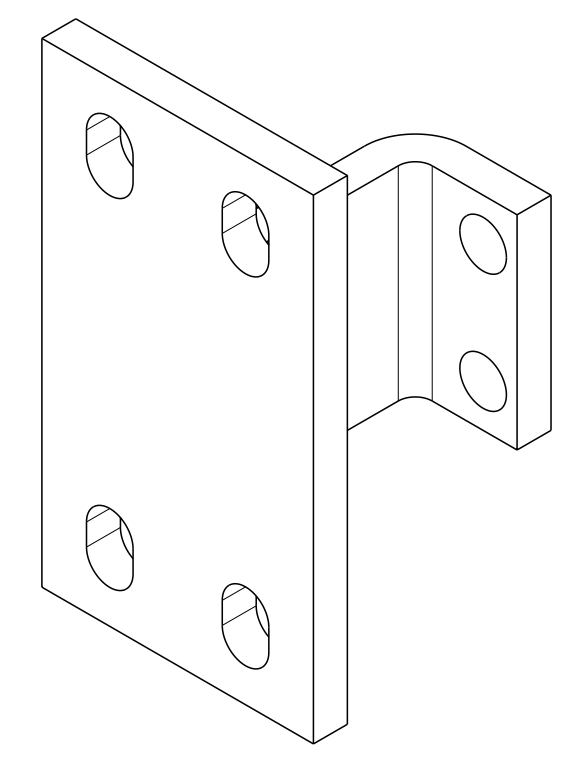
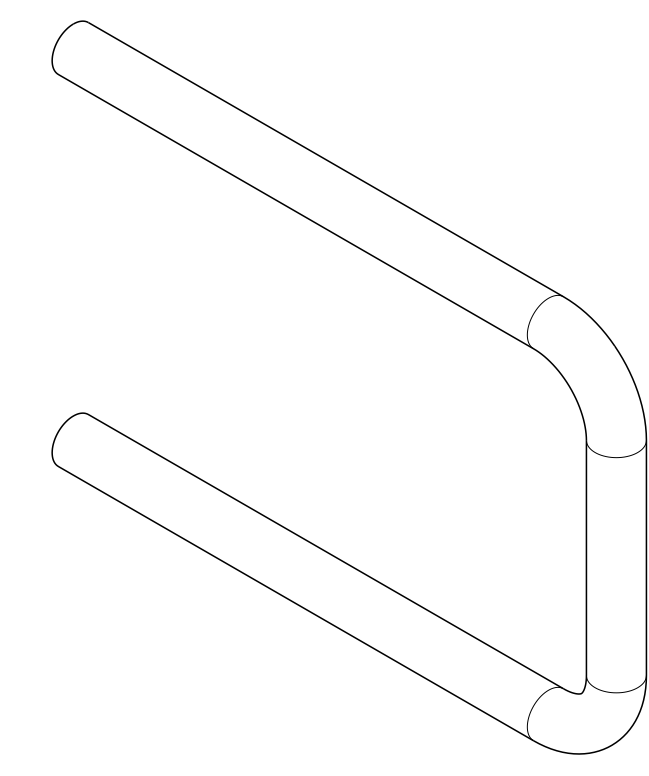
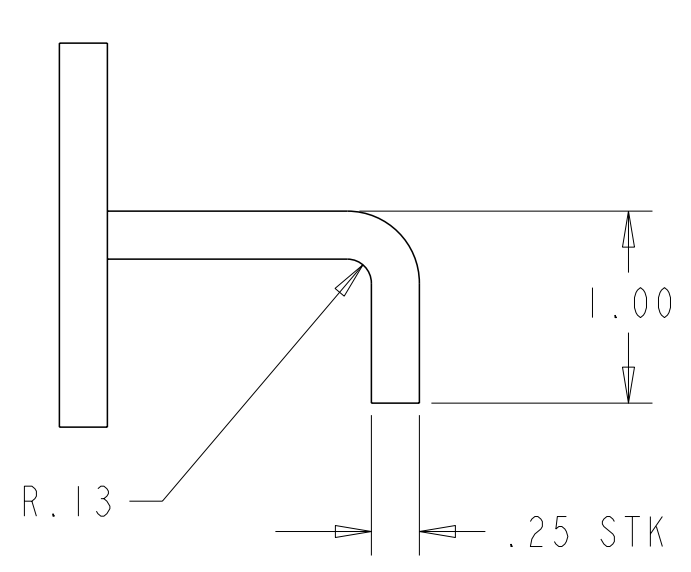


