

Page: 1 Date: 01/30/04 User ID: MCCORKLE

64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:14 Op:10 Revision: 12/11/03 15:11

Part: - - SE121-001P-2 PANEL # 1

	Drawing ID: SE121-001P Rev: A		INSPECTION INS	TRUC	TIONS		INSPECTED BY		BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	1
*			PERMEABILITY GAG	QA			TESTED 15 RANDOM LO	581-D.ED		'	Α
							CATIONS, MAX. MAG.			1	İ
		Magnetic Permeability 1.0 Max.					PERMEABILITY =1.000			1	İ
		(Panel Blank)						09-25-03		1	
*			ULTRASONIC THICK	QA		J-160	.412	085-D.GR			Α
		.375 (+.040/-0)								I	İ
		(Panel Blank)	O.D. MICS					10-02-03		<u> </u>	
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR		'	Α
		SURFACE FINISH:								I	
		SMOOTH, CLEAN, NO HEAVY SCRAPES,								1	İ
		PITS, OR GOUGES								1	
		(Panel Blank)						10-02-03		1	

Workorder: 64880/1-0 Sub:14 Op:31 Revision: 01/16/04 11:09

Part: - - SE121-001P-2 PANEL # 1

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS				INSPECTED BY]	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			VISUAL INSPECTION	QA		VISUAL	OK	085-D.GR			A
		VERIFY HEAT TREAT CERTIFICATION									
		AND FURNACE CHART COMPLY WITH									
		MTM PURCHASE ORDER REQUIREMENTS						01-16-04			

Workorder: 64880/1-0 Sub:14 Op:35 Revision: 12/11/03 15:11

Part: - - SE121-001P-2 PANEL # 1

	Drawing ID: SE121-001P Rev: A		INSPECTION INSTRUCTIONS				INSPECTED BY			Ī	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	Ī
*			PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR		1	A
		MAGNETIC PERMEABILITY OF ANNEALE								1	



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64880 PPPI	NCSX PVVS	INSPECTION PL	AN
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	1.01 MAX				01-16-04	
			•			

Workorder: 64880/1-0 Sub:14 Op:40 Revision: 01/20/04 10:51

Part: - - SE121-001P-2 PANEL # 1

]	Drawing ID: SE121-001P Rev: A	INSPECTION INSTRUCTIONS]	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*			FEELER GAGE	MFG		FEELER GAGE	.080 (GOOD)	746-G.D	522-R.DU		A
		.094" Max Gap (Part Surface To gauge)		QA		FEELER GAGE		10-29-03	10-29-03	1	

Workorder: 64880/1-0 Sub:14 Op:70 Revision: 12/11/03 15:12

Part: - - SE121-001P-2 PANEL #1

	Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max								
*			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*		(g .094")	TEMPLATE	QA						
		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	ENG						

Workorder: 64880/1-0 Sub:15 Op:10 Revision: 12/11/03 15:12

Part: - - SE121-001P-2 PANEL # 2

	Drawing ID: SE121-001P Rev: A		INSPECTION INS	TRUC	TIONS		INSPECTED BY]	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			PERMEABILITY GAG	QA			TESTED 15 RANDOM LO	581-D.ED			A
							CATIONS, MAX. MAG.				
		Magnetic Permeability 1.0 Max.					PERMEABILITY =1.000				
		(Panel Blank)						09-25-03			
*			ULTRASONIC THICK	QA		J-160	.405	085-D.GR			A
		.375 (+.040/-0)									
		(Panel Blank)	O.D. MICS					10-02-03			
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A



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64880 PPPI	NCSY PVVS	INSPECTION PLA	ΔN
0 1 000 1 1 1 L			

SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES,					
PITS, OR GOUGES					
(Panel Blank)			10-02-03		

Workorder: 64880/1-0 Sub:15 Op:31 Revision: 01/16/04 11:10

Part: - - SE121-001P-2 PANEL # 2

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS			-	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A
		VERIFY HEAT TREAT CERTIFICATION									
		AND FURNACE CHART COMPLY WITH									
		MTM PURCHASE ORDER REQUIREMENTS						01-16-04			

Workorder: 64880/1-0 Sub:15 Op:35 Revision: 12/11/03 15:13

Part: - - SE121-001P-2 PANEL # 2

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS				INSPECTED BY]	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR			A
		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX						01-16-04			

Workorder: 64880/1-0 Sub:15 Op:40 Revision: 01/20/04 11:08

Part: - - SE121-001P-2 PANEL # 2

I al to	- 0101	21-0011 -2 1 11 (EE // 2									
]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	STRUC	TIONS]	RESULTS	IN	SPECTED	BY	l
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	l
1*			FEELER GAGE	MFG		J-642	.094" NOGO	407-R.TH	363-C.M		A
		.094" Max Gap (Part Surface To gauge)		QA				01-20-04	01-20-04	I	l

Workorder: 64880/1-0 Sub:15 Op:70 Revision: 12/11/03 15:13

Part: - - SE121-001P-2 PANEL # 2

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT



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64880 PPPL NCSX PVVS INSPECTION PLAN

*		PERMEABILITY GAG	QA			
	Magnetic Permeability 1.01 Max					
*	32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA			
*	(a .094") .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA ENG			

Workorder: 64880/1-0 Sub:16 Op:10 Revision: 12/11/03 15:14

Part: - - SE121-001P-2 PANEL #3

	I	Drawing ID: SE121-001P Rev: A	INSPECTION INS	TRUC	TIONS]	RESULTS	INS	SPECTED	BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			PERMEABILITY GAG	QA			TESTED 15 RANDOM LO	581-D.ED			Α
							CATIONS, MAX. MAG.				
		Magnetic Permeability 1.0 Max.					PERMEABILITY =1.000				
		(Panel Blank)						09-25-03			
*			ULTRASONIC THICK	QA		J-160	.381	085-D.GR			A
		.375 (+.040/-0)									
		(Panel Blank)	O.D. MICS					10-02-03			
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A
		SURFACE FINISH:									İ
		SMOOTH, CLEAN, NO HEAVY SCRAPES,									İ
		PITS, OR GOUGES									
		(Panel Blank)						10-02-03			

Workorder: 64880/1-0 Sub:16 Op:31 Revision: 01/16/04 11:11

Part: - - SE121-001P-2 PANEL #3

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A
		VERIFY HEAT TREAT CERTIFICATION									
		AND FURNACE CHART COMPLY WITH									
		MTM PURCHASE ORDER REQUIREMENTS						01-16-04			ĺ



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Part: - - SE121-001P-2 PANEL # 3

		Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR			A
		MAGNETIC PERMEABILITY OF ANNEALE									
		1.01 MAX						01-16-04			

