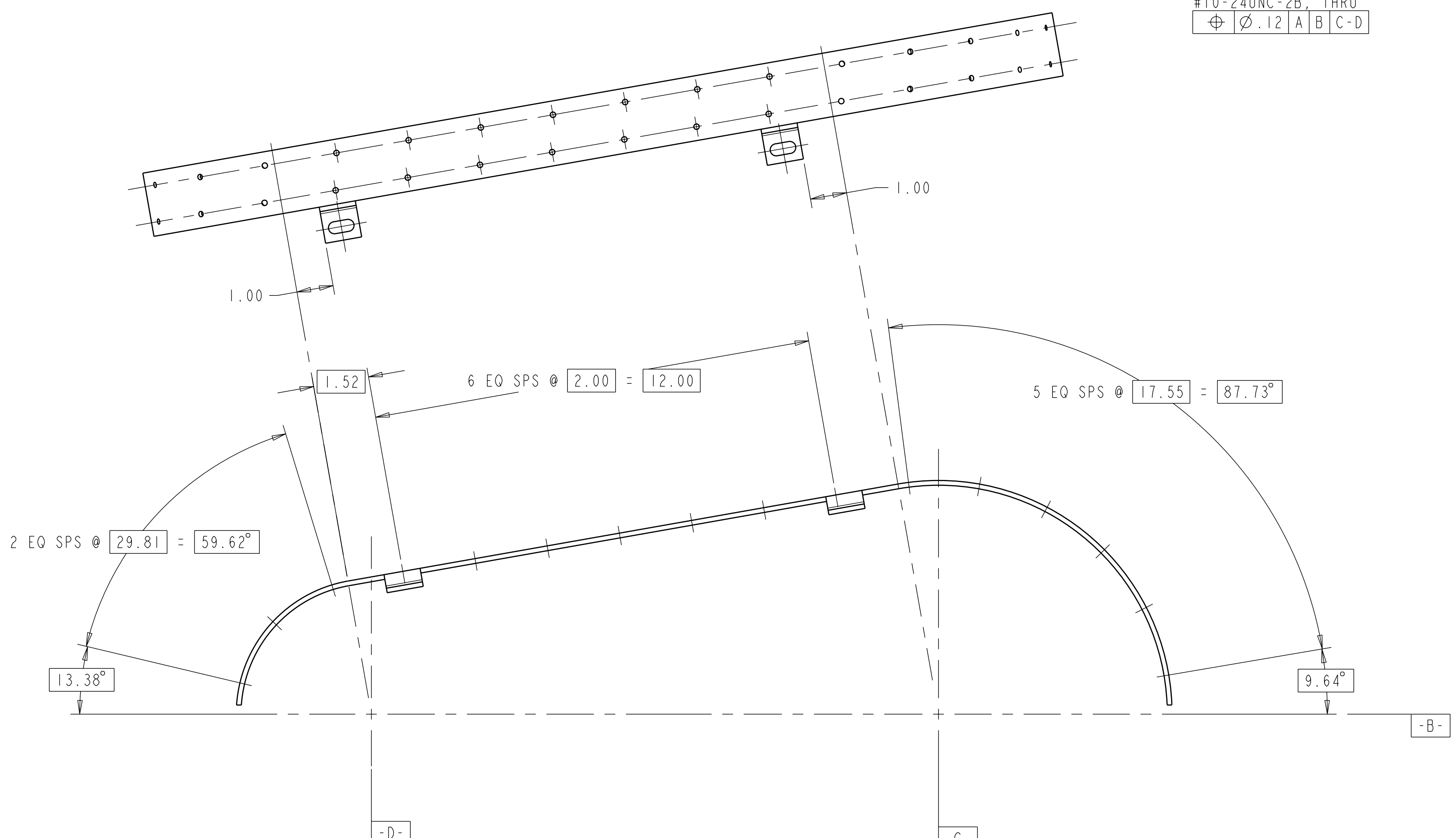
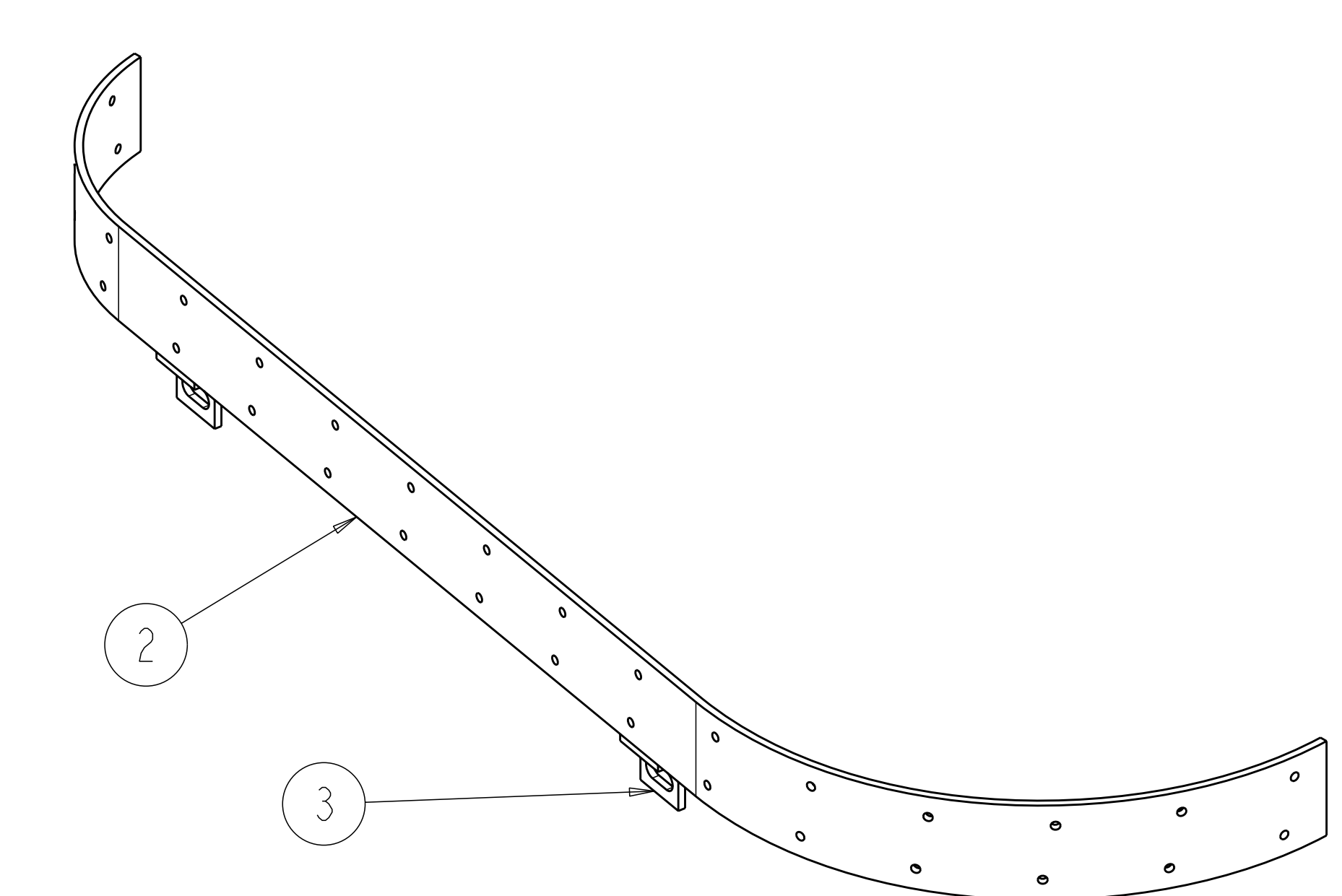