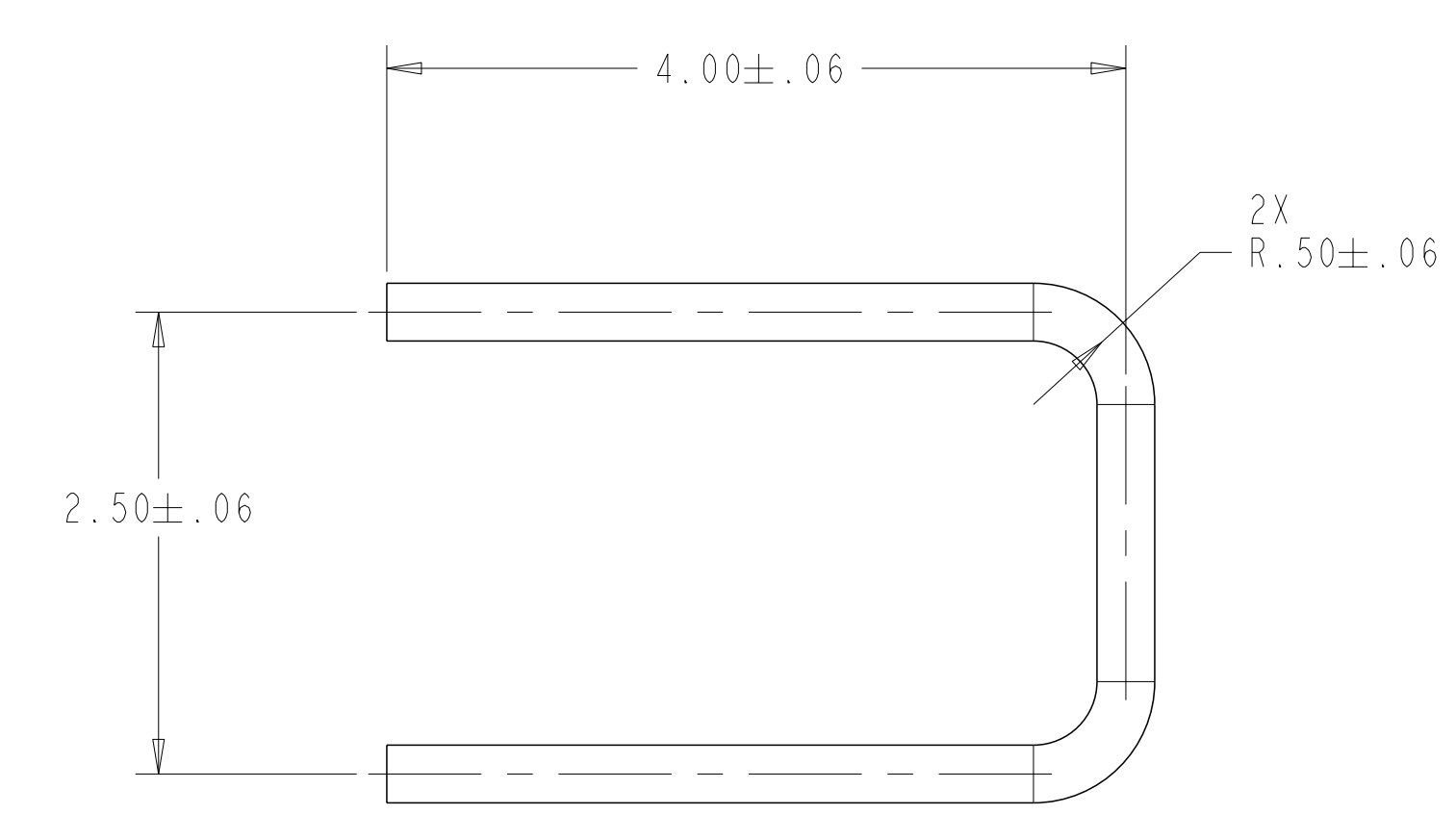
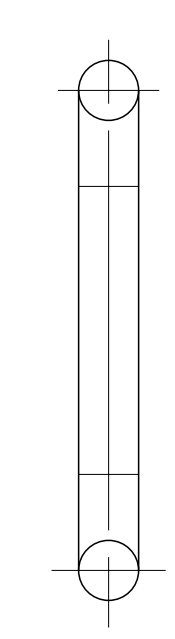
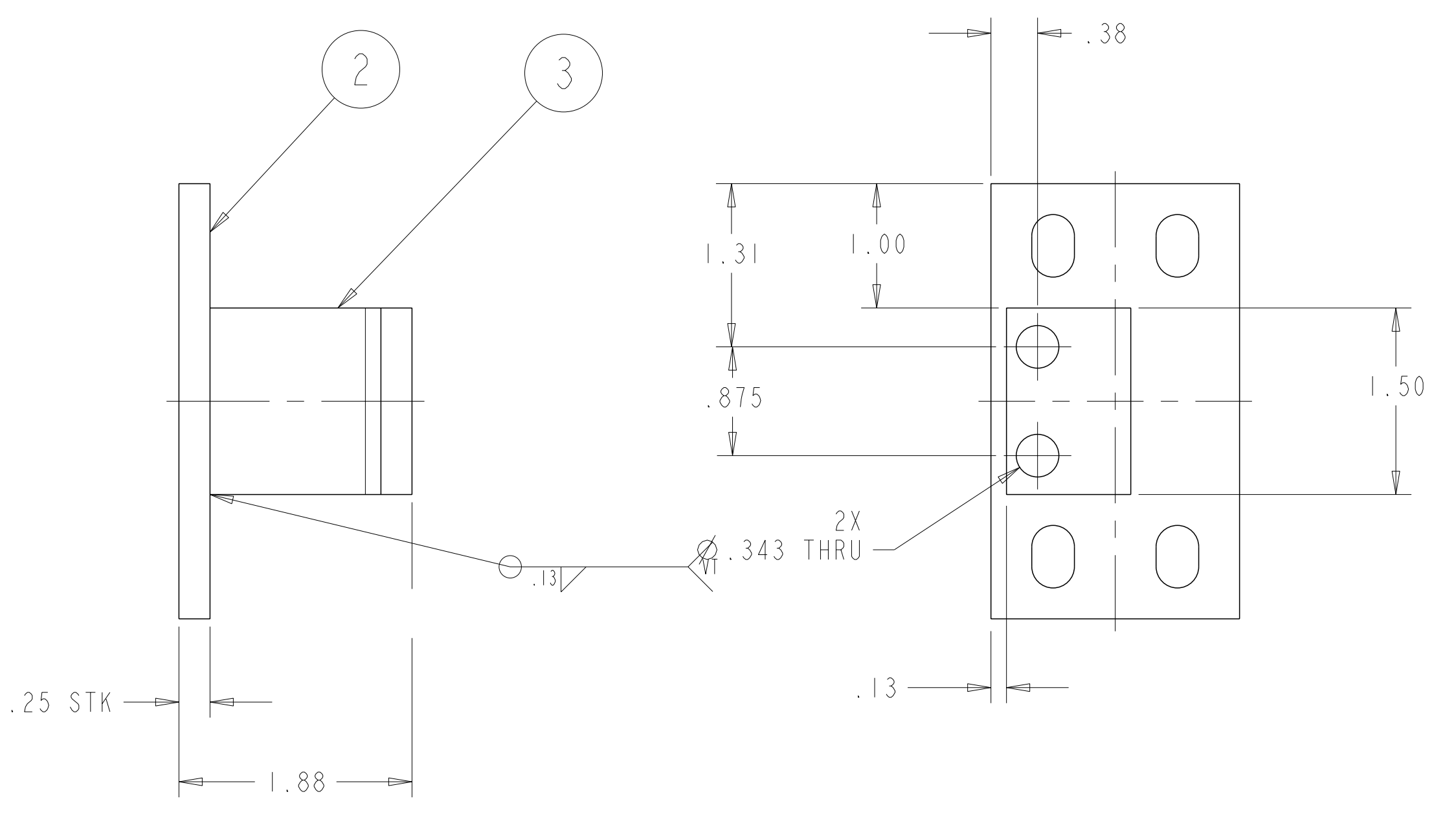
