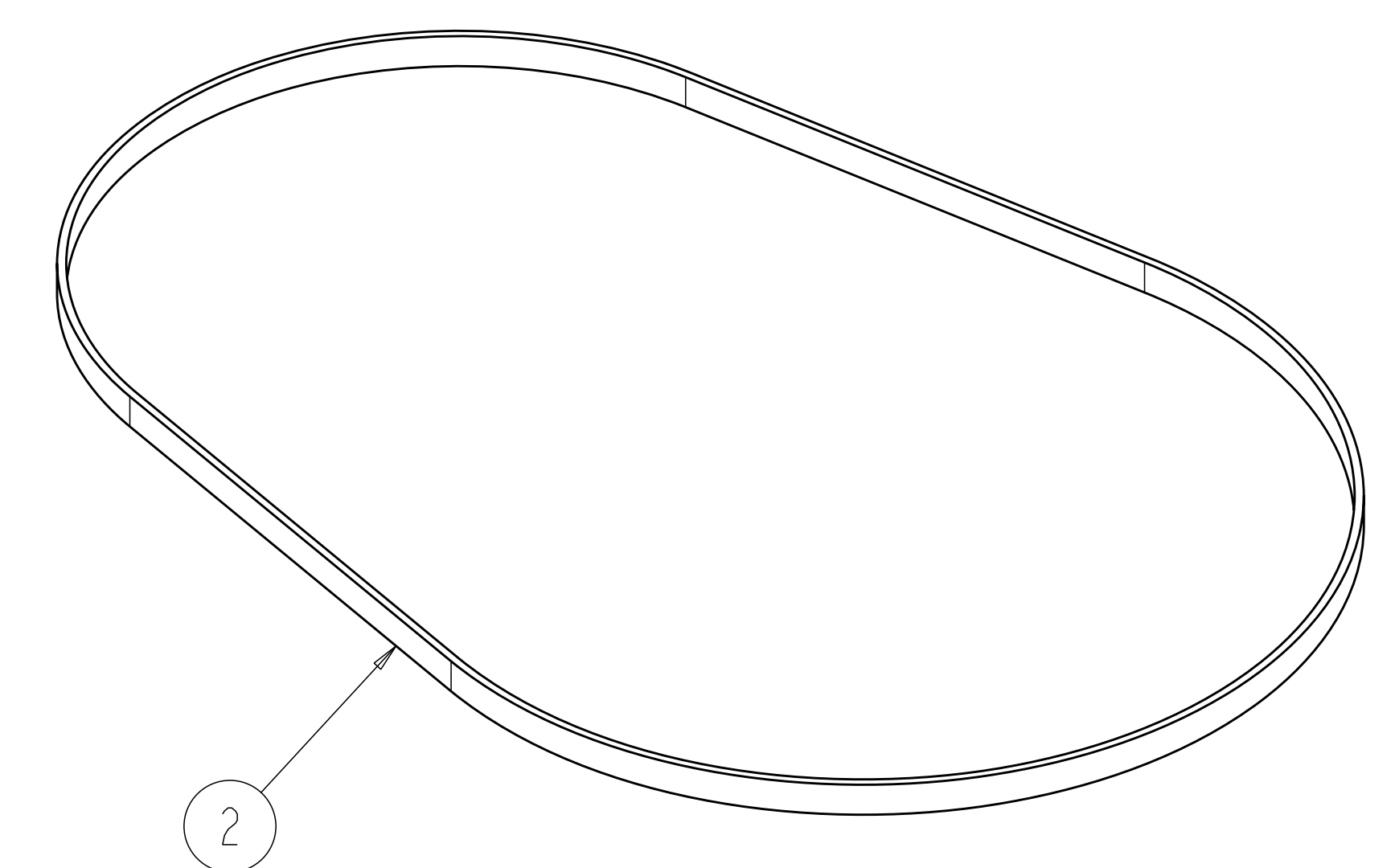
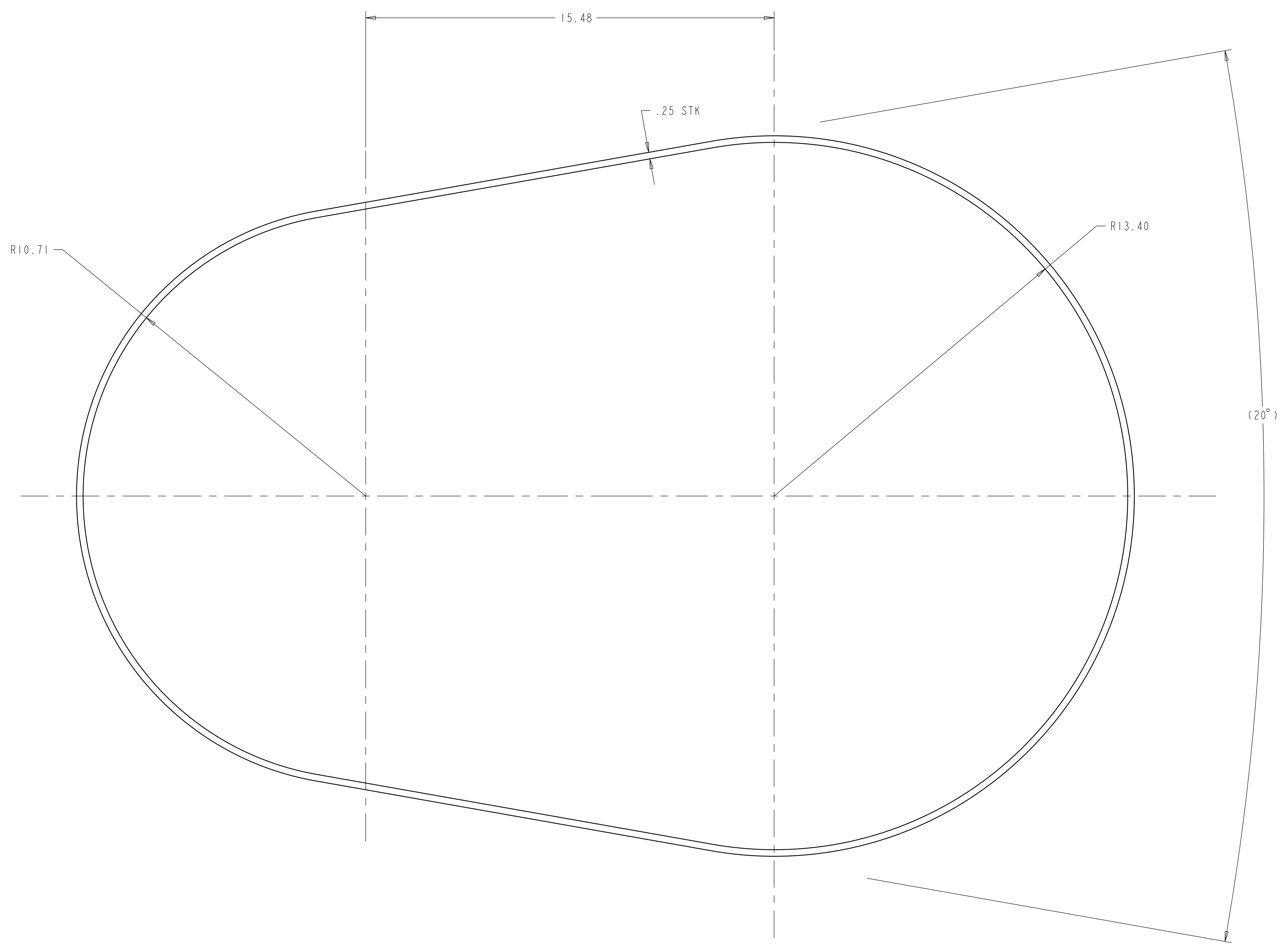
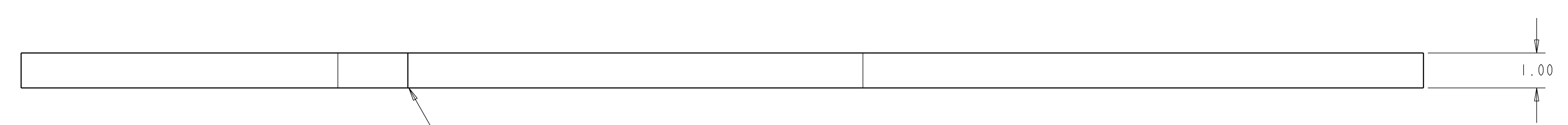


