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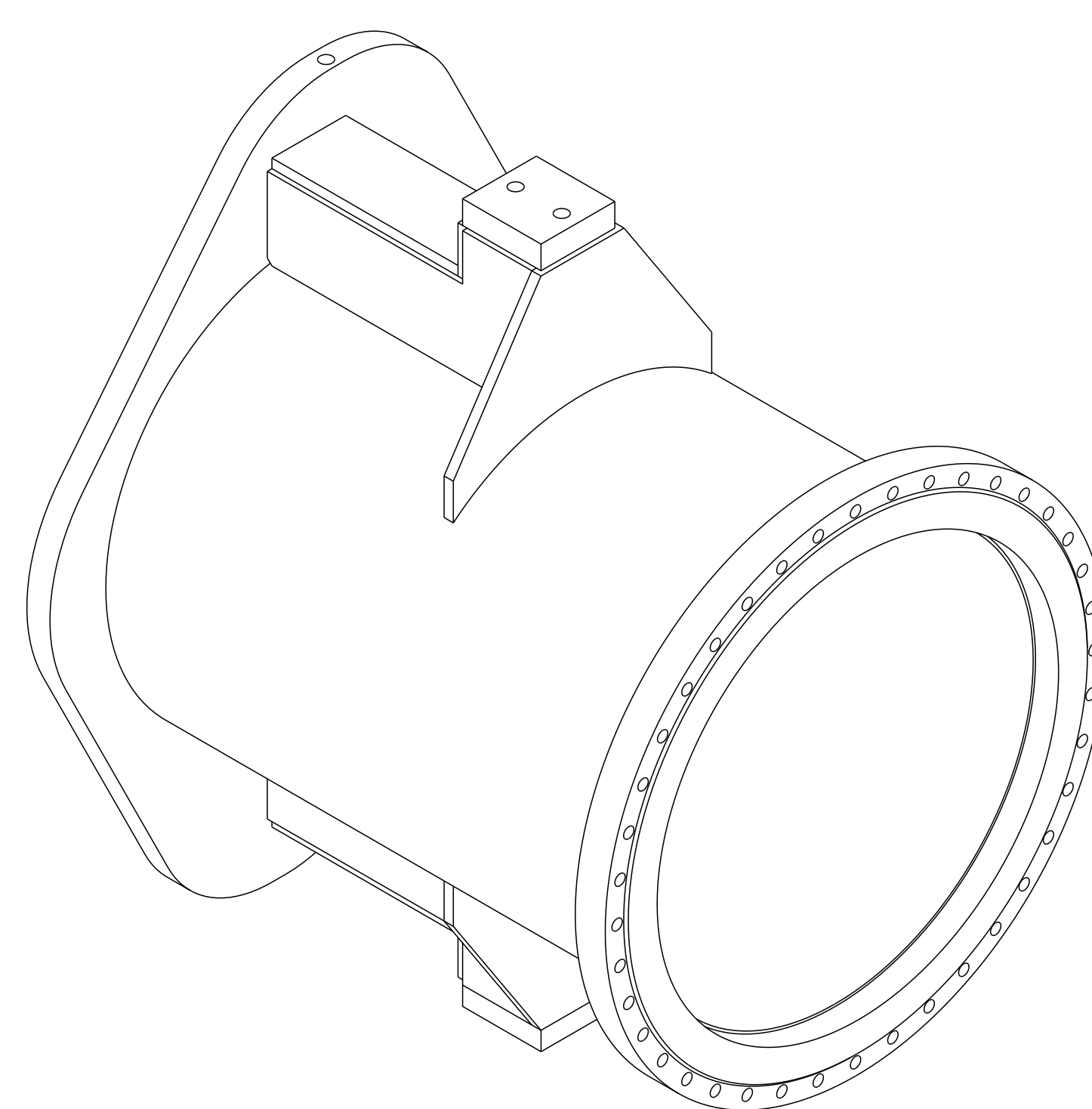
