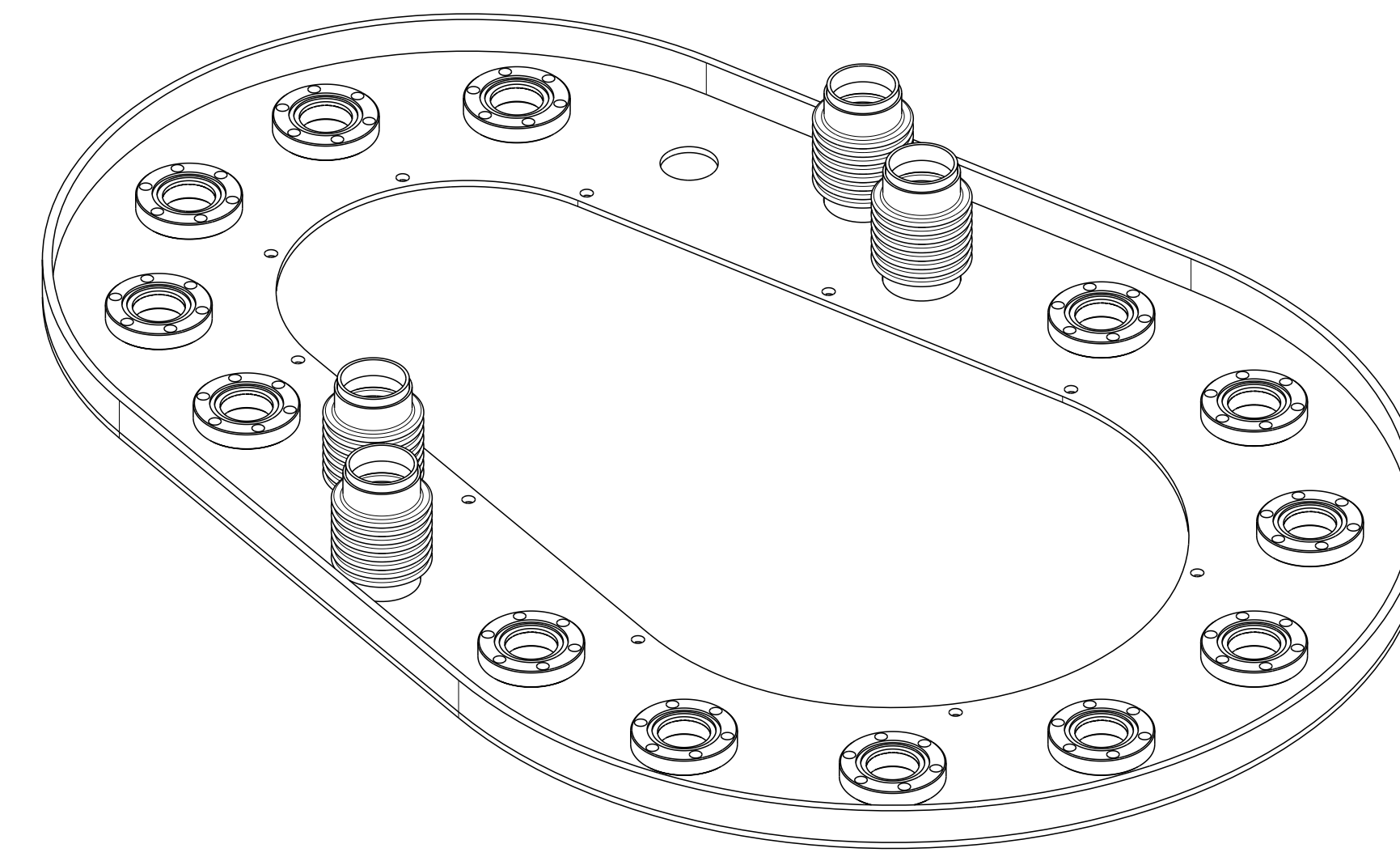
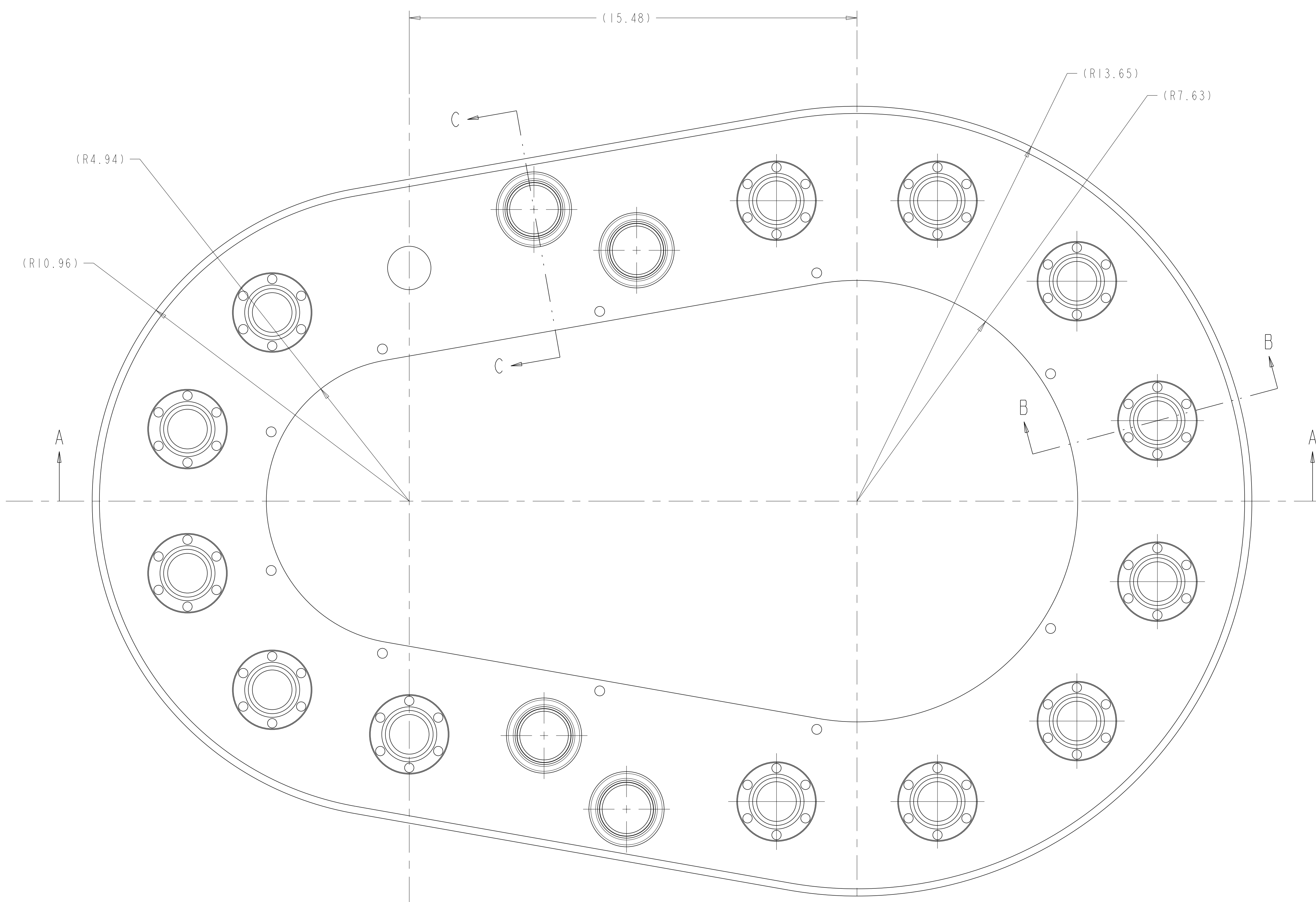
