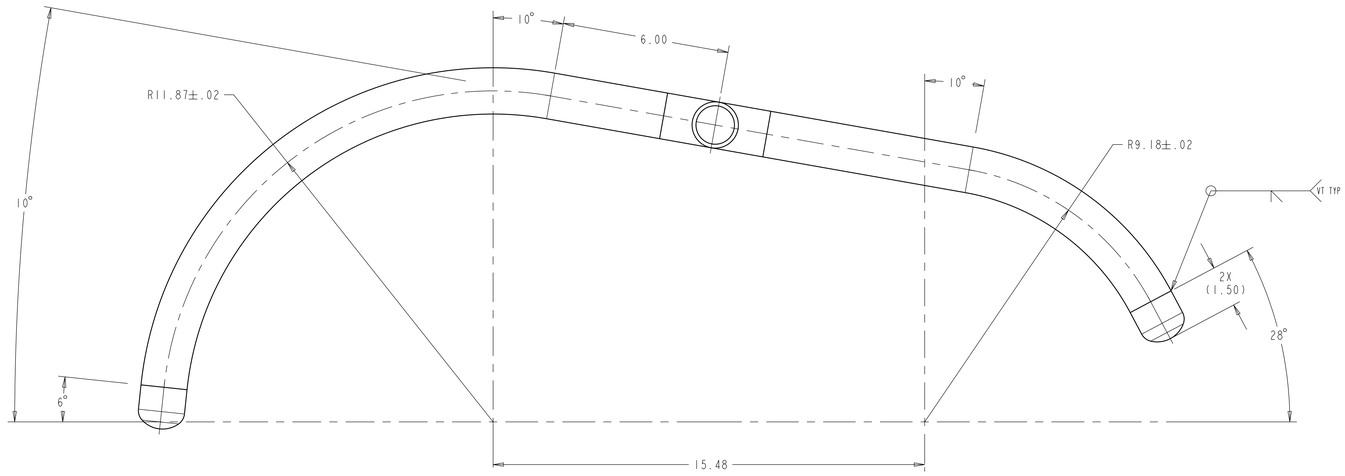
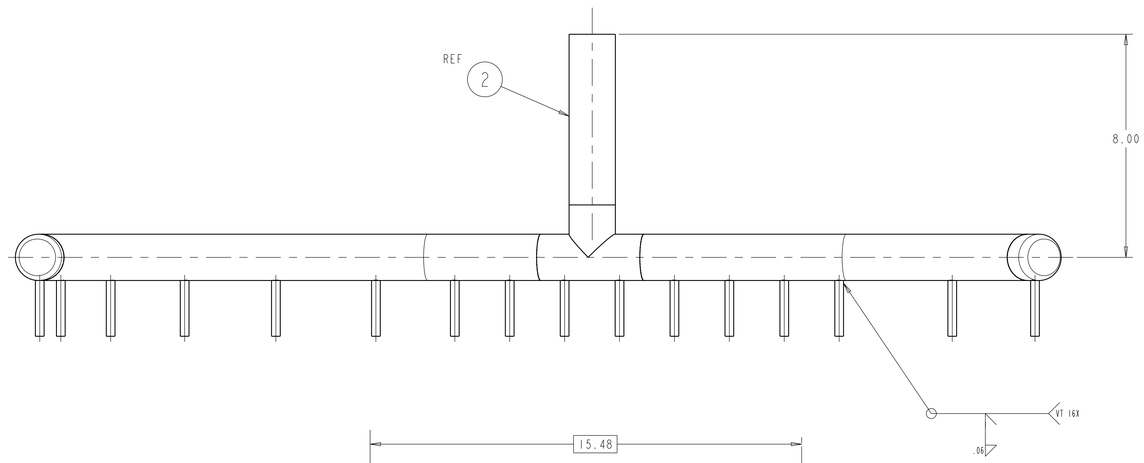
NEXT ASS'Y: FINAL ASS'Y:

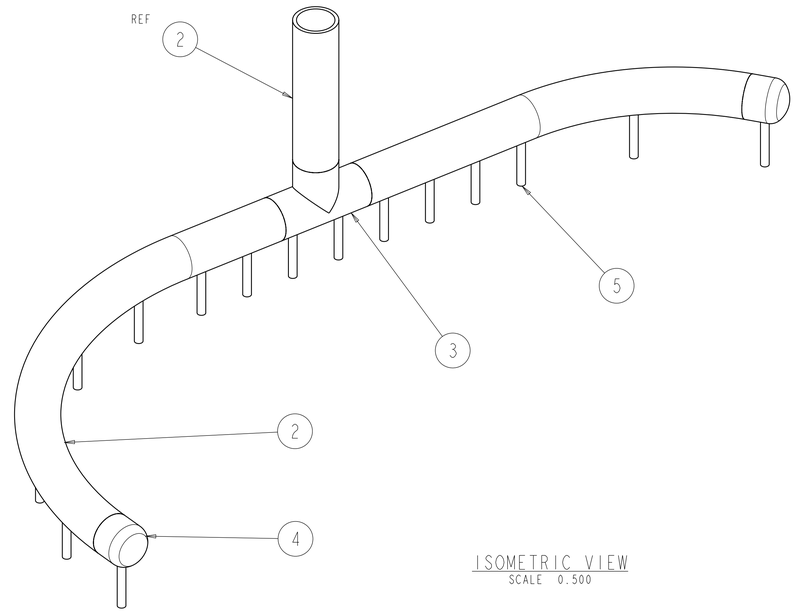


NOTES

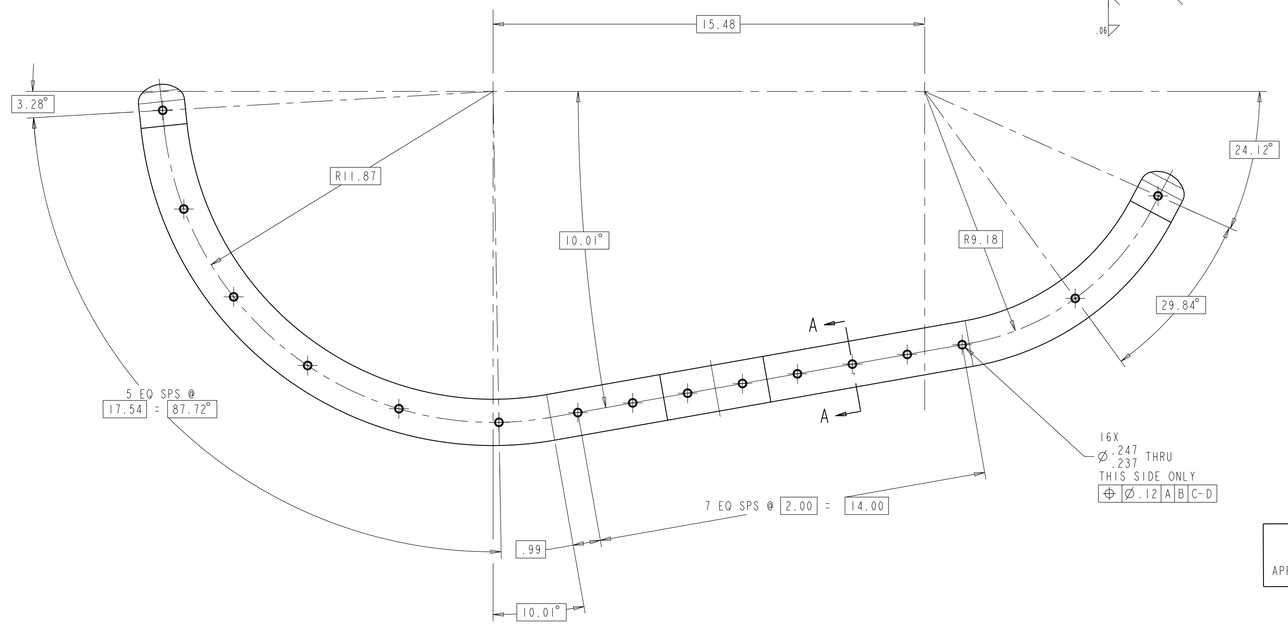
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSIONS ARE IN INCHES
3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCOURDANCE WITH THE RREQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES.
   WELDS USING SMAW PROCESS ARE 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

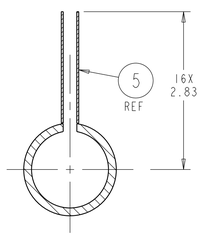




ISOMETRIC VIEW
SCALE 0.500



VIEW FOR HOLE LOCATION



SECTION A-A
SCALE 1.00

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: ? Jerry Siegel 2005.10.28 13:24:53 -05'00'

WELDING ENGINEER
APPROVED B. KEILBACH DATE: 10/05

	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	X	-1	OUTER HEADER B WELDMENT			1
SE123-049	-1	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		← NEXT ASSEMBLY		PARTS LIST			

SE123-163

P THIS DRAWING PRODUCED ON PRO-ENGINEER

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

REVISION OR ISSUE PURPOSE — REVISION APPROVAL

SCALE NOTED
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS ±.03
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH .125 UNLESS OTHERWISE SPECIFIED

DRAWING APPROVALS	DATE
DES P.L.GORANSON	04/07/05
DRW G.H. JONES	04/07/05
CHK S PARSON	05/05
SECT :	:
DEPT :	:
PE :	:
CR :	:
PJ :	:
REQ :	:
PPPL DRFT J SIEGEL	10/05
:	:
:	:

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UT-BATTELLE, LLC. Oak Ridge, Tennessee

NATIONAL COMPACT STELLARATOR EXPERIMENT

VACUUM VESSEL HEATING/COOLING OUTER HEADER B WELDMENT

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
3	X10	5700	3	1	1	B	U

PROJECT NAME

RELEASE LEVEL: Fabrication — SE123-163 — REV 0