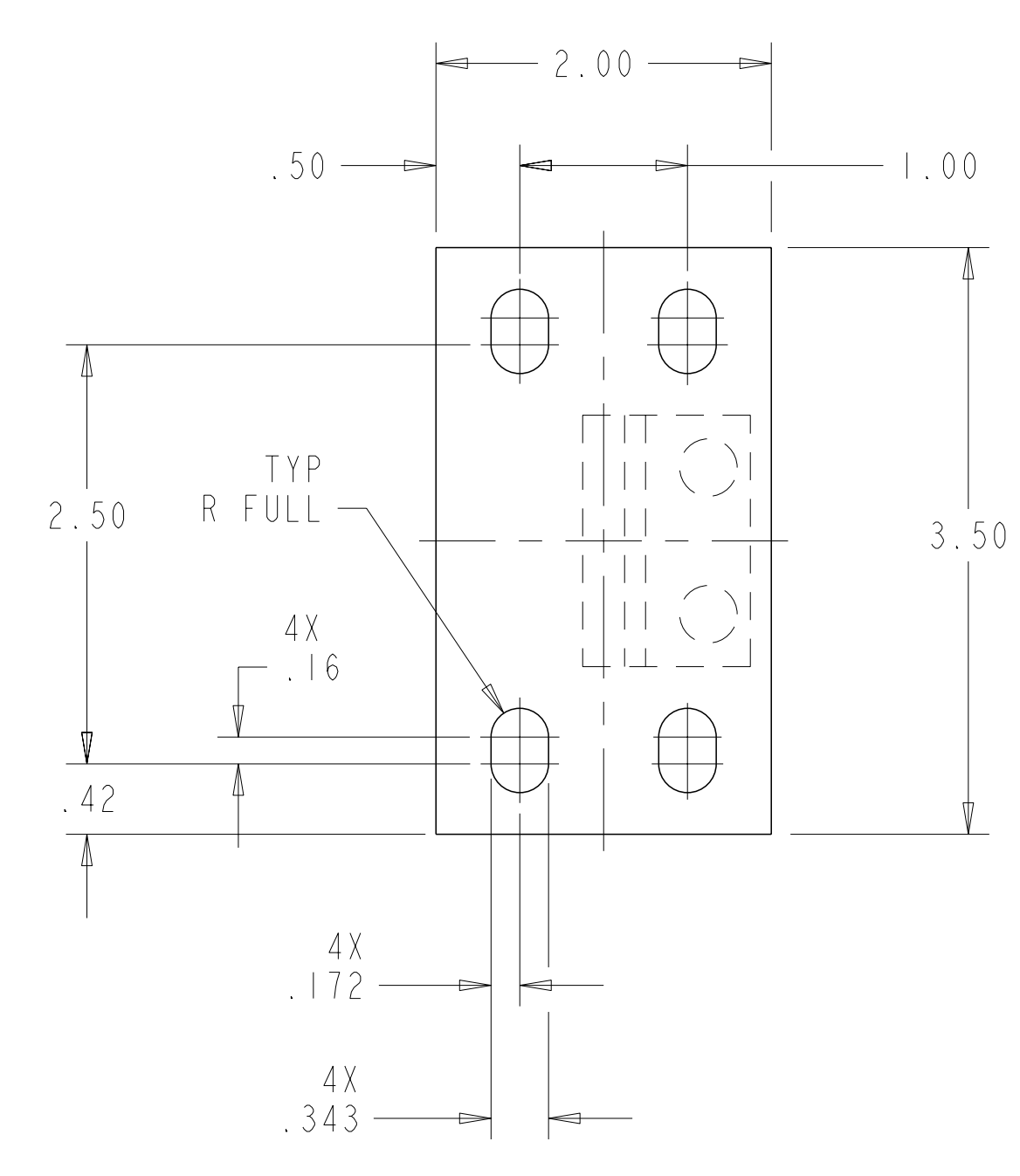
- NOTES**
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSIONS ARE IN INCHES
 3. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS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