Workorder: 64880/1-0 Sub:16 Op:40 Revision: 01/20/04 11:08

Part: - - SE121-001P-2 PANEL # 3

	. ~==	=1 0011 =1111 (EE // C								
		Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	RESULTS	INSPECTED BY			
SHE	ET ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*	:		FEELER GAGE	MFG						
		.094" Max Gap (Part Surface To gauge)		QA						İ

Workorder: 64880/1-0 Sub:16 Op:70 Revision: 12/11/03 15:14

Part: - - SE121-001P-2 PANEL # 3

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS	I	RESULTS	INS	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max								
*			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH								
		(INTERIOR (CONCAVE) SIDE)								
*		(g .094")	TEMPLATE	QA		_				
		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	ENG						

Workorder: 64880/1-0 Sub:17 Op:10 Revision: 12/11/03 15:15

Part: - - SE121-001P-2 PANEL # 4

Į		Ι	Drawing ID: SE121-001P Rev: A	INSPECTION INST	TRUC	ΓIONS]	RESULTS	INS	SPECTED	BY]
	SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
ſ	*			PERMEABILITY GAG	QA			TESTED 15 RANDOM LO	581-D.ED		<u> </u>	A



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		Magnetic Permeability 1.0 Max. (Panel Blank)				CATIONS, MAX. MAG. PERMEABILITY =1.000	09-25-03		
ſ	*		ULTRASONIC THICK	QA	J-160	.396	085-D.GR		A
ı		.375 (+.040/-0)							ı
L		(Panel Blank)	O.D. MICS				10-02-03		ı
	*		VISUAL INSPECTION	QA	VISUAL	GOOD	085-D.GR		A
İ		SURFACE FINISH:							l
İ		SMOOTH, CLEAN, NO HEAVY SCRAPES,							l
1		PITS, OR GOUGES							ı
L		(Panel Blank)					10-02-03		l

Workorder: 64880/1-0 Sub:17 Op:31 Revision: 01/16/04 11:11

Part: - - SE121-001P-2 PANEL # 4

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS	-	RESULTS	INS	SPECTED	BY	Ī
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT]
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A
		VERIFY HEAT TREAT CERTIFICATION									İ
		AND FURNACE CHART COMPLY WITH									
		MTM PURCHASE ORDER REQUIREMENTS						01-16-04			

Workorder: 64880/1-0 Sub:17 Op:35 Revision: 12/11/03 15:15

Part: - - SE121-001P-2 PANEL # 4

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INST	TRUC	TIONS]	RESULTS	INS	SPECTED	BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT]
*			PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR			A
		MAGNETIC PERMEABILITY OF ANNEALE									
		1.01 MAX						01-16-04			

Workorder: 64880/1-0 Sub:17 Op:40 Revision: 01/20/04 11:08

Part: - - SE121-001P-2 PANEL #4

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT



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64880 PPPI	NCSX PVVS	S INSPECTION PLA	N
U700V I I I L	11112272X 1 V V 1)	

1*		FEELER GAGE	MFG	J-642	.094" NOGO	407-R.TH	363-C.M	A
	.094" Max Gap (Part Surface To gauge)		QA			01-20-04	01-20-04	

Workorder: 64880/1-0 Sub:17 Op:70 Revision: 12/11/03 15:16

Part: - - SE121-001P-2 PANEL # 4

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max								
*			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH								
		(INTERIOR (CONCAVE) SIDE)								
*		(g .094")	TEMPLATE	QA						
		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	ENG						

Workorder: 64880/1-0 Sub:18 Op:10 Revision: 12/11/03 15:21

Part: - - SE121-001P-2 PANEL # 5

]	Drawing ID: SE121-001P Rev: A	INSPECTION INS	TRUC	TIONS		RESULTS	INS	SPECTED	BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			PERMEABILITY GAG	QA		J-1143	TESTED 15 RANDOM LO	581-D.ED		'	A
							CATIONS, MAX. MAG.			I	
		Magnetic Permeability 1.0 Max.					PERMEABILITY =1.000			I	
		(Panel Blank)						09-25-03		<u> </u>	
*			ULTRASONIC THICK	QA		J-160	.415	085-D.GR		1	A
		.375 (+.040/-0)								I	
		(Panel Blank)	O.D. MICS					10-02-03		<u> </u>	
*			VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR		1	A
		SURFACE FINISH:								I	
		SMOOTH, CLEAN, NO HEAVY SCRAPES,								I	
		PITS, OR GOUGES								I	
		(Panel Blank)						10-02-03		1	

Workorder: 64880/1-0 Sub:18 Op:31 Revision: 01/16/04 11:12



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64880 PPPL NCSX PVVS INSPECTION PLAN

Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS		RESULTS		INSPECTED BY		BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			VISUAL INSPECTION	QA			VISUAL	825-B.JA			A
		VERIFY HEAT TREAT CERTIFICATION									
		AND FURNACE CHART COMPLY WITH									
		MTM PURCHASE ORDER REQUIREMENTS						01-07-04			

Workorder: 64880/1-0 Sub:18 Op:35 Revision: 12/11/03 15:22

Part: - - SE121-001P-2 PANEL # 5

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS]	INSPECTED BY					
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*			PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR			A
İ		MAGNETIC PERMEABILITY OF ANNEALE									Ì
		1.01 MAX						01-16-04			

Workorder: 64880/1-0 Sub:18 Op:40 Revision: 01/20/04 11:08

Part: - - SE121-001P-2 PANEL # 5

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY		BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
1*			FEELER GAGE	MFG		J-642	.094" NOGO	407-R.TH	363-C.M		A
		.094" Max Gap (Part Surface To gauge)		QA				01-20-04	01-20-04		

Workorder: 64880/1-0 Sub:18 Op:70 Revision: 12/11/03 15:22

Part: - - SE121-001P-2 PANEL # 5

	Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS	INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max								
*			PROFILOMETER	QA						
		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)								
*		(g .094")	TEMPLATE	QA						



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64880 PPPI	NCSY PVVS	INSPECTION PLA	ΔN
0 1 000 1 1 1 L			

.094" Max Gap (Part Surface To gauge) FEELER GAGE	ENG		
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Workorder: 64880/1-0 Sub:19 Op:10 Revision: 12/24/03 9:48

Part: SE212-003P-3 - PORT EXTENSION -

		Drawing ID: SE121-002P Rev: 0	INSPECTION INS	TRUC	TIONS	RESULTS		INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						

Workorder: 64880/1-0 Sub:19 Op:20 Revision: 12/11/03 15:32

Part: SE212-003P-3 - PORT EXTENSION -



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64880 PPPL NCSX PVVS INSPECTION PLAN