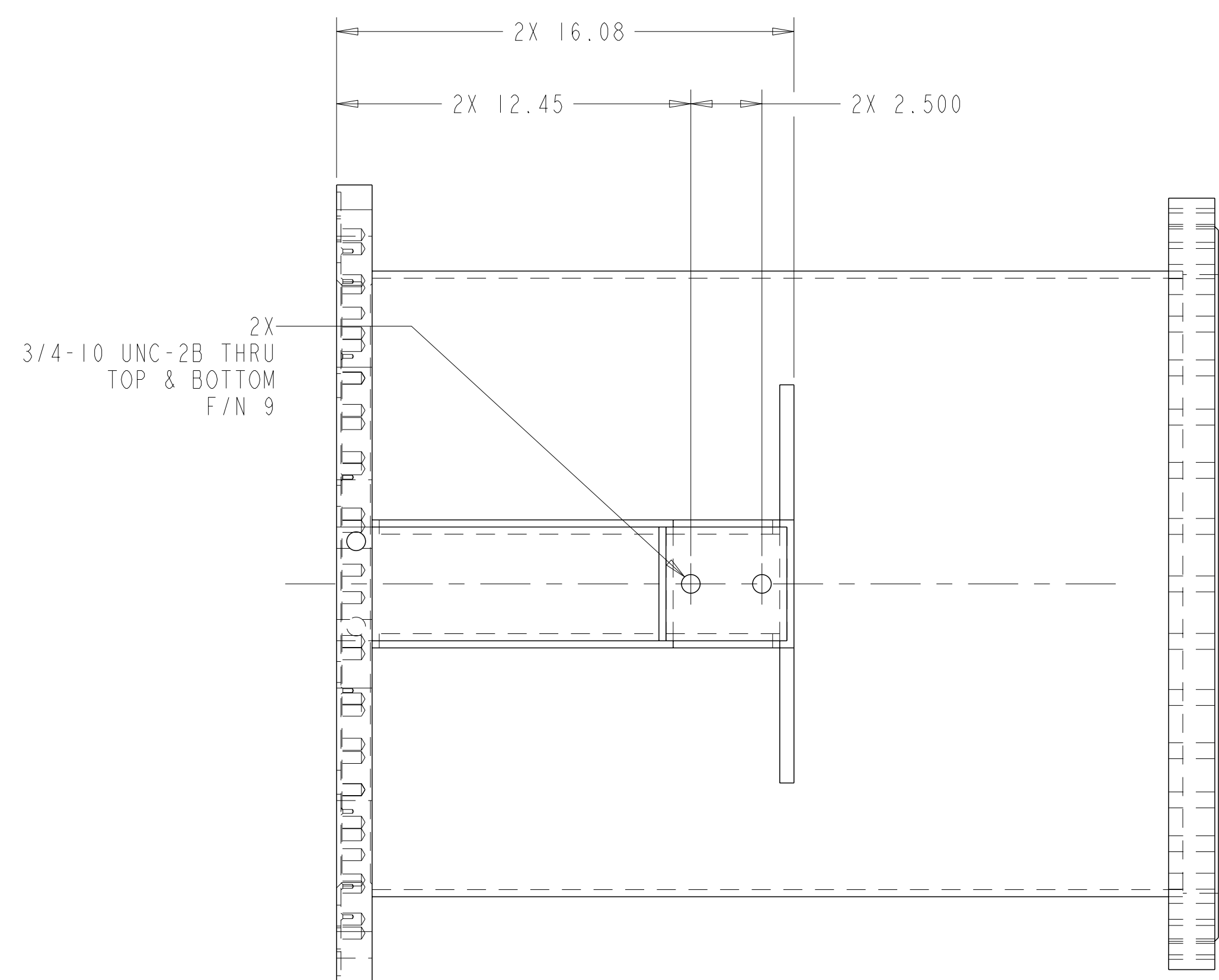
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