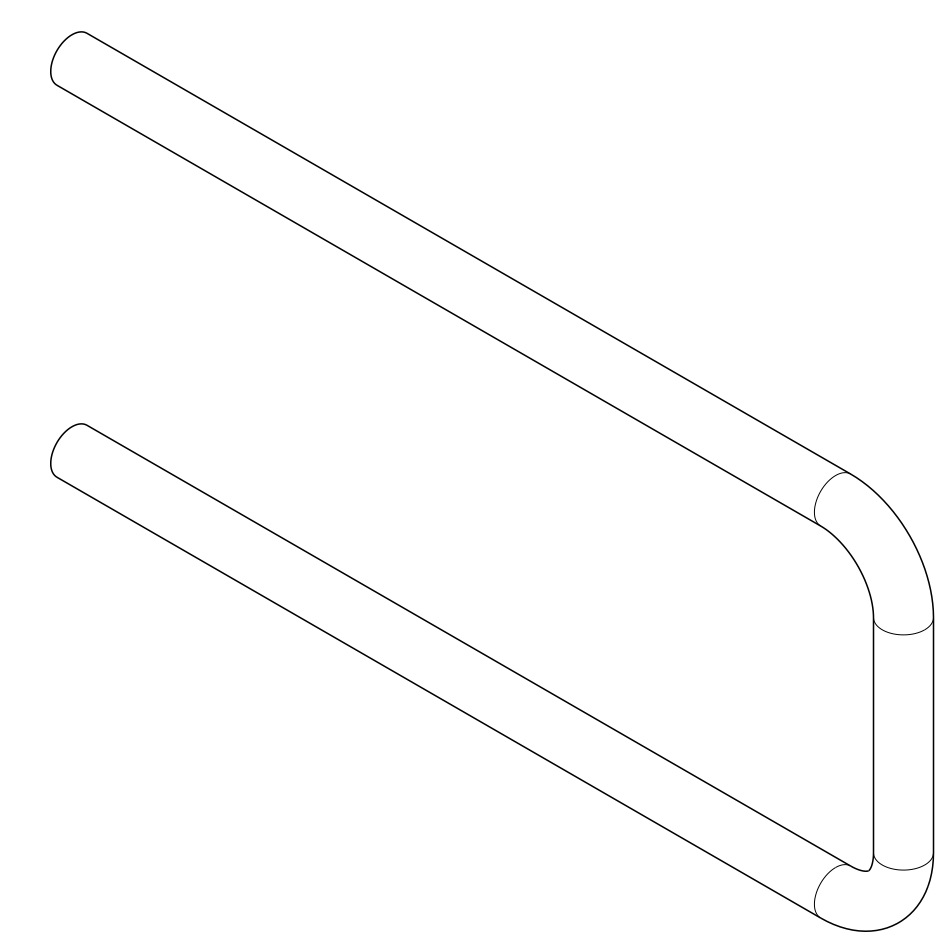
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SCALE 1.00