	Drawing ID: SE121-002P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY		BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PROFILOMETER	QA						
		32 Micro Surface Finish (Interior)								
*			PERMEABILITY GAG	QA						
		1.2 Max Magnetic Permeability								
		(Flange To Tube)								i l

Workorder: 64880/1-0 Sub:24 Op:30 Revision: 10/02/03 9:44

Part: - - SURFACE FINISH TESTING TEST PIECES TO DEVELOP SURFACE FINISHING TECHNIQUES, CLEANING PROCEDURE, AND PERMEABILITY TESTING METH

		Drawing ID: SE121 Rev: A	INSPECTION INSTRUCTIONS				INSPECTED BY		1		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	Ī
			PROFILOMETER	QA		J-1152	22 TO 27 MICRO	139-R.S			A
		SURFACE FINISH: 32 MICRO ON ONE SIDE									
		SMOOTH BLASTED SURFACE SIDE OPPOS						10-02-03			_
			VISUAL INSPECTION	QA		VISUAL	ACC	139-R.S			A
		CLEANLINESS PER PP475.						10-02-03			j
				QA		J-1143	1.01	085-D.GR			A
		MAGNETIC PERMEABILITY (1.01 MAX)						10-02-03			

Workorder: 64880/1-0 Sub:25 Op:15 Revision: 12/11/03 15:30

Part: SE121-003P-4 - PORT EXTENSION WELD BACKING RING -

I ui to L		051 4 TORT EXTENSION VILLE BROKEN	O IME TO								_
	Drawing ID: SE121-003P Rev:		INSPECTION INSTRUCTIONS]	INSPECTED BY		BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
			PERMEABILITY GAG	QA			15 RANDOM LOCATION	581-D.ED			A
							HIGH=1.007, LOW=1				
		MAGNETIC PERMEABILITY 1.01 MAX					.006				
		(AFTER ROLLING / PRIOR TO WELDING)						09-22-03			

Workorder: 64880/1-0 Sub:25 Op:20 Revision: 12/24/03 9:50

Part: SE121-003P-4 - PORT EXTENSION WELD BACKING RING -

Drawing ID: SE121-003P Rev: 0	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY
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64880 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				CWI						
		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION		CILII						
*		CVVV (TTC) V V T (DTC)		CWI						
		CWI/TEAM LEADER								
		VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*		THE THROUGH COMMEDIA.		CWI						
		CWI/TEAM LEADER		0 111						
		VERIFY PURGE DAM MATERIAL COMPLIA								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				CWI						
		CWI / TEAM LEADER								
		VERIFY WELDER QUALIFICATIONS COMP								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION		~~~						
*				CWI						
		CWI/TEAM LEADER								
		VERIFY PARAMETER COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION							l	

Workorder: 64880/1-0 Sub:25 Op:40 Revision: 12/22/03 11:31

Part: SE121-003P-4 - PORT EXTENSION WELD BACKING RING -

Drawing ID: SE121-003P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			ULTRASONIC THICK	QA						
		MAGNETIC PERMEABILITY 1.01 MAX								
*				QA						
		CLEANLINESS PER PP475								





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64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:26 Op:60 Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS		RESULTS	IN	SPECTED	BY	
SHEET ZO	NE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	1
*	Verify Panel Joint Alignment Weld Seam # 2-5	VISUAL INSPECTION	MFG			LESS THAN .020 MISM ATCH	791-D.W	933-D.LE		A
	(.02" Max)		CWI				01-28-04	01-28-04		
*	Verify Panel / Rest Stop Position Panel #2 (009" Gap)	FEELER GAGE	MFG			LESS THAN .090	791-D.W 01-28-04			A
*	Verify Panel / Rest Stop Position Panel #5 (009" Gap)	FEELER GAGE	MFG			LESS THAN .090	791-D.W 01-28-04			A
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA			ACCEPTABLE TO WPS 3 90 PPPL REV 0 20 CFH FLOW/ARGON GAS	791-D.W			A
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA			HT LOT AV8128 / TRA CE TICKET #94881 6 25 INCO	791-D.W			A
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA			STAINLESS STEEL 300 SERIES CONSTRUCTIO N,STAINLESS STEEL W OOL	791-D.W 01-28-04			A



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64880 PPPL NCSX PVVS INSPECTION PLAN

*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START	QA		ER WELDER 791-D.W	A
*	AND THROUGH COMPLETION CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE	QA	WELDER SE AX AMPER WELD OP	01-28-04 ET AT 140 M AGE AT TAC	A
	PRIOR TO OPERATION START AND THROUGH COMPLETION			01-28-04	

Workorder: 64880/1-0 Sub:26 Op:70 Revision: 01/27/04 12:40

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	ΓΙΟΝS]	RESULTS	INS	SPECTED	BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT]
*		(g ,188")	SMX	QA		4470	+0.003 / +0.096	522-R.DU			A
		Upper Half Of Bilateral Tolerance									
		(tack welded vessel)									
		At weld seam only (development panel)						01-27-04			
*			PERMEABILITY GAG	QA		J-1165	LESS THAN 1.01	522-R.DU			A
		Magnetic Permeability 1.01 Max.									
		Record range (high / low)									
		At weld seam only (development panel)						01-27-04			
*				QA		J-770-NDT	0.380-0.389	522-R.DU			A
		Material Thickness									
		.375 +.04/-0"						01-27-04			

Workorder: 64880/1-0 Sub:26 Op:80 Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		BY
SHEET ZONE CHARACTERISTIC		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*				QA						
		CWI / TEAM LEADER								



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64880 PPPI	NCSX PVVS INSPECTION PLAN	V

0.00011	I DIVERSITION OF THE PROPERTY			
	VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			

Workorder: 64880/1-0 Sub:26 Op:90 Revision: 01/27/04 10:20

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	J	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS		TIONS]	IN	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,208"} Profile Tolerance (+.188 /020") (tack welded vessel) At weld seam only (development panel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN					
At weld seam only (development panel)					
	Worko	rder: 64880/1-0 S	Sub:26 Op:100		Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	Drav	wing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	VEF ANI PRI	/I / TEAM LEADER RIFY SHIELDING GAS ID PURGE GAS COMPLIANCE IOR TO OPERATION START ID THROUGH COMPLETION		QA						
*	VEI PRI	/I / TEAM LEADER RIFY WELD FILLER MATERIAL COMPLI IOR TO OPERATION START ID THROUGH COMPLETION		QA						
*	VEI PRI	/I / TEAM LEADER RIFY PURGE DAM MATERIAL COMPLIA IOR TO OPERATION START ID THROUGH COMPLETION		QA						
*	VEI PRI	/I / TEAM LEADER RIFY WELDER QUALIFICATIONS COMP IOR TO OPERATION START ID THROUGH COMPLETION		QA						
*	VEI PRI	/I / TEAM LEADER RIFY PARAMETER COMPLIANCE IOR TO OPERATION START ID THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:26 Op:110 Revision: 01/27/04 10:22