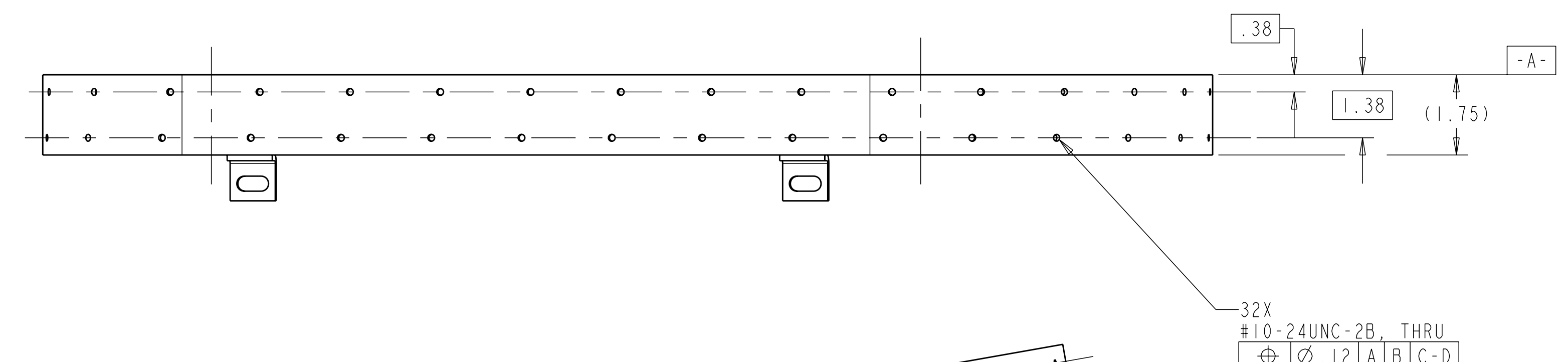