ISOMETRIC VIEW
SCALE 1.00

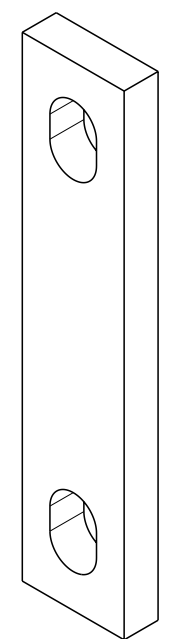


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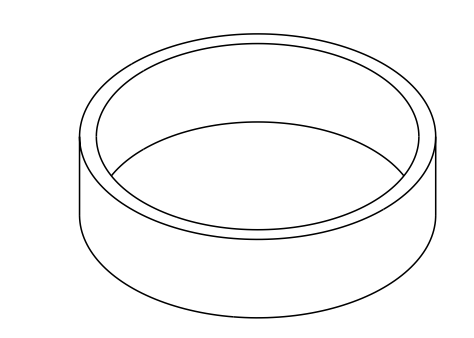


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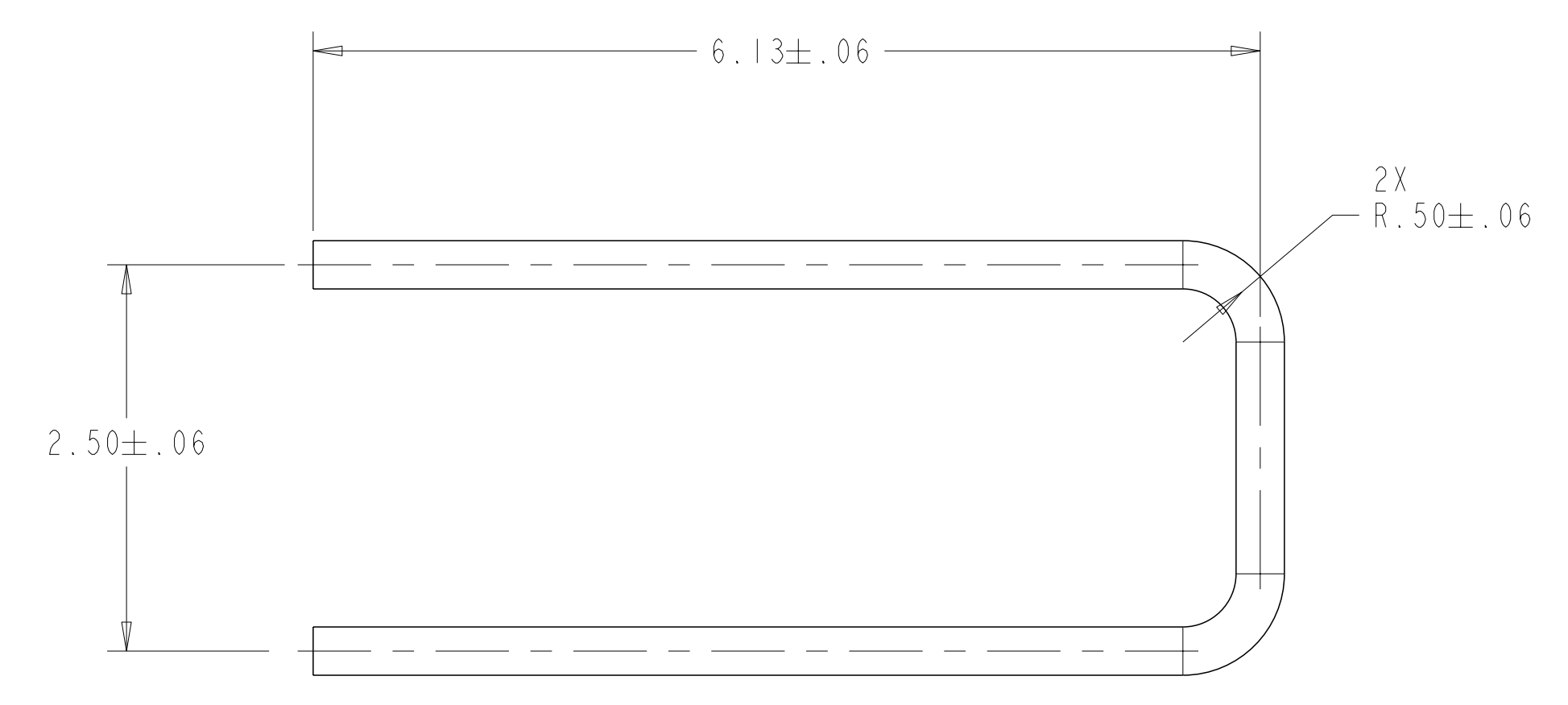