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1



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64880 PPPL NCSX PVVS INSPECTION PLAN

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	IN	INSPECTED BY		
SHEET	SHEET ZONE CHARACTERISTIC		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Profile Tolerance (+.188/040") (tack welded vessel) At weld seam only (development panel)	SMX	QA						
*			PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:26 Op:120

Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL PRIOR TO OPERATION START AND THROUGH COMPLETION	. COMPLI	QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL PRIOR TO OPERATION START AND THROUGH COMPLETION	COMPLIA	QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIO PRIOR TO OPERATION START AND THROUGH COMPLETION	NS COMP	QA						



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64880 PPPL NC	'SY PVVS	INSPECTION PLA	ΔN
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*		QA			
	CWI / TEAM LEADER				
	VERIFY PARAMETER COMPLIANCE				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:26 Op:130 Revision: 01/27/04 10:23

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	SHEET ZONE CHARACTERISTIC		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Profile Tolerance (+.188/060") (tack welded vessel) At weld seam only (development panel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low) At weld seam only (development panel)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:26 Op:140 Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	J	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						



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64QQA DDDI	NCSX PVVS INSPECTION PLA	N
04880 222	, NUSA PVVS INSPECTIUM PLA	13

	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION				
*		QA			
	CWI/TEAM LEADER				
	VERIFY WELDER QUALIFICATIONS COMP				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				
*		QA			
	CWI / TEAM LEADER				
	VERIFY PARAMETER COMPLIANCE				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:26 Op:150 Revision: 01/27/04 10:25

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	Dra	awing ID: SE121-001P Rev: 0	INSPECTION INS	NSTRUCTIONS		RESULTS		IN	INSPECTED BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	Pr (ta		SMX	QA						
*	Re	lagnetic Permeability 1.01 Max. ecord range (high / low) t weld seam only (development panel)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:26 Op:160 Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY		BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								



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64880 PPPL	NCSX PVVS INSPECTION PLA	ΔN
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0100011				
	AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:26 Op:170 Revision: 01/27/04 10:27

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	I	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,288")	SMX	QA						
		Profile Tolerance (+.188/100")								
		(tack welded vessel)								
		At weld seam only (development panel)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								
		At weld seam only (development panel)								



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64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:26 Op:180	Revision
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Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

	Drawing ID: SE121-001P Rev: 0		INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						
*		AND THROUGH COMPLETION CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:26 Op:190 Revision: 01/27/04 10:29

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY



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64880 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,308")	SMX	QA						
		Profile Tolerance (+.188/120")								1
		(tack welded vessel)								
		At weld seam only (development panel)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								i l
		Record range (high / low)								
		At weld seam only (development panel)								ĺ

Workorder: 64880/1-0 Sub:26 Op:200 Revision:

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

]	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						



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	CWI / TEAM LEADER					
İ	VERIFY PARAMETER COMPLIANCE					
	PRIOR TO OPERATION START					
İ	AND THROUGH COMPLETION					

Workorder: 64880/1-0 Sub:26 Op:210 Revision: 01/27/04 10:33

Part: - - SE121-001P-2 TEST PANEL NOTE: DERRIVED FROM DIE SET #1

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Profile Tolerance (+.188/140") (tack welded vessel) At weld seam only (development panel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low) At weld seam only (development panel)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:29 Op:10 Revision: 12/11/03 15:33

Part: SE212-003P-3 - -

]	Drawing ID: SE121-002P Rev:	INSPECTION INS	TRUC	TIONS]	RESULTS	INS	SPECTED	BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*				QA			MAX. RECORDING OF P	581-D.ED			A
							ERM. OF PLATE 1.002				İ
							, 12 PLCS. RANDOMLY				
		MAGNETIC PERMEABILITY 1.01 MAX					CHECKED.	09-17-03			

Workorder: 64880/1-0 Sub:29 Op:30 Revision: 12/11/03 15:34

Part: SE212-003P-3 - -

	I	Drawing ID: SE121-002P Rev:	INSPECTION INSTRUCTIONS]	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	_
*			PERMEABILITY GAG	QA			21 RANDOM LOCATION	581-D.ED			A
							, HIGH=1.007, LOW=1				



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64880 PPPI	NCSX PVVS INSI	PECTION PLAN
U700U I I I L		LUCITORILLARI

MAGNETIC PERMEABILITY 1.01 MAX		.006		
(AFTER ROLLING / PRIOR TO WELDING)			09-22-03	

Workorder: 64880/1-0 Sub:29 Op:40 Revision: 01/16/04 8:36

Part: SE212-003P-3 - -

	Drawing ID: SE121-003P Rev: 0	INSPECTION IN	STRUC	TIONS		INSPECTED BY			
SHEET ZONI	E CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			CWI						
	CWI/TEAM LEADER								
	VERIFY SHIELDING GAS								
	AND PURGE GAS COMPLIANCE								
	PRIOR TO OPERATION START								
	AND THROUGH COMPLETION								
*			CWI						
	CWI/TEAM LEADER								
	VERIFY WELD FILLER MATERIAL COMPLI								
	PRIOR TO OPERATION START								
	AND THROUGH COMPLETION								
*			CWI						
	CWI / TEAM LEADER								
	VERIFY PURGE DAM MATERIAL COMPLIA								
	PRIOR TO OPERATION START								
	AND THROUGH COMPLETION								
*			CWI						
	CWI / TEAM LEADER								
	VERIFY WELDER QUALIFICATIONS COMP								
	PRIOR TO OPERATION START								
	AND THROUGH COMPLETION		~~~						
*			CWI						
	CWI/TEAM LEADER								
	VERIFY PARAMETER COMPLIANCE								
	PRIOR TO OPERATION START								
	AND THROUGH COMPLETION Proving ID: SE121 002P Povi	INSPECTION IN	TDI I	PIONG		RESULTS	TAT	 SPECTED	DV
CHEED ACM	Drawing ID: SE121-002P Rev:					1		I	
SHEET ZONI	E CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
			QA	1					



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64880 I	PPPL NCSX PVVS INSPECTION PLAN					
	Verify Port Tube Weld Joint Alignment					
	(.02" Max)				!	