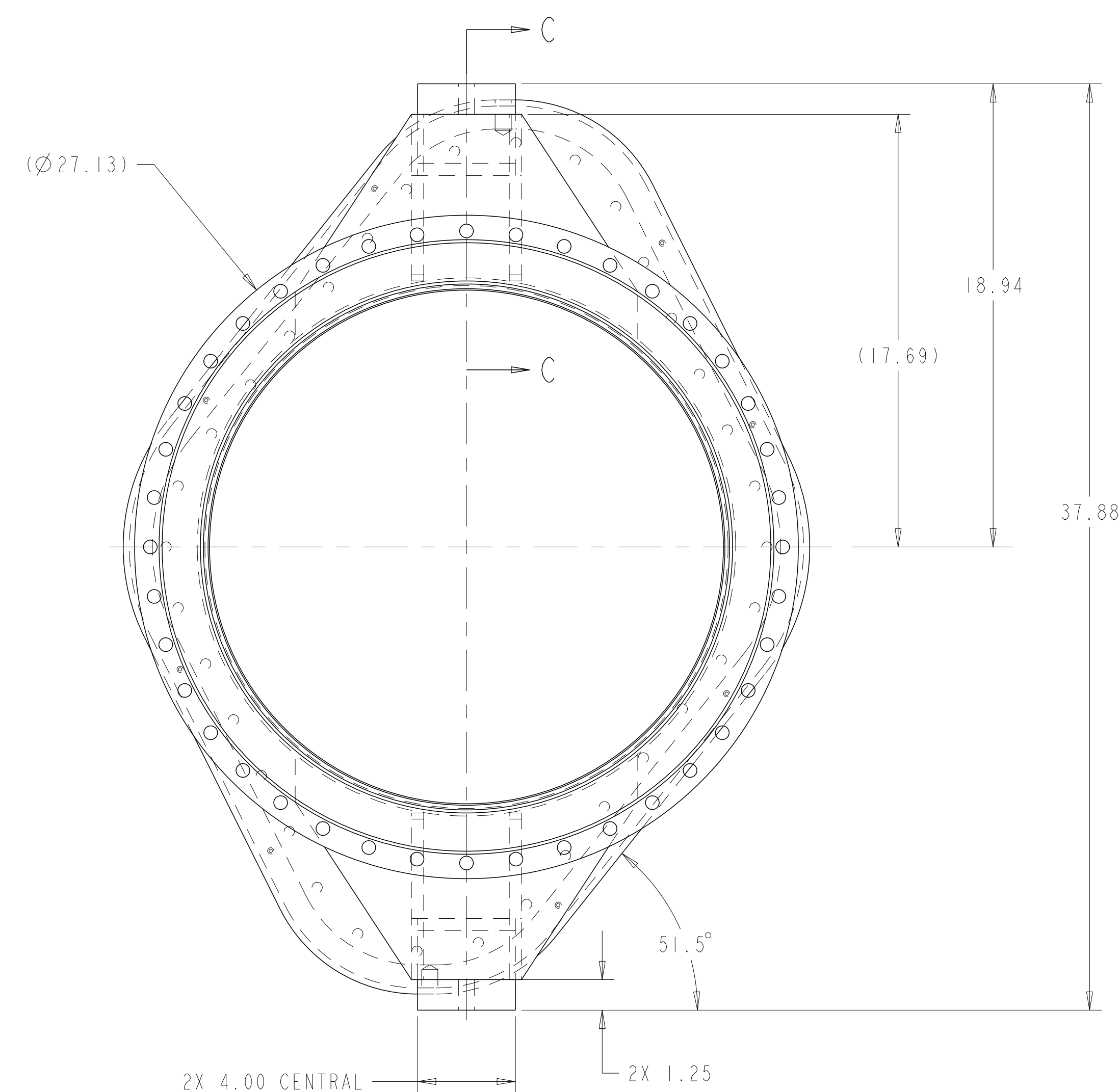
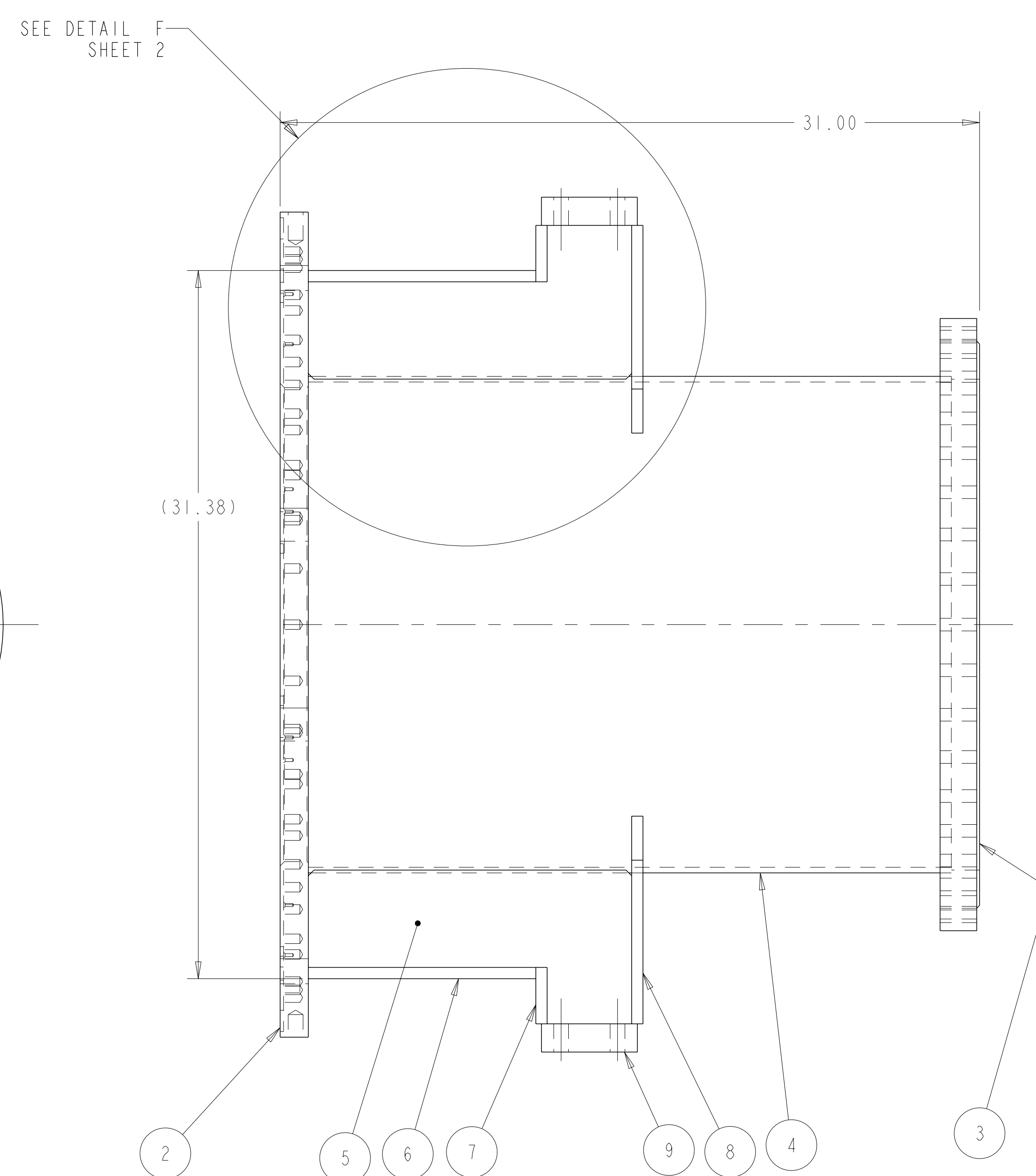
NEXT ASS'Y: 1 FINAL ASS'Y:

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 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.
5. FABRICATION, INSPECTION AND TESTING SHALL BE PERFORMED IN ACCORDANCE WITH SPECIFICATION NCSX-CSPEC-121-02-06 AND STATEMENT OF WORK NCSX-SOW-121-03.



SCALE 0.18



SCALE 0.25

WELDING ENGINEER
 APPROVED _____ DATE: _____

AR	REV	DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	-10	WELD FILLER METAL			10
	-9	1/4" PLATE			9
	-8	1/2" PLATE			8
	-7	1/2" PLATE			7
	-6	1/2" PLATE			6
	-5	1/2" PLATE			5
	-4	1/4" ROLLED PLATE			4
	SE121-133-1	MDC FLANGE MODIFICATION			3
	SE121-132-1	PORT COVER MODIFICATION			2
	-1	MAN HOLE PORT WELDMENT			1
SE121-130	-1	PART OR IDENTIFYING NO			
		NOMENCLATURE OR DESCRIPTION			
		MATERIAL			
		SPECIFICATION			
		FIND NO			

PARTS LIST

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 BIDDERS 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	MTB	06/05	DBR								

SCALE NOTED	DES BE NELSON	06/06
TOLERANCES UNLESS OTHERWISE SPECIFIED	DRW MT BROWN	06/05
FRACTIONS ±1/32	CHK D.B. RAINEY	08/05
XX DECIMALS ±.03	DEPT :	
XXX DECIMALS ±.005	PE :	
ANGLES ±0°15'	CR :	
BREAK SHARP EDGES .06 MAX	PJ :	
FINISH .125 UNLESS OTHERWISE SPECIFIED	RED :	
	PPPL DRFT :	

UT-BATTELLE		Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT CONTRACT DE-AC05-00OR2225 UT-BATTELLE, LLC, Oak Ridge, Tennessee	
PROJECT NAME NATIONAL COMPACT STELLARATOR EXPERIMENT			
MAN HOLE PORT WELDMENT			
VERSION NO.	PLANT	BLDG	FL SHT OF TYPE CLASS
pro1	ORNL	5700	3 1 2 B U
RELEASE LEVEL	SE121-131		REV 0
pro1	release		