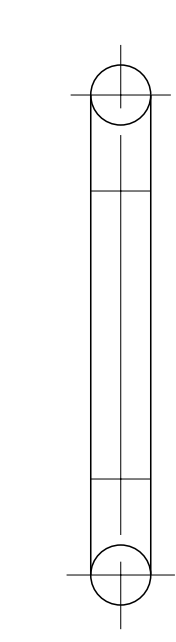
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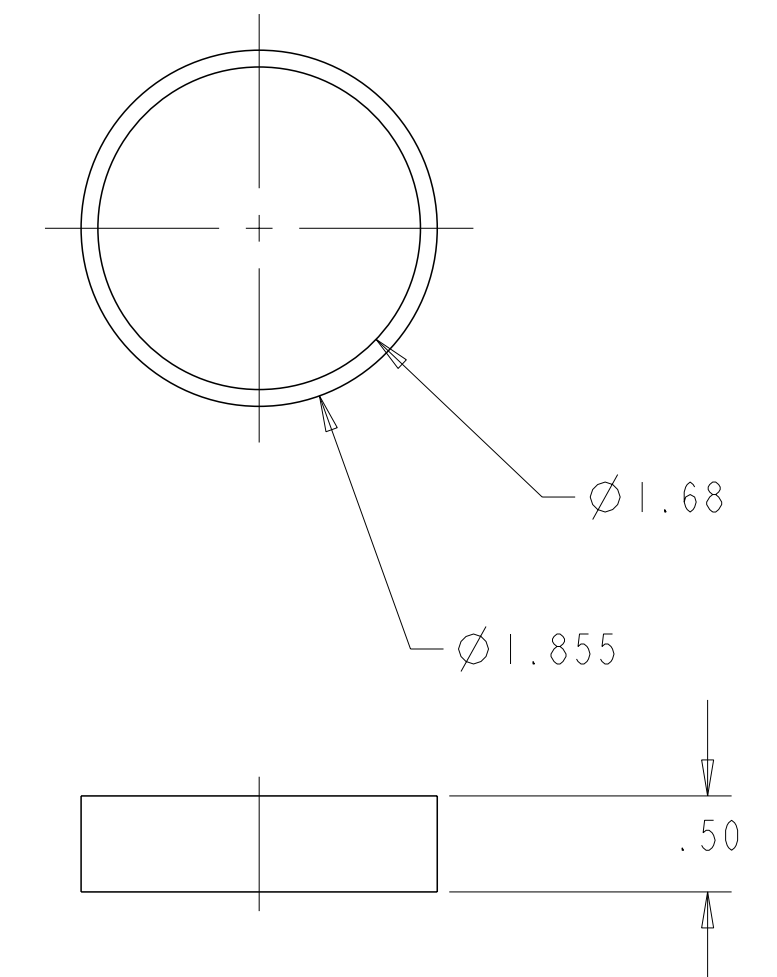
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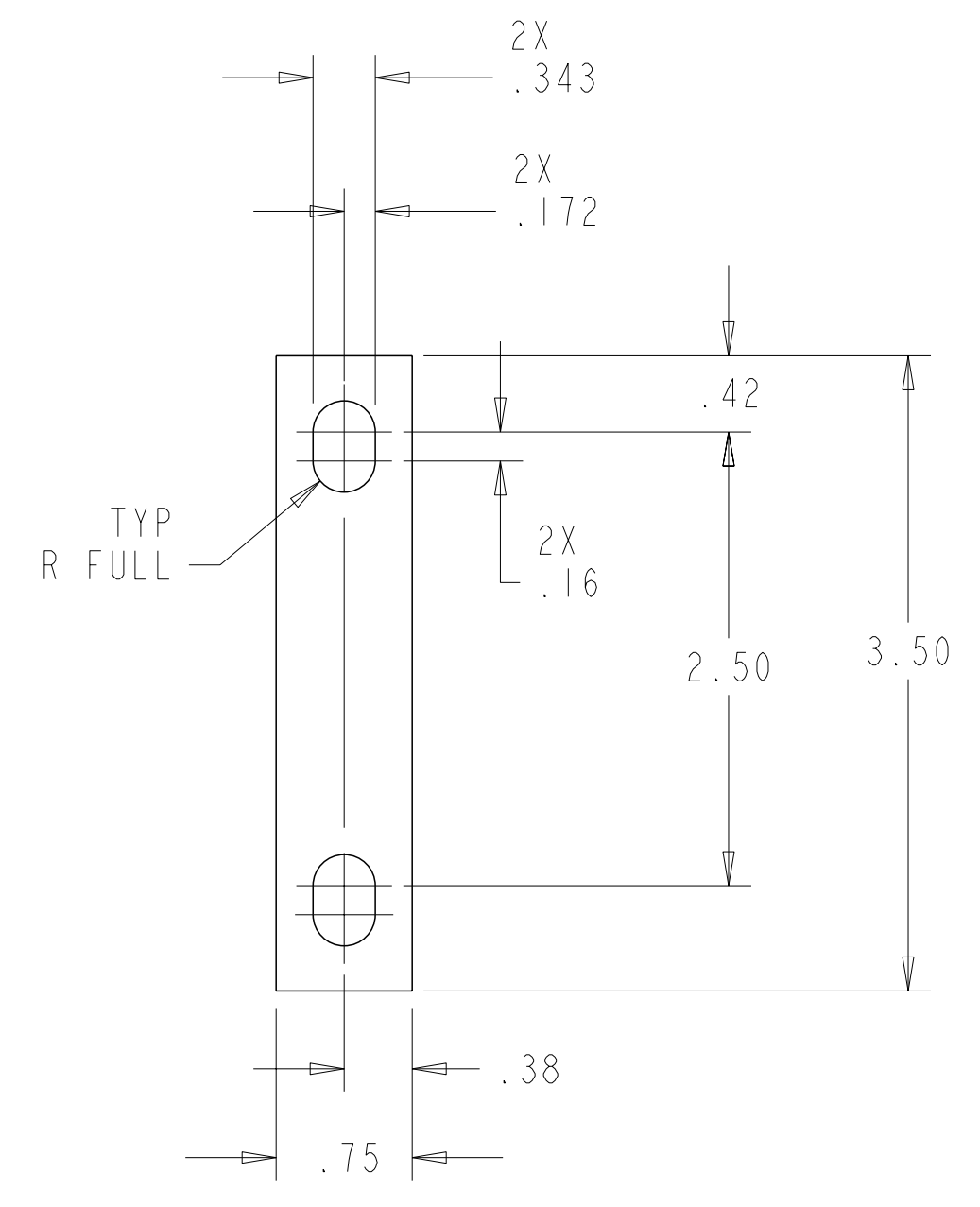
ISOMETRIC VIEW
SCALE 1.000