Workorder: 64880/1-0 Sub:29 Op:50 Revision: 01/09/04 14:25

Part: SE212-003P-3 - -

		Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		QA						

Workorder: 64880/1-0 Sub:29 Op:70 Revision: 01/09/04 14:37

Part: SE212-003P-3 - -

Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			PROFILOMETER	QA						
		32 MICRO-INCH RA SURFACE FINISH								



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L		(PORT EXTENSION TUBE)						
ſ	*		PERMEABILITY GAG	QA				l
		MAGNETIC PERMEABILITY 1.01 MAX (PORT EXTENSION TUBE)						l
	1*	8.0" Diameter +3/32" / -0 (per ASTM B444)		QA				

Workorder: 64880/1-0 Sub:31 Op:10 Revision:

Part: - - NAMEPLATE

	Ι	Drawing ID: NAMEPLATE Rev:	INSPECTION INSTRUCTIONS				INSPECTED BY]	
SHEET	Γ ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT]
			PERMEABILITY GAG	QA		J1143	9 LOC. CHECKED- HIG	581-D.ED			A
		MAGNETIC PERMEABILITY OF NAMEPLA					H 1.007, LOW 1.007.				
		1.0 MAX						09-24-03			

Workorder: 64880/1-0 Sub:31 Op:20 Revision:

Part: - - NAMEPLATE

		Drawing ID: Rev:	INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
			PERMEABILITY GAG	QA						
		MAGNETIC PERMEABILITY OF NAMEPLA								
		1.0 MAX								ł

Workorder: 64880/1-0 Sub:39 Op:10 Revision:

Part: - - SE121-003P NCSX PVVS COMPLETE RE-STRUCTURE / DETAIL TASK BREAKDOWN 07Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

]	Drawing ID: SE121-002P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				CWI						
		CWI / TEAM LEADER								İ
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								



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64880 PPPL NCSX PVVS INSPECTION PLAN

	AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		

Workorder: 64880/1-0 Sub:39 Op:30 Revision:

Part: - - SE121-003P NCSX PVVS COMPLETE RE-STRUCTURE / DETAIL TASK BREAKDOWN 07.Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

]	Drawing ID: SE121-003P Rev: 0	INSPECTION INS	STRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		CWI						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		CWI						



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64880 PPPL NCSX PVVS INSPECTION PLAN

	AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	CWI		

Workorder: 64880/1-0 Sub:39 Op:40 Revision: 01/27/04 17:00

Part: - - SE121-003P NCSX PVVS COMPLETE RE-STRUCTURE / DETAIL TASK BREAKDOWN 07.Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

		Drawing ID: SE121-003P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability of all Inconel 625	PERMEABILITY GAG	QA						
		Material And Weld Zones (1.01 Max)								
*		Magnetic Permeability of Conflat Flange (1.02 Max)	PERMEABILITY GAG	QA						
*		Magnetic Permeability of Weld / Heat Affecte ne (Flange to Tube) (1.2 Max)	PERMEABILITY GAG	QA						
*		(g ,375) Finished part profile	SMX	QA						
*		{# d.125"p48" A B C} Port Extension position (after re-attachment)	SMX	QA						



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	.375 +0.04/06"	QA			
	.125 +/013"	QA			

Workorder: 64880/1-0 Sub:40 Op:10 Revision: 01/12/04 16:15

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPL PRIOR TO OPERATION START AND THROUGH COMPLETION	I	QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	A	QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COM PRIOR TO OPERATION START AND THROUGH COMPLETION	P	QA						
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						



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Workorder: 64880/1-0 Sub:40 Op:40	Revision: 01/12/04 16:15
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Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0	INSPECTION INST	RUC	TIONS	I	RESULTS	IN	SPECTED	BY
SHEET Z	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
ж	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:70 Revision: 01/12/04 16:22

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY		BY	
SHEET ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT



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64880 PPPL NCSX PVVS INSPECTION PLAN

*		VISUAL INSPECTION	MEG	
	Verify Panel Joint Alignment Weld Seam # 1-2	VISOAL INSECTION		
	(.02" Max)		CWI	
	Verify Panel Joint Alignment Weld Seam # 3-4 (.02" Max)		MFG CWI	
*		FEELER GAGE	MFG	
	Verify Panel / Rest Stop Position Panel #1 (009" Gap)			
*	Verify Panel / Rest Stop Position Panel #3 (009" Gap)	FEELER GAGE	MFG	
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA	
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA	
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA	
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA	
*	CWI / TEAM LEADER		QA	



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64880 PPPL NCSX PVVS INSPECTION PLAN			
VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			
	Workorder: 64880/1-0 Sub:40 Op:80	Revision	n:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	IN	INSPECTED BY		
SHEET	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	Upper Half Of Bilateral Tolerance (tack welded vessel)	SMX	QA						
*	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:90 Revision: 01/12/04 16:22

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS		QA						
		AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN

*		QA			
	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION				
*		QA			
	CWI / TEAM LEADER				
	VERIFY PARAMETER COMPLIANCE				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:40 Op:100 Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	T ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	G ,208" } Profile Tolerance (+.188 /020") (tack welded vessel)	SMX	QA						
*	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:110 Revision: 01/12/04 16:23

Part: - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4. INSTALLING AND TESTING THE PORT EXTENSION.

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS			I	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE		QA						
		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI		QA						



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Revision:

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	PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:40 Op:120

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	IN	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,228"} Profile Tolerance (+.188/040") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:130 Revision: 01/12/04 16:23

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								



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64880 PPPL	NCSX PV	VVS	INSPECTION PLA	N

0.000111	ENCOMI VVO ENDI ECITOTI I EMI			
	VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			

Workorder: 64880/1-0 Sub:40 Op:140 Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4. INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			I	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,248"} Profile Tolerance (+.188/060") (tack welded vessel)	SMX	QA						
*	l l	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:40 Op:150	Revision: 01/12/04 16:23
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Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	INSPECTED BY			
SHEET Z	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:160 Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT



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(4000 DDDT)	NICCV DVXXC	INSPECTION PLA	T.T
0400U FFFL	INCOA FY VO	INSPECTION PLA	.IN

*	Profile Tolerance (+.188/080") (tack welded vessel)	SMX	QA			
*		PERMEABILITY GAG	QA			
	Magnetic Permeability 1.01 Max. Record range (high / low)					

Workorder: 64880/1-0 Sub:40 Op:170 Revision: 01/12/04 16:24

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

		Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START		QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN							
AND THROUGH COMPLETION							
	Workorder: 6	54880/1 ₋ 0	Sub-40 Op-180			Revisio	ı

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,288") Profile Tolerance (+.188/100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:190 Revision: 01/12/04 16:24

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

		Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	ΓΙΟΝS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER		QA						



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	VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION					
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA				

Workorder: 64880/1-0 Sub:40 Op:200

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(c) ,308") Profile Tolerance (+.188/120") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:210 Revision: 01/12/04 16:16