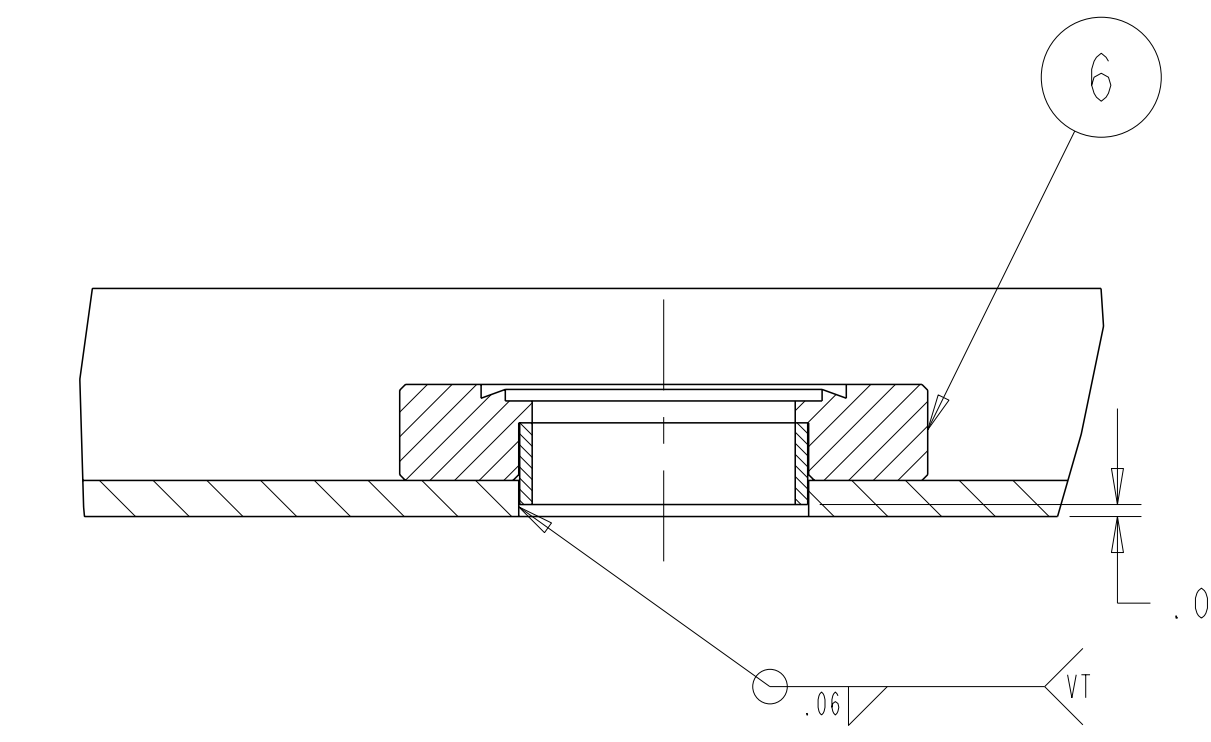


