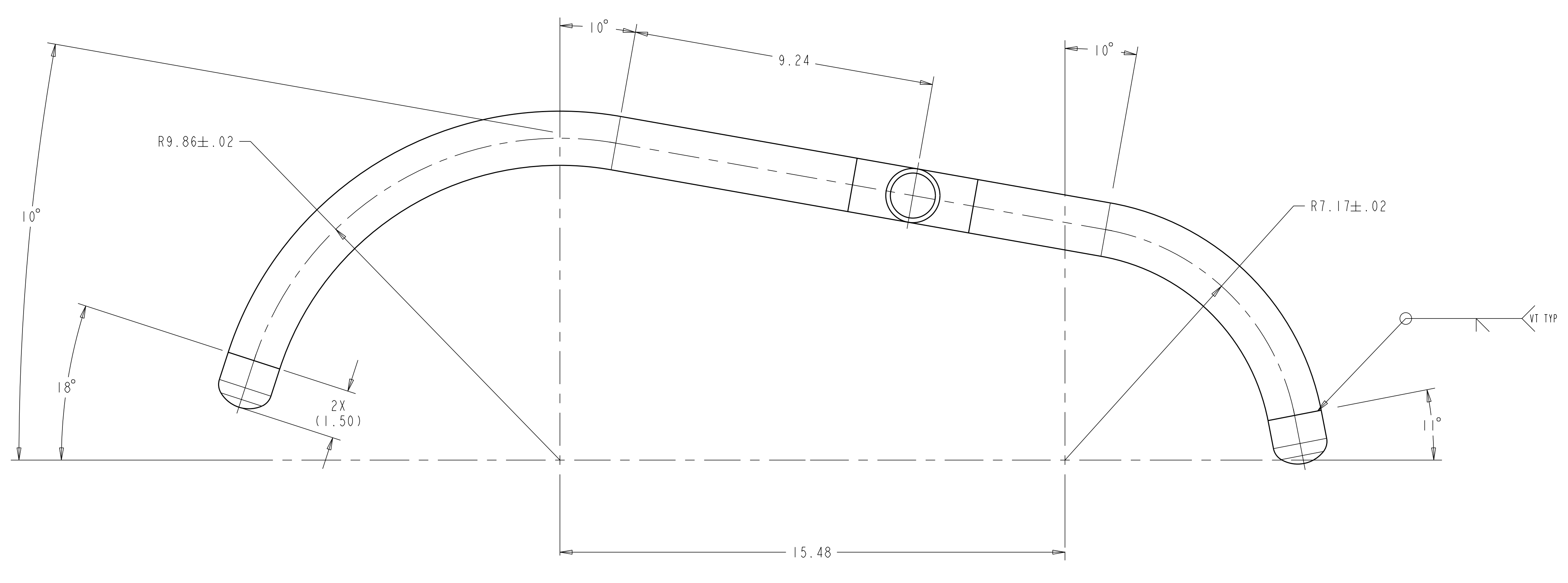
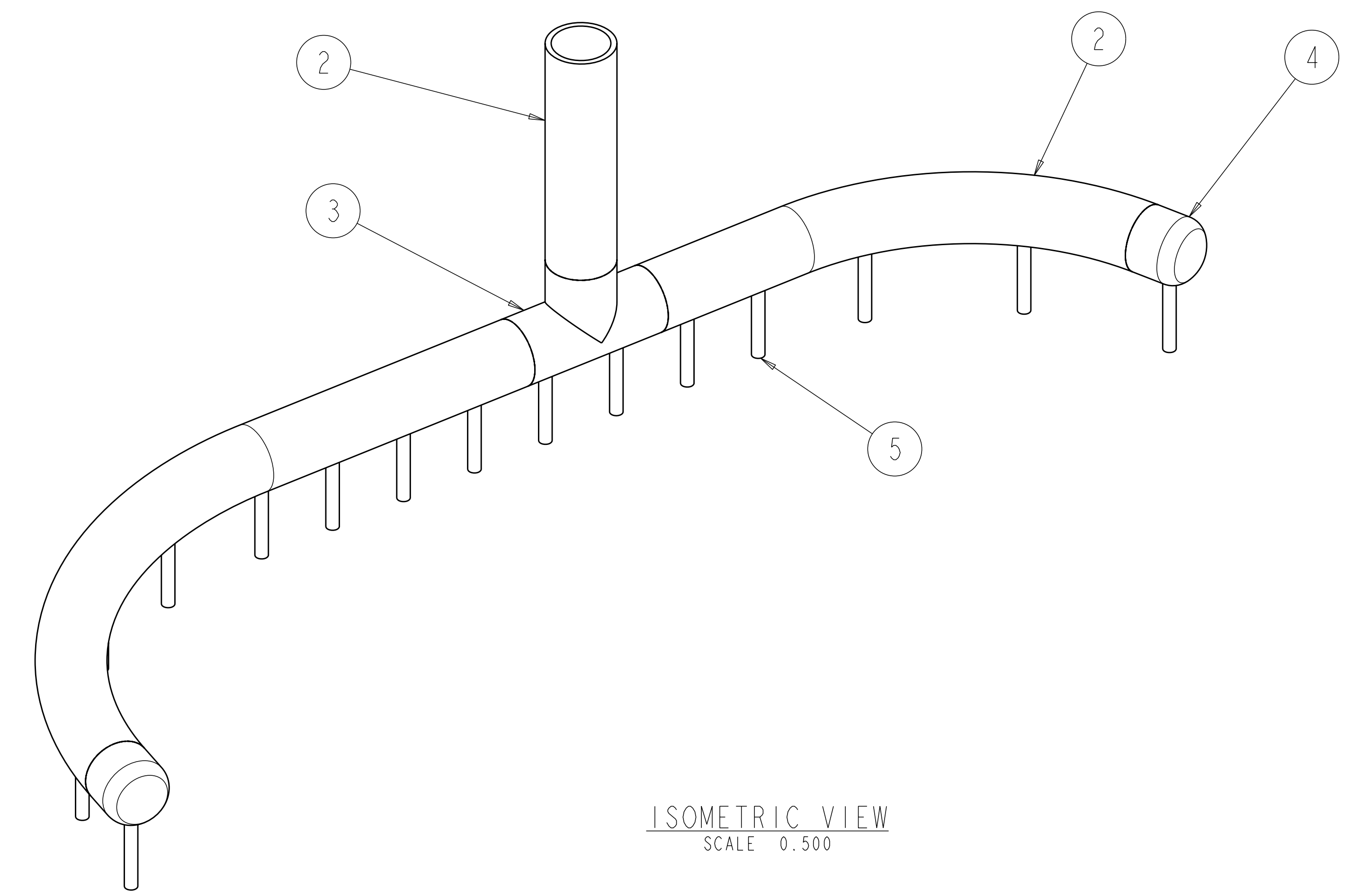