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

		Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								i İ
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
		CWI / TEAM LEADER								
		VERIFY WELD FILLER MATERIAL COMPLI								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								



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64880 PPPL NCSX PVVS INSPECTION PLAN

*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			

Workorder: 64880/1-0 Sub:40 Op:220 Revision: 01/13/04 12:52

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS	INSPECTED BY		
SHEET	T ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	{g ,328"} Profile Tolerance (+.188/140") (tack welded vessel)	SMX	QA						
*	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:40 Op:230 Revision: 01/12/04 16:13

Part: - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE								



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	PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:40 Op:240 Revision: 01/13/04 12:53

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,328")	SMX	QA						
	1	Profile Tolerance (+.188/140")								
		(within approximately 6" of port attachment po								
		t)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								
		{# .125 p48"}	SMX	QA						
		- 1 18 -		~						İ



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64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:40 Op:250	Revision
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Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

		Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:40 Op:260 Revision: 01/16/04 9:06

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY
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64880 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,348")	SMX	QA						
		Profile Tolerance (+.188/160")								
		(within approximately 6" of port attachment po								
		t)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								
		{# .150 p48"}	SMX	QA						

Workorder: 64880/1-0 Sub:40 Op:270

Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	I	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						



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64880 PPP1	INCCY	PVVC	INCPE	CTION	PI AN
0 4 00U FFFI	レハしつム		IINOFE	CHUN	ELAN

*		QA			
	CWI / TEAM LEADER				
	VERIFY PARAMETER COMPLIANCE				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:40 Op:280 Revision: 01/16/04 9:07

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

	I	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC'	TIONS]	RESULTS	INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,358")	SMX	QA						
		Profile Tolerance (+.188/170")								
		(within approximately 6" of port attachment po								
		t)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								
		{# .150 p48"}	SMX	QA						

Workorder: 64880/1-0 Sub:40 Op:290 Revision:

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN

*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:40 Op:300 Revision: 01/16/04 9:08

Part: - - PVVS PRIMARY FABRICATION JOINING 1-3 TO 2-5-4, INSTALLING AND TESTING THE PORT EXTENSION.

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	ΓIONS]	RESULTS	INS	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,368")	SMX	QA						
		Profile Tolerance (+.188/160")								
		(within approximately 6" of port attachment po								
		t)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								
		{# .150 p48"}	SMX	QA						
				~						

Workorder: 64880/1-0 Sub:41 Op:10 Revision: 01/12/04 16:33

Part: - - PANEL SUB-SET 2-5-4

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP BY SAM		SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			VISUAL INSPECTION	MFG						



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64880 PPPL NCSX PVVS INSPECTION PLAN

1 1	Verify Panel Joint Alignment	I	1 1	Í	l	
	Weld Seam # 4-5					
	(.02" Max)		CWI			
*		FEELER GAGE	MFG			
	Verify Panel / Rest Stop Position					
	Panel #4 (009" Gap)					
*		FEELER GAGE	MFG			
	Verify Panel / Rest Stop Position					
	Panel Sub-Set #2-5 (009" Gap)					
*			QA			
	CWI / TEAM LEADER					
	VERIFY SHIELDING GAS					
	AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START					
	AND THROUGH COMPLETION					
*	THE THROUGH COM EDITOR		QA			
	CWI/TEAM LEADER		QA			
	VERIFY WELD FILLER MATERIAL COMPLI					
	PRIOR TO OPERATION START					
	AND THROUGH COMPLETION					
*			QA			
	CWI / TEAM LEADER					
	VERIFY PURGE DAM MATERIAL COMPLIA					
	PRIOR TO OPERATION START					
*	AND THROUGH COMPLETION		0.4			
*	CWI /TEAM LEADED		QA			
	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP					
	PRIOR TO OPERATION START					
	AND THROUGH COMPLETION					
*			QA			
	CWI / TEAM LEADER]	
	VERIFY PARAMETER COMPLIANCE					
	PRIOR TO OPERATION START					
	AND THROUGH COMPLETION					

Workorder: 64880/1-0 Sub:41 Op:20

Revision:



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64880 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PANEL SUB-SET 2-5-4

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(p ,188") Upper Half Of Bilateral Tolerance (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:30 Revision: 01/12/04 16:34

Part: - - PANEL SUB-SET 2-5-4

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	INSPECTION INSTRUCTIONS			RESULTS	INSPECTED BY		
SHEET	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL PRIOR TO OPERATION START AND THROUGH COMPLETION	. COMPLI	QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL PRIOR TO OPERATION START AND THROUGH COMPLETION	COMPLIA	QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIO PRIOR TO OPERATION START AND THROUGH COMPLETION	NS COMP	QA						



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64880 PPPI	NCSX PVVS	S INSPECTION PLA	N
U700V I I I L	11112272X 1 V V 1) 113171 12C2 1 1C/13 1 12/51	

*		QA			
	CWI / TEAM LEADER				
	VERIFY PARAMETER COMPLIANCE				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:41 Op:40 Revision:

Part: - - PANEL SUB-SET 2-5-4

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(c) ,208"} Profile Tolerance (+.188 /020") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						-

Workorder: 64880/1-0 Sub:41 Op:50 Revision: 01/12/04 16:34

Part: - - PANEL SUB-SET 2-5-4

	J	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	STRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE		QA						
*		PRIOR TO OPERATION START AND THROUGH COMPLETION CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI		QA						
		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA		QA						



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	PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:41 Op:60 Revision:

Part: - - PANEL SUB-SET 2-5-4

	Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,228") Profile Tolerance (+.188/040") (tack welded vessel)	SMX	QA						
*	1	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:70 Revision: 01/12/04 16:34

Part: - - PANEL SUB-SET 2-5-4

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	IN	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA		•				



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64880 PPPI	NCSY PVVS	S INSPECTION PLA	N
U700U 1 1 1 L	1 1 1 1 1 2 2 2 X 1 Y Y 1 2) 113171 12C2 1 1C <i>I</i> 13 1 12 <i>I</i> 3	11.