NOTES

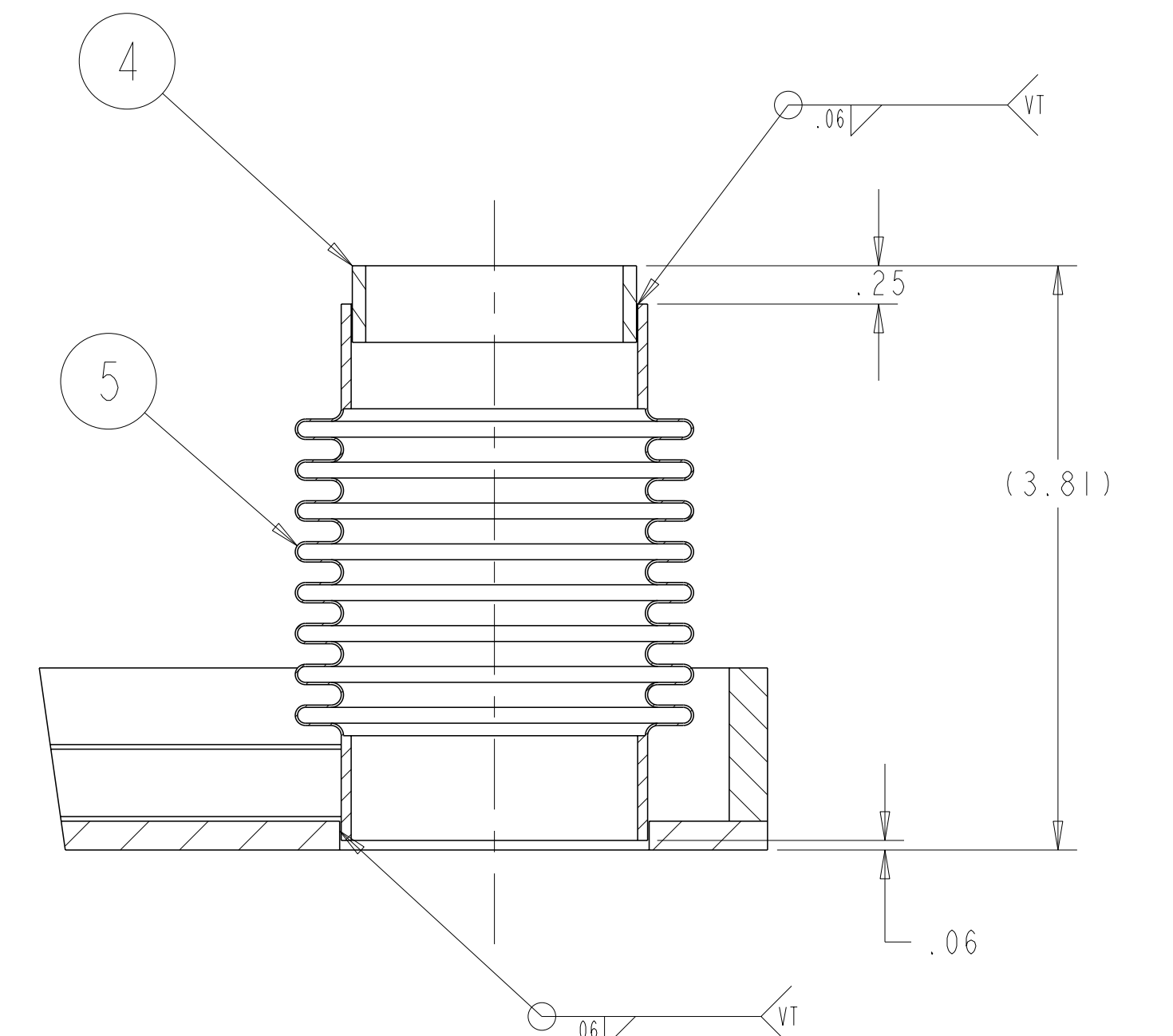
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
2. DIMENSIONS ARE IN INCHES
3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.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