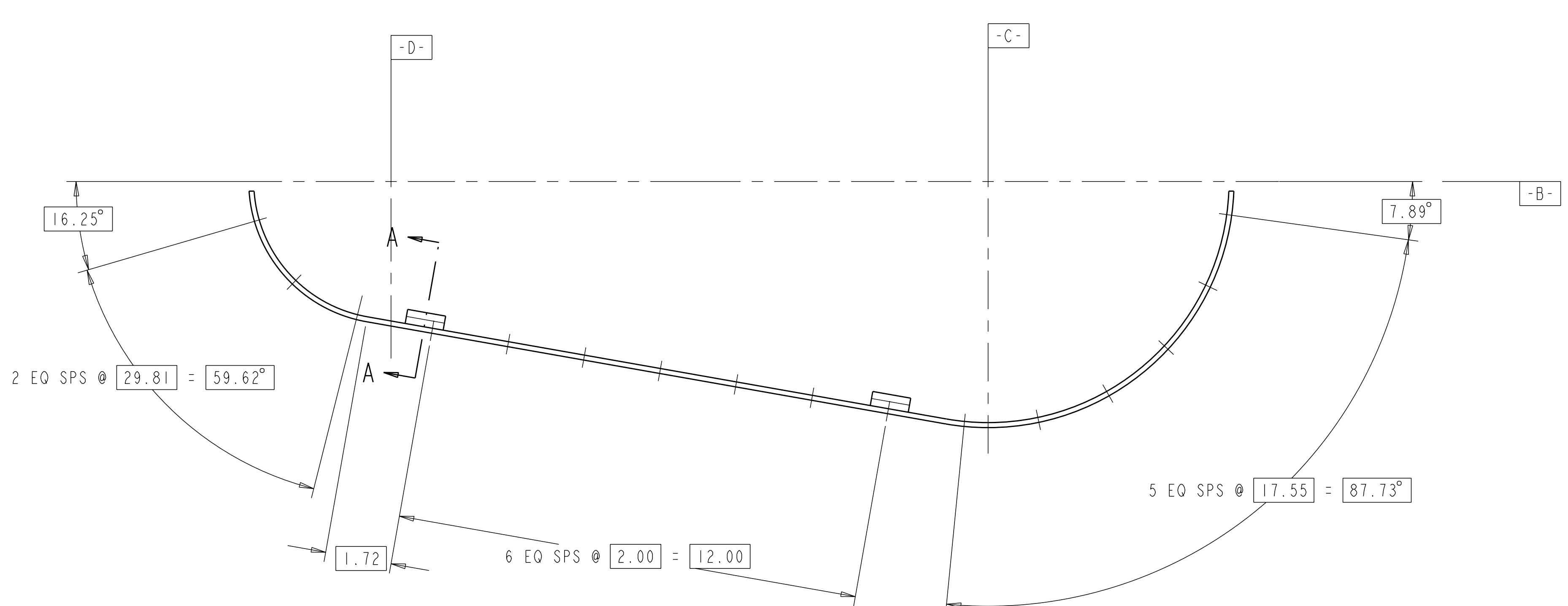
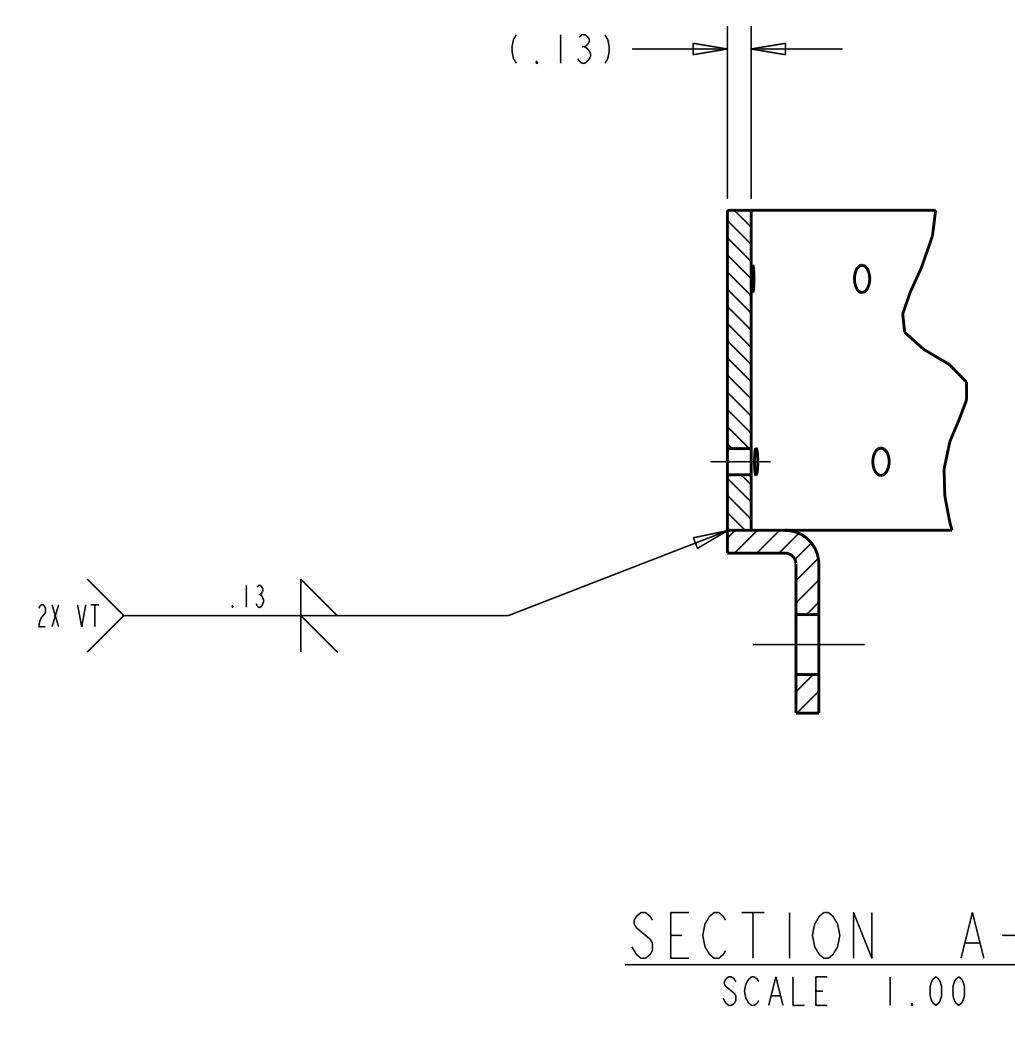


