PPPL NONCO	NFORMANC	EREPURI	NO:	3655	Open	Date	05/31/06			
Status	9 - Closed NC	CR			Trend	07-O	ut Of Toler	ance		
Department	NCSX				Division	NCS	(Project			
Source/Org	VENDOR									
Item Dwg/Part#	NCSX-CSPEC-1	21-02-06	Procure	ement #	S0052	243-F		Cost Ce	enter _	
RAP# 3245	Job Doc #	S005243-F		Vendor	MAJOR T	OOL AN	ID MACHIN	E, INC.		
RAP Title Field F	Period Assembly	Component Rec	eipt Inspec	ction						
☐ HoldTag Ap	plied								*	:
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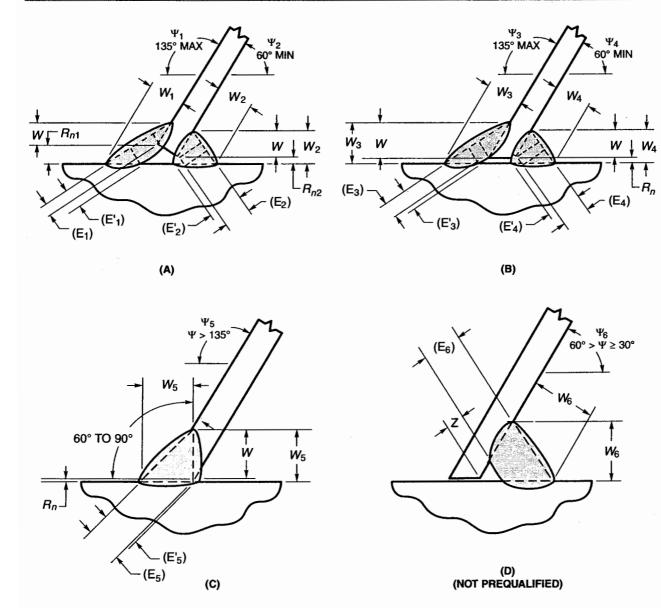
NCR 3655 - Attachment 1

Port to Vessel Fillet Welds

Port No.	Dwg Weld Size	Length of Undersize	Actual Weld Size	Angle Port to Vessel	Annex II Weld Size	
9B	3/16"	1 area 5"	1/8"	125°	0.23"	
		1 area 2", 1 area		1 area 135°, 1 area		
4A	3/16"	2.5"	1/8"	125°	0.23" to 0.25"	
				1 area 135°, 1 area		
NB	3/16"	2 areas 2" ea.	1/8"	125°	0.23" to 0.25"	
11A	3/16"	1 area 3.5"	1/16"	155°	> 0.25"	
11B	3/16"	1 area 3"	1/16"	155°	> 0.25"	
10A	3/16"	1 area 3"	1/8"	110°	0.22"	
Dome						
В	3/16"	1 area 2"	1/8"	Not able to measure	> 3/16"	

Table II-1	
Equivalent Fillet Weld Leg Size Factors for Skewed T-Joints (see A	nnex II)

Dihedral angle, Ψ	60°	65°	70°	75°	80°	85°	90°	95°
Comparable fillet weld size for same strength	0.71	0.76	0.81	0.86	0.91	0.96	1.00	1.03
Dihedral angle, Ψ	100°	105°	110°	115°	120°	125°	130°	. 135°
Comparable fillet weld size for same strength	1.08	1.12	1.16	1.19	1.23	1.25	1.28	1.31



- (E)_(n), (E')_(n) = Effective throat dependent on magnitude of root opening (R_n) (see 5.4.1). (n) represents 1 through 5.
 t = thickness of thinner part.
 Not prequalified for gas metal arc welding using short circuiting transfer.

Figure II-1—Details for Skewed T-Joints^{1,2,3} (see 2.17)

VVSA-1 Undersize fillet weld areas – port to vessel welds – 5/30/06



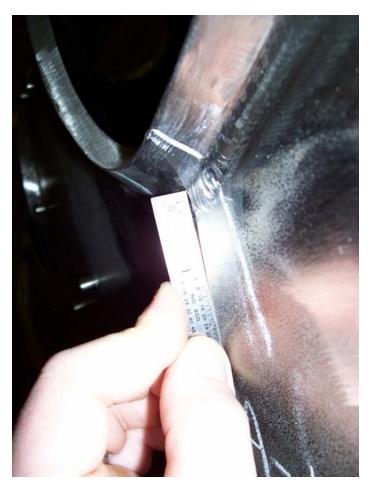












4A-1



4A-2