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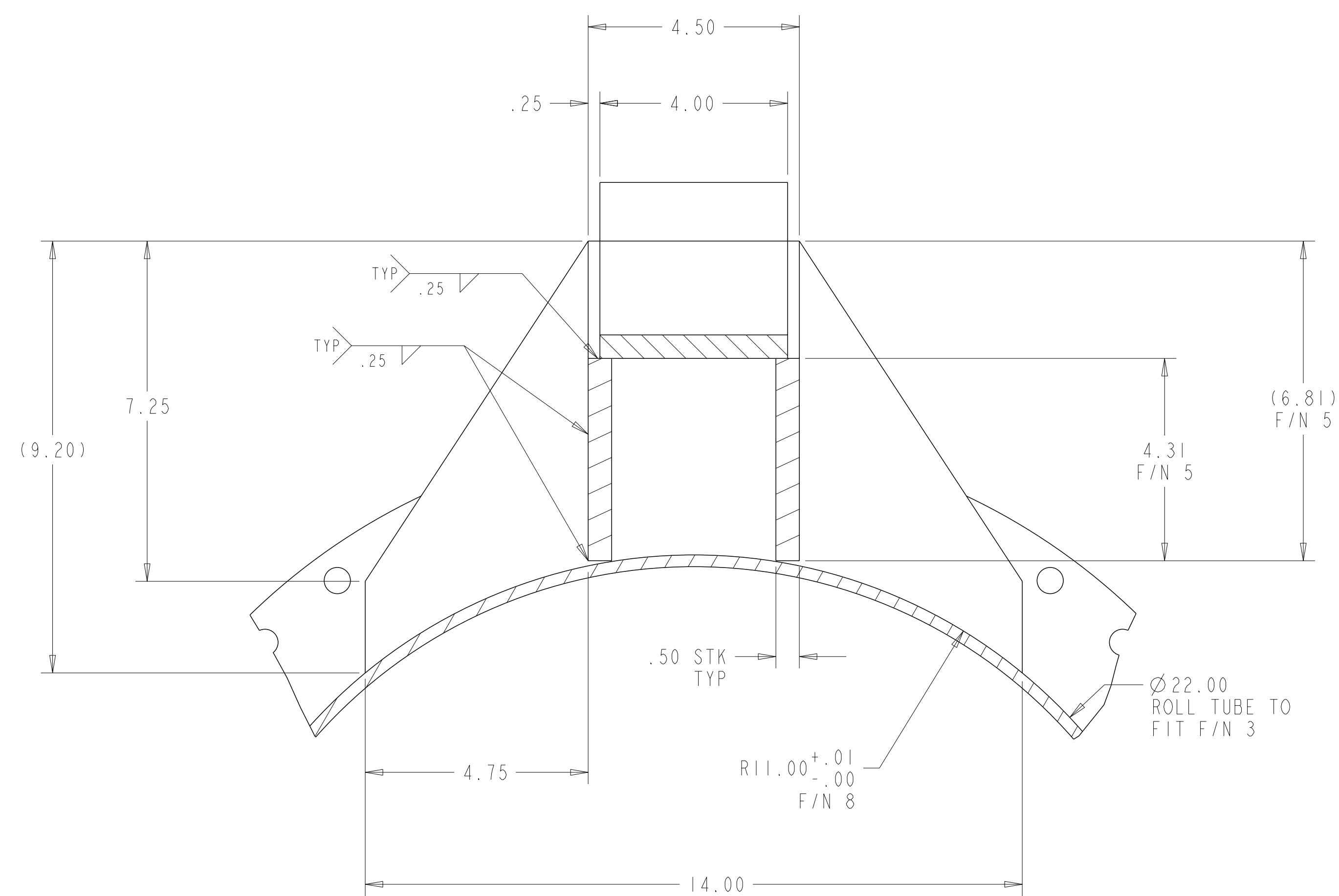
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