- NOTES**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
  2. DIMENSIONS ARE IN INCHES
  3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS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



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

AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		-4	WELD FILLER METAL			4
2		SE123-172-2	MOUNTING BRACKET			3
1		SE123-172-1	MOUNTING SUPPORT			2
AR		-1	SUPPORT BRACKET A WELDMENT			1
SE123-049			NEXT ASSEMBLY			

WELDING ENGINEER  
APPROVED **B. KEILBACH** DATE **10/05**

1  
SCALE: .50

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	ORNL	DOE	DATE
0	ORIGINAL ISSUE											
1	REVISION OR ISSUE PURPOSE											

SCALE NOTED	DES P. L. GORANSON 04/28/05	<b>UT-BATTELLE</b> Oak Ridge National Laboratory Managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract #E-AC05-00OR22725 UT-BATTELLE, LLC, Oak Ridge, Tennessee
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW G. H. JONES 04/28/05 CHK S. PARSON 05/05	
FRACTIONS : DEPT :	SECT :	<b>NATIONAL COMPACT STELLARATOR EXPERIMENT</b> <b>VACUUM VESSEL HEATING/COOLING</b> <b>SUPPORT BRACKET A</b> <b>WELDMENT</b>
XX DECIMALS ±.003	PE :	
XXX DECIMALS ±.0005	CR :	
ANGLES ±0°15'	PJ :	
BREAK SHARP EDGES .06 MAX	REQ :	
FINISH .125 UNLESS OTHERWISE SPECIFIED	REVISION APPROVALS DATE	
	PPPL DRFT J SIEGEL 10/05	VERSION NO. 3
		PLANT X10
		BLDG 5700
		FL 3
		SHT 1
		TYPE 1
		CLASS B
		REV 0
		RELEASE LEVEL Fabrication
		SE123-170