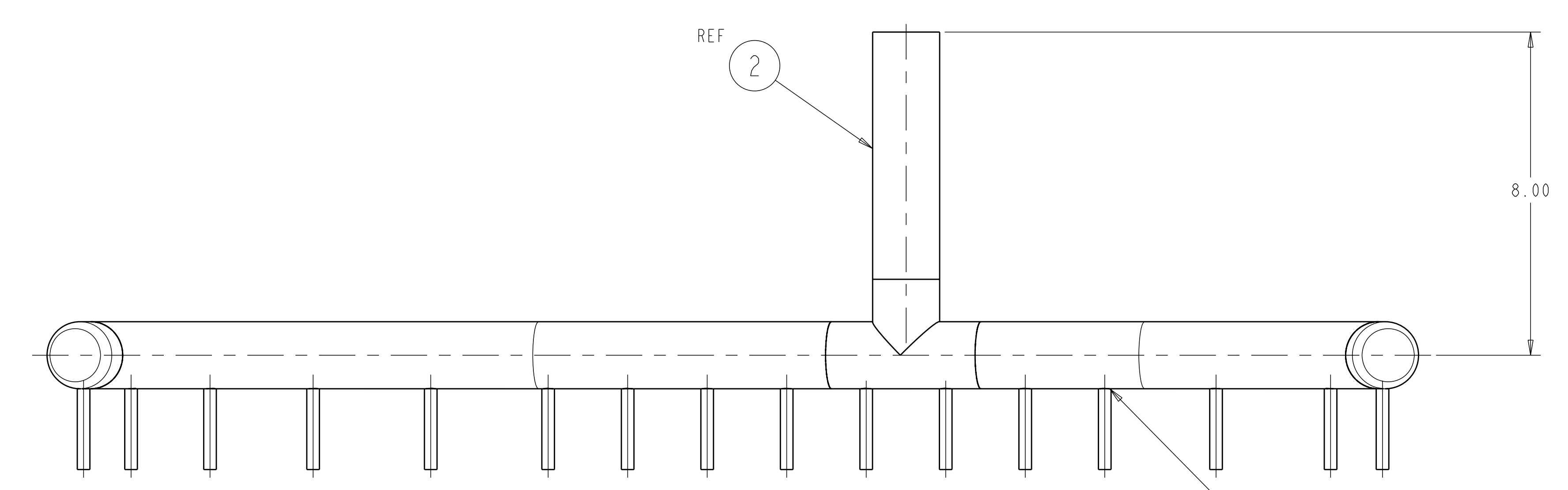


