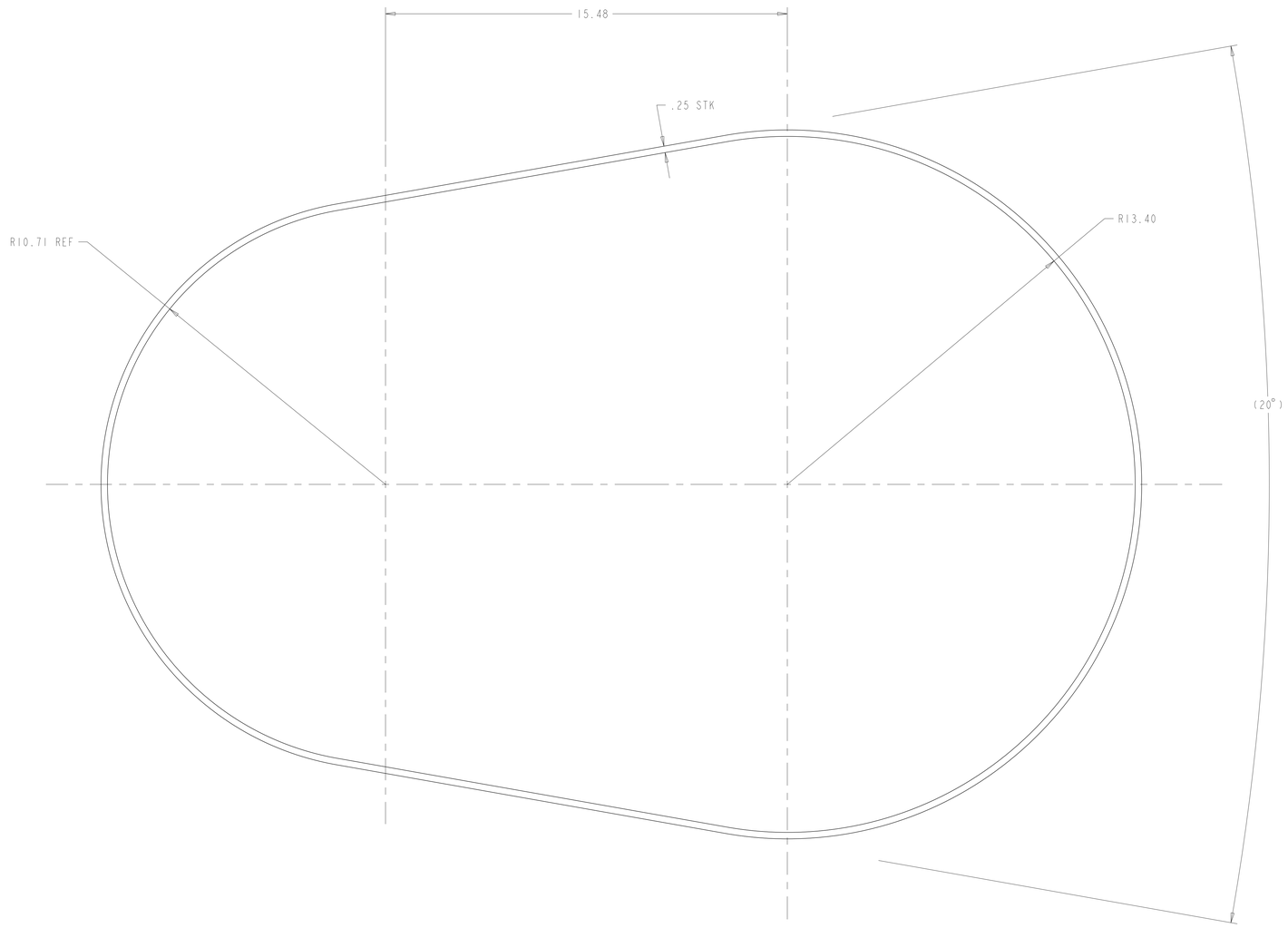
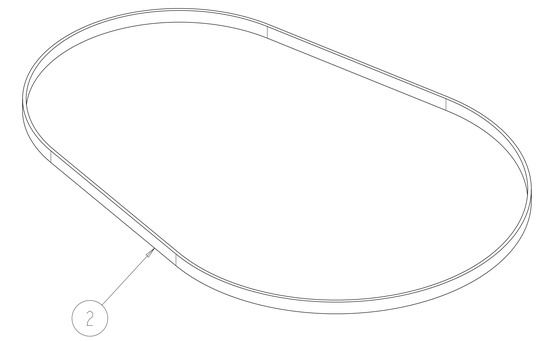
NEXT ASS'Y:

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.





ISOMETRIC VIEW
SCALE 0.25

1

SCALE: .50

	AR		-3	WELD FILLER METAL		3
	1		-2	PLATE, .25 THK.	316L SST ANNEALED	ASTM A240	2
AR			-1	CRYOSTAT INTERFACE FLANGE LIP WELDMENT		1
SE123-164 -1		CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
		NEXT ASSEMBLY		PARTS LIST			

SE123-166

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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

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 QRFT		:
	:	:
	:	:

DRAWING APPROVALS — DATE

UT-BATTELLE

Oak Ridge National Laboratory
managed for the DEPARTMENT OF ENERGY under
U.S. GOVERNMENT contract DE-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
1+	X10	5700	3	1	1	B	U

RELEASE LEVEL		REV
WIP	SE123-166	0