- NOTES**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES
 3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS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



ISOMETRIC VIEW
SCALE: 0.25



SCALE: .50

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

AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
AR			CRYOSTAT INTERFACE FLANGE LIP WELDMENT	316L SST ANNEALED	ASTM A240	2
SE123-166			NEXT ASSEMBLY			

WELDING ENGINEER
APPROVED B. KEILBACH DATE: 10/05

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

SCALE	NOTED	DES	P. L. GORANSON	04/07/05
TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW	G. H. JONES	04/07/05
FRACTIONS		CHK	S. PARSON	05/05
XX DECIMALS ±.003		SECT		
XXX DECIMALS ±.0005		DEPT		
ANGLES ±0°15'		CR		
BREAK SHARP EDGES .06 MAX		PJ		
FINISH .125 UNLESS OTHERWISE SPECIFIED		REQ		
		PPPL DRFT	J. SIEGEL	10/05

UT-BATTELLE	Oak Ridge National Laboratory Managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract # AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee					
PROJECT NAME NATIONAL COMPACT STELLARATOR EXPERIMENT						
VACUUM VESSEL HEATING/COOLING CRYOSTAT INTERFACE FLANGE LIP WELDMENT						
VERSION NO.	PLANT	BLDG	FL	SHT OF	TYPE	CLASS
4	X10	5700	3	1	I	B
RELEASE LEVEL		Fabrication		SE123-166		
DRAWING APPROVALS		DATE		REV 0		

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