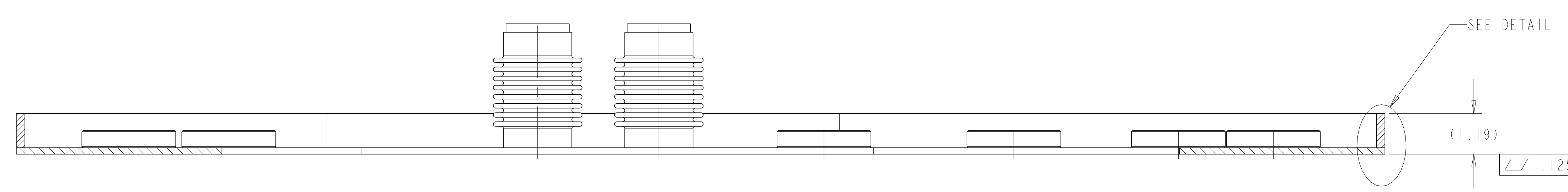
ISOMETRIC VIEW
SCALE 0.25



SECTION B-B
(TYP 14X)
SCALE 1.00

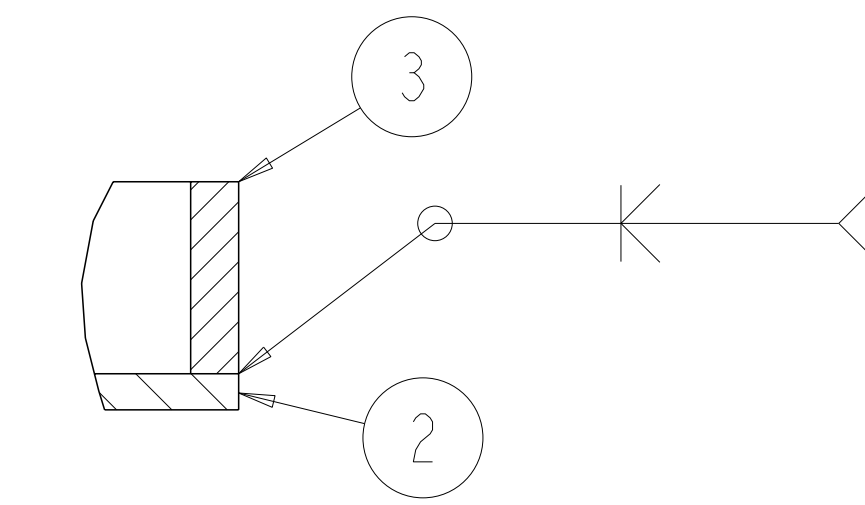


SECTION C-C
(TYP 4X)
SCALE 1.00



SECTION A-A

SCALE: .50



DETAIL X
SCALE 1.00

AR	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
-7			WELD FILLER METAL			7
14	401023		HALF NIPPLE, 2.75 O.D. TAPPED			6
4	470506		FORMED BELLOWS, WELD CUFF 2.00 O.D. TUBE			5
4	SE123-168-7		BELLOWS RING			4
1	SE123-166		CRYOSTAT INTERFACE FLANGE LIP WELDMENT			3
1	SE123-165		CRYOSTAT INTERFACE FLANGE DETAIL			2
AR	X	-1	CRYOSTAT INTERFACE FLANGE WELDMENT			1
SE123-049						

PARTS LIST

WELDING ENGINEER
APPROVED _____ DATE: _____

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

SCALE	NOTED	DES	DATE
TOLERANCES UNLESS OTHERWISE SPECIFIED		P. L. GORANSON	04/07/05
FRACTIONS		G. H. JONES	04/07/05
XX DECIMALS ± .03		S. PARSON	05/05
XXX DECIMALS ± .005			
ANGLES ± 0°15'			
BREAK SHARP EDGES .06 MAX			
FINISH .125 UNLESS OTHERWISE SPECIFIED			

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U.S. GOVERNMENT CONTRACT DE-AC05-00OR22725
UT-BATTELLE, LLC, Oak Ridge, Tennessee

NATIONAL COMPACT STELLARATOR EXPERIMENT
VACUUM VESSEL HEATING/COOING
CRYOSTAT INTERFACE FLANGE
WELDMENT

VERSION NO. PLANT BLDG FL SHT OF TYPE CLASS
proj-rev-1.01 X10 5700 3 1 1 B U
RELEASE LEVEL
proj-release SE123-164 REV 0

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