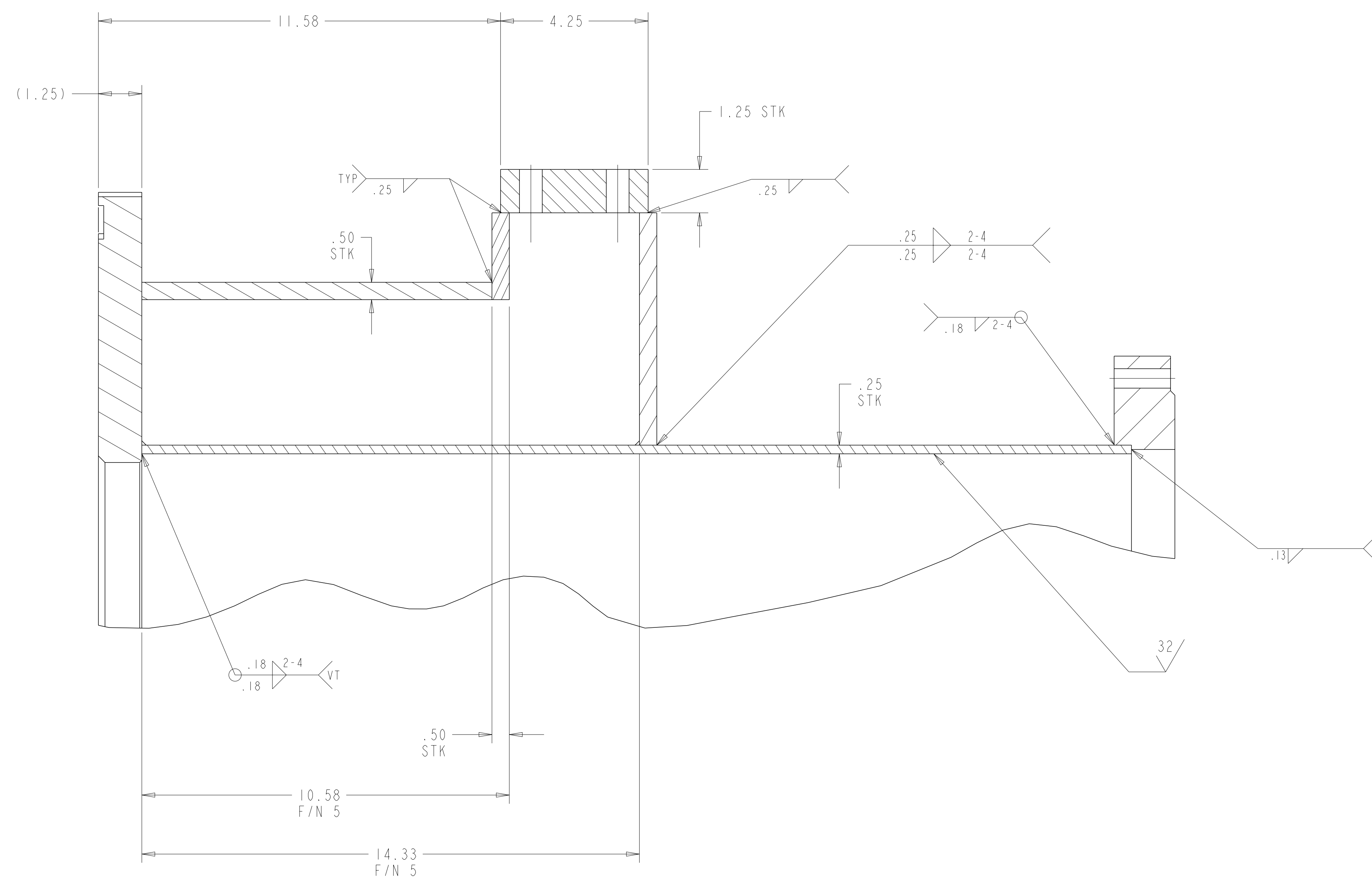
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NEXT ASS'Y:

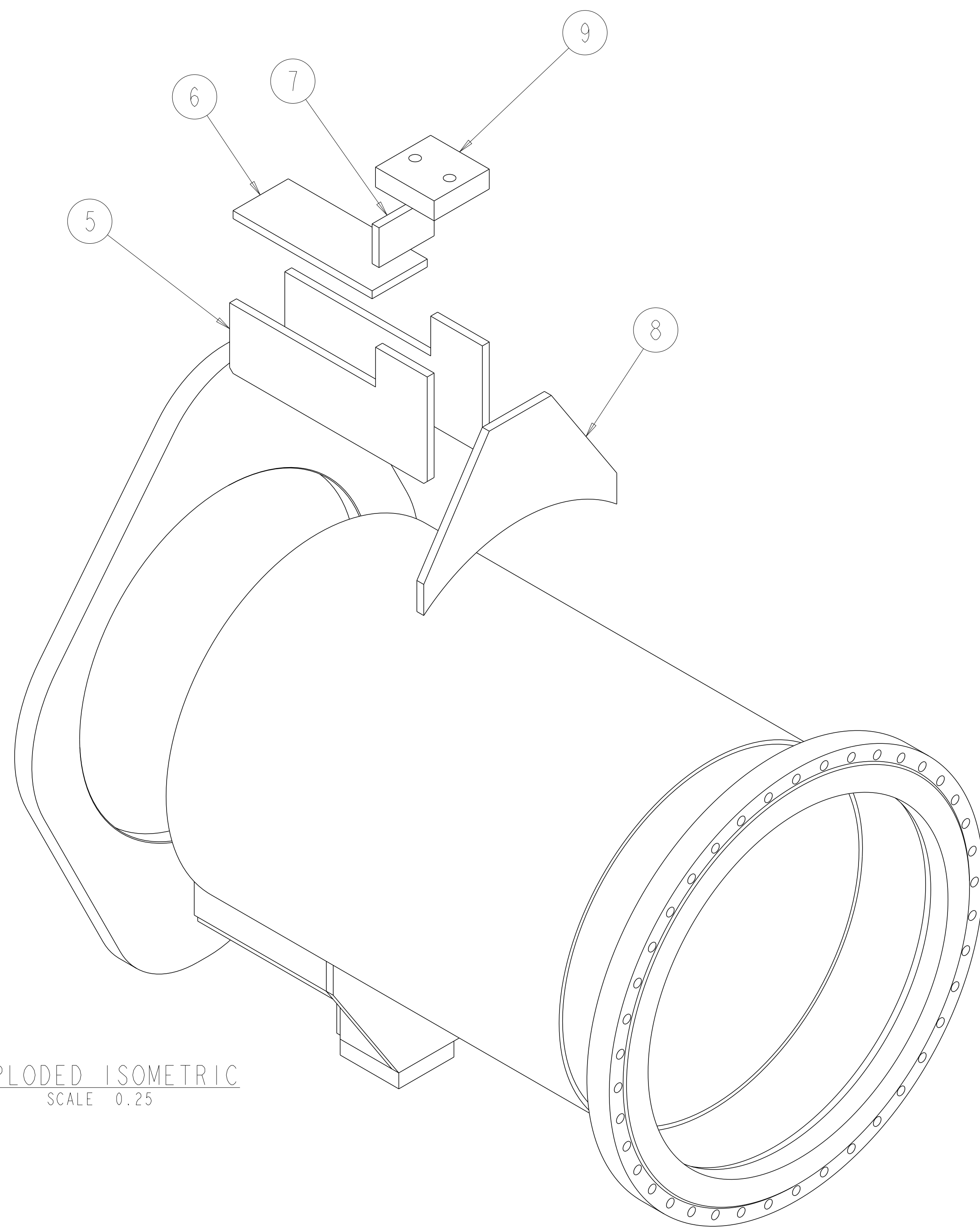
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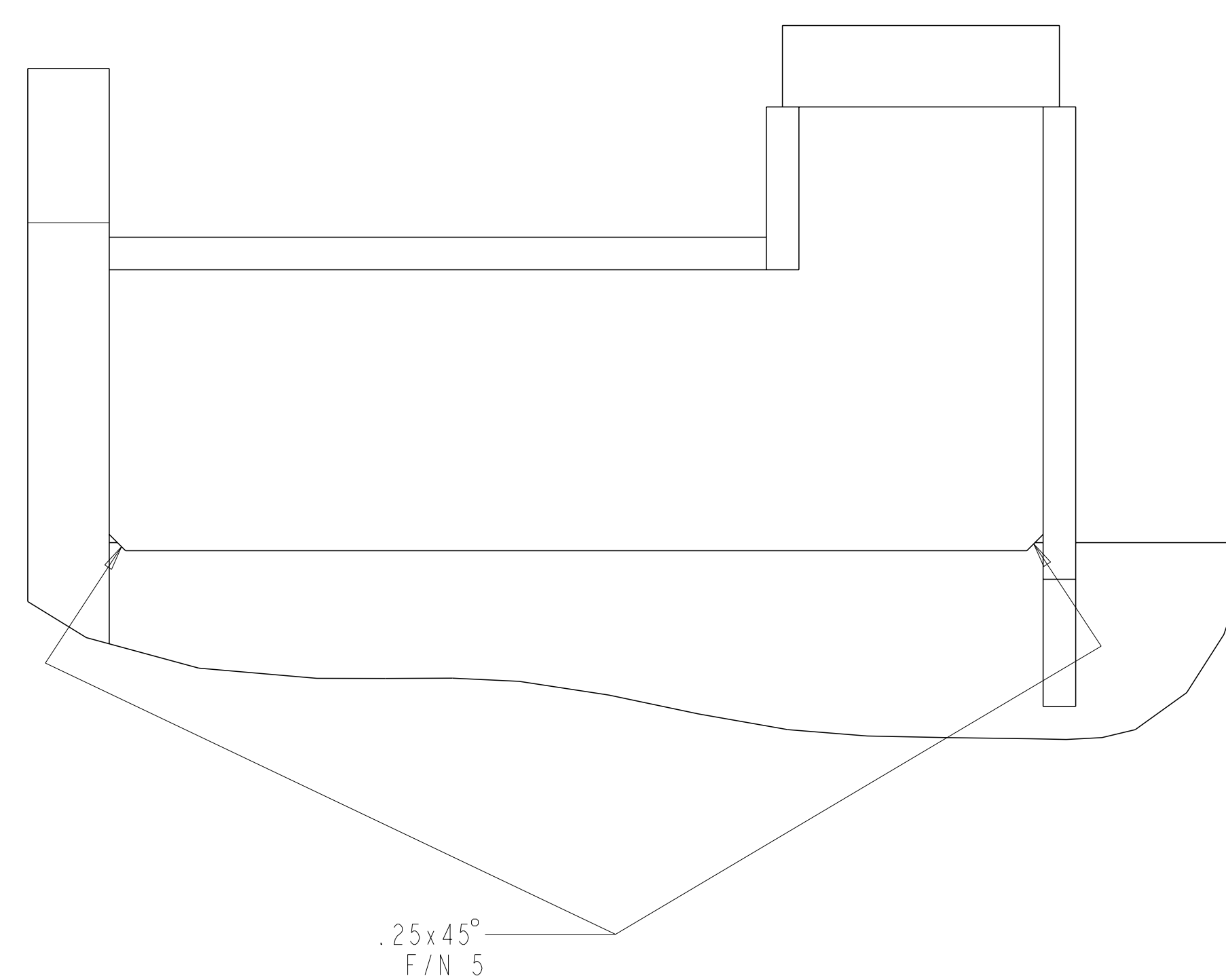
SECTION E-E
SCALE 0.50



SECTION C-C
SCALE 0.50



EXPLODED ISOMETRIC
SCALE 0.25



DETAIL F
SCALE 0.500

Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-80OR2125 UT-BATTELLE, LLC, Oak Ridge, Tennessee						
PROJECT NAME NATIONAL COMPACT STELLARATOR EXPERIMENT						
MAN HOLE PORT WELDMENT						
VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE CLASS
0	ORNL	5700	3	2	2	B U
RELEASE LEVEL		SEI21-131			REV	
Fabrication					0	

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SEI21-131