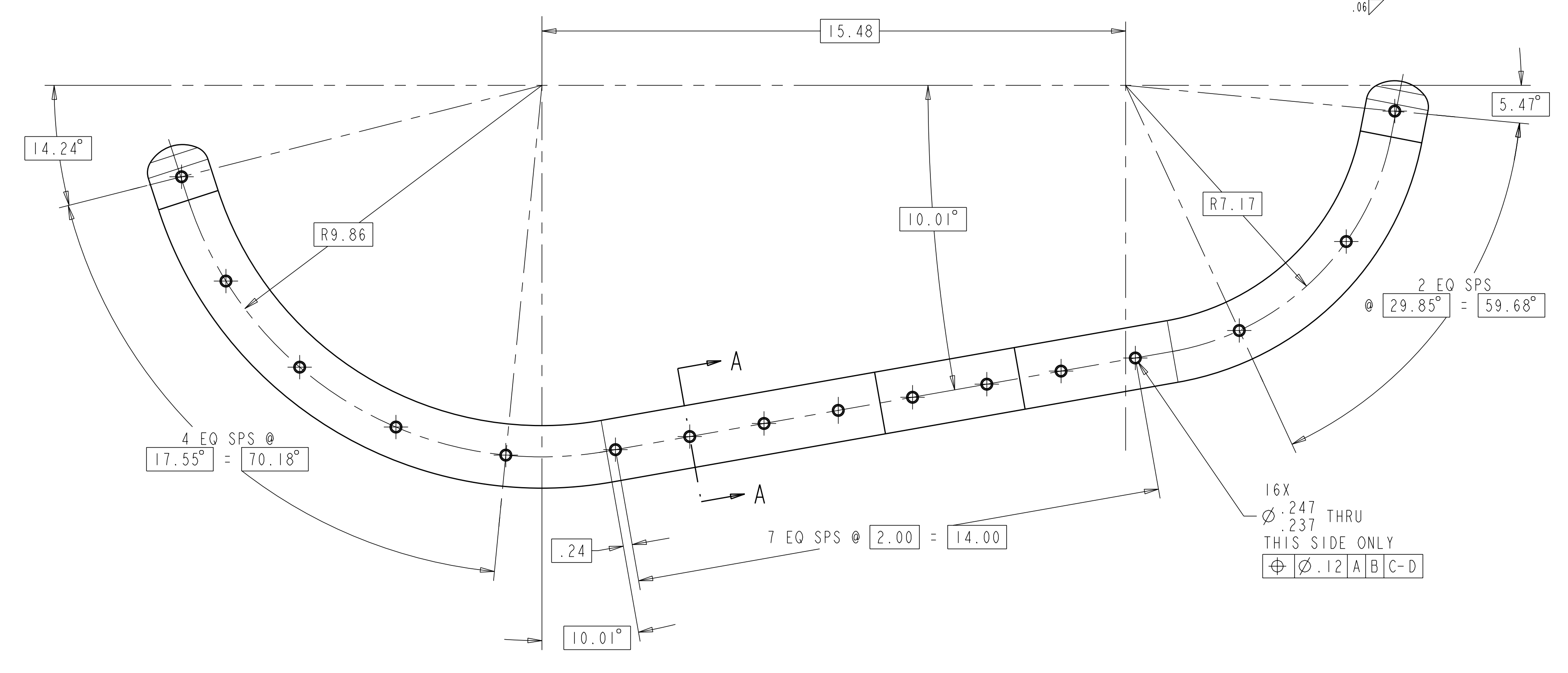
- NOTES**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES
 3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.
 4. 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.