5 SCALE: 1.00



7 SCALE: 1.00



6 SCALE: 1.00

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
0	ORIGINAL ISSUE											
1	DESCRIPTION											
2	REVISION OR ISSUE PURPOSE											

CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
SET23-049		HEADER BRACKET			
SET23-164		STANDOFF WELDMENT			
		BELLOWS RING	316L SST ANNEALED	ASTM A276	7
		LONG BRACKET STOP	316L SST ANNEALED	ASTM A240	6
		5/16-18UNC ALL THREAD LONG BRACKET U-BOLT	316 SST		5
		5/16-18UNC ALL THREAD BRACKET U-BOLT	316 SST		4
		STANDOFF MOUNT	316L SST ANNEALED	ASTM A240	3
		STANDOFF PLATE	316L SST ANNEALED	ASTM A240	2
		WELD FILLER METAL			8

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P THIS DRAWING PRODUCED ON PRO-ENGINEER

SCALE	NOTED	DES	DATE
		P. L. GORANSON	04/07/05
		G. H. JONES	04/07/05
		S. PARSON	05/05

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UT-BATTELLE, LLC, Oak Ridge, Tennessee

NATIONAL COMPACT STELLARATOR EXPERIMENT
VACUUM VESSEL HEATING/COOLING
MISC.
WELDMENT AND DETAILS

VERSION NO.	PLANT	BLOG	FL	SHT	OF	TYPE	CLASS
14	X10	5700	3	1	1	B	U
RELEASE LEVEL	SEI23-168						REV
WIP							0