	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:41 Op:80 Revision:

Part: - - PANEL SUB-SET 2-5-4

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Profile Tolerance (+.188/060") (tack welded vessel)	SMX	QA						
*	1	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:90 Revision: 01/12/04 16:35

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT



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64880 PPPL NCSX PVVS INSPECTION PLAN

*				
*		QA		
	CWI / TEAM LEADER			
	VERIFY SHIELDING GAS			
	AND PURGE GAS COMPLIANCE			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER			
	VERIFY WELD FILLER MATERIAL COMPLI			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
*	AND THROUGH COM LETTOR	QA		
,	CNII / TELAN (I E A DED	QA		
	CWI/TEAM LEADER			
	VERIFY PURGE DAM MATERIAL COMPLIA			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER			
	VERIFY WELDER QUALIFICATIONS COMP			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER			
	VERIFY PARAMETER COMPLIANCE			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
	ALD THOUGH COMELLION			

Workorder: 64880/1-0 Sub:41 Op:100 Revision:

Part: - - PANEL SUB-SET 2-5-4

Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS]	INSPECTED BY		BY	
SHEET	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	Profile Tolerance (+.188/080") (tack welded vessel)	SMX	QA						
*	Magnetic Permeability 1.01 Max.	PERMEABILITY GAG	QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN								
Record range (high / low)]
	Workorder: 64	1880/1-0 Sub:4	41 Op:110		Re	vision: 01	/12/04 16	:35

Part: - - PANEL SUB-SET 2-5-4

	I	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS	RESULTS		INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:41 Op:120

Revision:

Part: - - PANEL SUB-SET 2-5-4



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64880 PPPL NCSX PVVS INSPECTION PLAN

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	II.	(g ,288") Profile Tolerance (+.188/100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:41 Op:130 Revision: 01/12/04 16:37

Part: - - PANEL SUB-SET 2-5-4

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS	RESULTS			INSPECTED BY		
SHEET ZON	NE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA							
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA							
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA							
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA							
*	CWI / TEAM LEADER		QA							



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64880 PPPL NCSX PVVS INSPECTION PLAN		
VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		
	Workorder: 64880/1-0 Sub:41 Op:140	Revision:

Part: - - PANEL SUB-SET 2-5-4

rait.	rt: - PANEL SUB-SET 2-3-4										
	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		(g ,308") Profile Tolerance (+.188/120") (tack welded vessel)	SMX	QA							
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA							

Workorder: 64880/1-0 Sub:41 Op:150 Revision: 01/12/04 16:37

Part: - - PANEL SUB-SET 2-5-4

	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET ZO	ONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS		QA						
	AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						



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*		QA		
	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
į	CWI / TEAM LEADER			
	VERIFY PARAMETER COMPLIANCE			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			

Workorder: 64880/1-0 Sub:41 Op:160 Revision:

Part: - - PANEL SUB-SET 2-5-4

1 111 11	, Interpolation									
]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Profile Tolerance (+.188/140") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:10 Revision: 01/12/04 16:38

Part: - - PANEL SUB-SET 1,3

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 1-3	VISUAL INSPECTION							
*		(.02" Max)	FEELER GAGE	CWI MFG						
		Verify Panel / Rest Stop Position Panel #1 (009" Gap)	I LLLEK GAGE	MIO						
*		Verify Panel / Rest Stop Position	FEELER GAGE	MFG						



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64880 PPPL NCSX PVVS INSPECTION PLAN

	Panel #3 (009" Gap)			1	ĺ	
ж	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA				
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	QA				
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA				
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA				
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA				

Workorder: 64880/1-0 Sub:43 Op:20	Revision:
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Part: - - PANEL SUB-SET 1.3

	I	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(c) ,188"} Upper Half Of Bilateral Tolerance (tack welded vessel)	SMX	QA						
*			PERMEABILITY GAG	QA		_				



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64880	64880 PPPL NCSX PVVS INSPECTION PLAN											
1		Magnetic Permeability 1.01 Max.										
		Record range (high / low)										

Workorder: 64880/1-0 Sub:43 Op:30 Revision: 01/12/04 16:38

Part: - - PANEL SUB-SET 1,3

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET Z	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:43 Op:40 Revision: 01/07/04 17:48



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64880 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PANEL SUB-SET 1,3

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Q ,208"} Profile Tolerance (+.188 /020") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:50 Revision: 01/12/04 16:39

Part: - - PANEL SUB-SET 1.3

	PRIOR TO OPERATION START AND THROUGH COMPLETION CWI / TEAM LEADER		INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START		QA						
*		VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						



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CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE				
PRIOR TO OPERATION START				
AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:43 Op:60 Revision: 01/07/04 17:47

Part: - - PANEL SUB-SET 1,3

	I	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,228"} Profile Tolerance (+.188/040") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:70 Revision: 01/12/04 16:39

Part: - - PANEL SUB-SET 1.3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
		CWI / TEAM LEADER								
		VERIFY WELD FILLER MATERIAL COMPLI								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
		CWI / TEAM LEADER								
		VERIFY PURGE DAM MATERIAL COMPLIA								
		PRIOR TO OPERATION START								



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	64880 PPPL	NCSX PVVS	SINSPECTION PLAN
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	AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:43 Op:80 Revision: 01/08/04 8:09

Part: - - PANEL SUB-SET 1,3

	Ι	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,248") Profile Tolerance (+.188/060") (tack welded vessel)	SMX	QA						
*	1 1	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:90 Revision: 01/12/04 16:40

Part: - - PANEL SUB-SET 1.3

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER		QA						
		VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		CWI / TEAM LEADER		QA						



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64880 PPPI	NCSY PVVS	INSPECTION PLAN	V
V 7 000 1 1 1 1	1111277X 1 V V 17	111171 120 1 1071 1 1271	•

	VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:43 Op:100 Revision: 01/08/04 8:12

Part: - - PANEL SUB-SET 1.3

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS		RESULTS		INSPECTED BY		BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(c) ,268") Profile Tolerance (+.188/080") (tack welded vessel)	SMX	QA						
*	1	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:43 Op:110 Revision: 01/12/04 16:40

Part: - - PANEL SUB-SET 1,3

		Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS]	RESULTS	IN	SPECTED	BY
SHEE	T ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						



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	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:43 Op:120 Revision: 01/08/04 9:03

Part: - - PANEL SUB-SET 1,3

	Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	l l	(g ,288") Profile Tolerance (+.188/100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:43 Op:130	Revision: 01/12/04 16:40
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Part: - - PANEL SUB-SET 1,3

	Drawing ID: SE121-001P Rev: 0		INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START		QA						
		AND THROUGH COMPLETION								
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:43 Op:140 Revision: 01/08/04 9:04

Part: - - PANEL SUB-SET 1,3



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64880 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,308")	SMX	QA						
		Profile Tolerance (+.188/120")								
		(tack welded vessel)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								

Workorder: 64880/1-0 Sub:43 Op:150 Revision: 01/12/04 16:41

Part: - - PANEL SUB-SET 1,3

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		
SHEET ZONI	E CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE		QA						



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64880	1880 PPPL NCSX PVVS INSPECTION PLAN										
		PRIOR TO OPERATION START AND THROUGH COMPLETION									