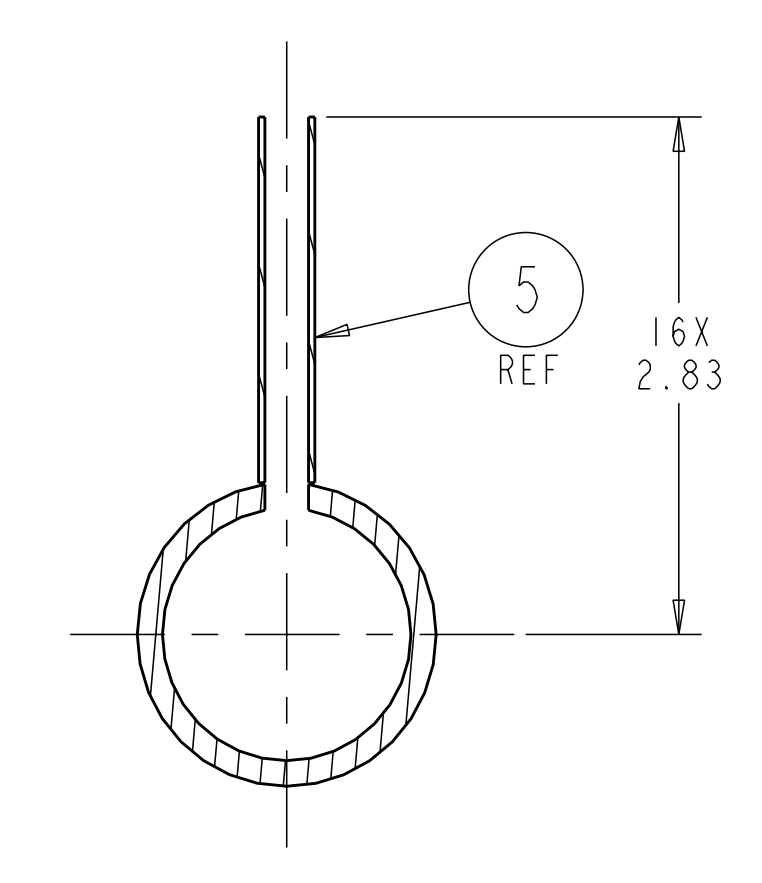
VIEW FOR TUBE FABRICATION



ISOMETRIC VIEW
SCALE 0.500



VIEW FOR HOLE LOCATION



SECTION A-A
SCALE 1.00

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting:

WELDING ENGINEER
APPROVED B. KEILBACH DATE: 10/05

AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
AR		-6		WELD FILLER METAL		6
16		-5	TUBE, 5/16 O.D. X .035 WALL	316L SST ANNEALED	ASTM A269	5
2		-4	BUTT WELD END CAP, 1 1/4 SCH 40	316L SST ANNEALED	ASTM A351	4
1		-3	BUTT WELD TEE, 1 1/4 SCH 40	316L SST ANNEALED	ASTM A351	3
AR		-2	PIPE, 1 1/4 SCH 40	316L SST ANNEALED	ASTM A312	2
AR		-1		INNER HEADER B WELDMENT		1
SE123-049						

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
0	ORIGINAL ISSUE											

SCALE NOTED: TOLERANCES UNLESS OTHERWISE SPECIFIED

FRACTIONS: DEPT: :
 XX DECIMALS: ±.003
 XXX DECIMALS: ±.005
 ANGLES: ±0°15'
 BREAK SHARP EDGES: .06 MAX
 FINISH: .125 UNLESS OTHERWISE SPECIFIED

DES: P. L. GORANSON 04/07/05
 DRW: G. H. JONES 04/07/05
 CHK: S. PARSON 05/05

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NATIONAL COMPACT STELLARATOR EXPERIMENT
 VACUUM VESSEL HEATING/COOLING
 INNER HEADER B
 WELDMENT

PPPL DRFT J SIEGEL 10/05
 VERSION NO. 3
 PLANT X10
 BLDG 5700
 FL 3
 SHT 1
 OF 1
 TYPE B
 CLASS REV 0

RELEASE LEVEL: Fabrication
 SE123-161

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE: .50