Workorder: 64880/1-0 Sub:43 Op:160 Revision: 01/16/04 9:17

Part: - - PANEL SUB-SET 1.3

	Drawing ID: SE121-001P Rev	v: 0 INSPECTION IN	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	T ZONE CHARACTERIS	TIC GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	Yer (+.188/140) Profile Tolerance (+.188/140) (tack welded vessel)	SMX	QA						
*	Magnetic Permeability 1.01 M Record range (high / low)	PERMEABILITY GAC ax.	G QA						

Workorder: 64880/1-0 Sub:45 Op:10 Revision: 01/12/04 16:26

Part: - - PANEL SUB-SET 2-5

	Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS		RESULTS	INSPECTED BY		BY
SHEET ZO	ONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	Verify Panel Joint Alignment Weld Seam # 2-5	VISUAL INSPECTION	MFG CWI						
*	Verify Panel / Rest Stop Position Panel #2 (009" Gap)	FEELER GAGE	MFG						
*	Verify Panel / Rest Stop Position Panel #5 (009" Gap)	FEELER GAGE	MFG						
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN

*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA			

Workorder: 64880/1-0 Sub:45 Op:20 Revision:

Part: - - PANEL SUB-SET 2-5

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS		RESULTS		INSPECTED BY		BY	
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(tack welded vessel)	SMX	QA						
*	l .	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:30 Revision: 01/12/04 16:26

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS	RESULTS	INSPECTED BY
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64880 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
*		AND THROUGH COMPLETION		0.4						
, "		CWI / TEAM LEADER		QA						
		VERIFY WELD FILLER MATERIAL COMPLI								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
		CWI / TEAM LEADER								
İ		VERIFY PURGE DAM MATERIAL COMPLIA								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
	1	CWI/TEAM LEADER								
		VERIFY WELDER QUALIFICATIONS COMP								
		PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		AND THROUGH COM LETION		QA						
		CWI / TEAM LEADER		L VA						
	1	VERIFY PARAMETER COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								i i

Workorder: 64880/1-0 Sub:45 Op:40 Revision:

Part: - - PANEL SUB-SET 2-5

		Drawing ID: SE121-001P Rev: 0	INSPECTION INS	TRUC	TIONS	I	RESULTS	INSPECTED BY		BY
SHEET	CET ZONE CHARACTERISTIC		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	I	(g ,208") Profile Tolerance (+.188 /020") (tack welded vessel)	SMX	QA						-
*			PERMEABILITY GAG	QA						



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64880 PPPL NCSX PVVS INSPECTION PLAN										
Magnetic Permeability 1.01 Max. Record range (high / low)										

Workorder: 64880/1-0 Sub:45 Op:50 Revision: 01/12/04 16:26

Part: - - PANEL SUB-SET 2-5

	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS]	RESULTS	INSPECTED BY		
SHEET Z	CONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

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64880 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PANEL SUB-SET 2-5

		Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	INSPECTED BY		BY		
SHEET	IEET ZONE CHARACTERISTIC		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,228") Profile Tolerance (+.188/040") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:70 Revision: 01/12/04 16:31

Part: - - PANEL SUB-SET 2-5

		Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						



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CWI/TEAM LEADER				
VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START				
AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:45 Op:80 Revision:

Part: - - PANEL SUB-SET 2-5

]	Drawing ID: SE121-001P Rev: 0	INSPECTION INSTRUCTIONS]	IN	INSPECTED BY			
SHEET	IEET ZONE CHARACTERISTIC		GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		{g ,248"} Profile Tolerance (+.188/060") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:90 Revision: 01/12/04 16:31

Part: - - PANEL SUB-SET 2-5

]	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	IN	SPECTED	BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
İ		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
		CWI / TEAM LEADER								
		VERIFY WELD FILLER MATERIAL COMPLI								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
		CWI / TEAM LEADER								
		VERIFY PURGE DAM MATERIAL COMPLIA								
		PRIOR TO OPERATION START		1						



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64880 PPPI	NCSX PVVS	INSPECTION PL	AN

	AND THROUGH COMPLETION] !
*		QA			
	CWI / TEAM LEADER				
	VERIFY WELDER QUALIFICATIONS COMP				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				
*		QA			
	CWI / TEAM LEADER				
	VERIFY PARAMETER COMPLIANCE				
	PRIOR TO OPERATION START				
	AND THROUGH COMPLETION				

Workorder: 64880/1-0 Sub:45 Op:100 Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	ZONE CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*	Profile Tolerance (+.188/080") (tack welded vessel)	SMX	QA						
*	Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:110 Revision: 01/12/04 16:32

Part: - - PANEL SUB-SET 2-5

]	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						
		CWI / TEAM LEADER								
		VERIFY SHIELDING GAS								
		AND PURGE GAS COMPLIANCE								
		PRIOR TO OPERATION START								
		AND THROUGH COMPLETION								
*				QA						
İ		CWI / TEAM LEADER								



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	VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER			
	VERIFY PURGE DAM MATERIAL COMPLIA			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER			
	VERIFY WELDER QUALIFICATIONS COMP			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			
*		QA		
	CWI / TEAM LEADER			
	VERIFY PARAMETER COMPLIANCE			
	PRIOR TO OPERATION START			
	AND THROUGH COMPLETION			

Workorder: 64880/1-0 Sub:45 Op:120 Revision:

Part: - - PANEL SUB-SET 2-5

	Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,288") Profile Tolerance (+.188/100") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

Workorder: 64880/1-0 Sub:45 Op:130 Revision: 01/12/04 16:32

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS]	INSPECTED BY				
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						



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	CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION			
*	CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		
*	CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION	QA		

Workorder: 64880/1-0 Sub:45 Op:140 Revision:

Part: - - PANEL SUB-SET 2-5

	Drawing ID: SE121-001P Rev: 0		INSPECTION INS	INSPECTION INSTRUCTIONS			RESULTS			BY
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,308") Profile Tolerance (+.188/120") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						





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Workorder: 64880/1-0 Sub:45 Op:150 Revision: 01/12/04 16:32

Part: - - PANEL SUB-SET 2-5

	-	Drawing ID: SE121-001P Rev: 0	INSPECTION IN	STRUC	TIONS		RESULTS	INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START	-	QA						
*		AND THROUGH COMPLETION CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

Workorder: 64880/1-0 Sub:45 Op:160 Revision: 01/16/04 9:16

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0 INSPECTION INSTRUCTIONS RESULTS



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SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		(g ,328")	SMX	QA						
	1	Profile Tolerance (+.188/140") (tack welded vessel)								
*			PERMEABILITY GAG	QA						
		Magnetic Permeability 1.01 Max.								
		Record range (high / low)								