



Procedure 03-8083-P04

Radiographic Examination



RADIOGRAPHIC EXAMINATION

1.0 Purpose:

To establish the method for Radiographic Examination for the Prototype Vacuum Vessel Segment for the National Compact Stellarator Experiment.

2.0 Scope:

All welded joints are to be radiographically examined with documented results. This procedure is supplied by and shall be completed by an External Supplier (Technico) and provides general instructions that are not specific to the Prototype Vacuum Vessel Segment for the National Compact Stellarator Experiment only. Requirements stated by Precision Metal Works shall supersede requirements or procedural options listed in the accompanying Technico procedure.

3.0 References:

- National Compact Stellarator Experiment (NCSX) Specification NCSX-CSPEC-121-01-01.
- ASME V, Article 2.
- ASME VIII, Division 1, UW-51.
- Technico -- Quality Control and Technical Operations Procedure for Radiographic Examination (General) QC-TOP-RT-1, Rev. 03.

4.0 Equipment:

- See Technico -- Quality Control and Technical Operations Procedure for Radiographic Examination (General) QC-TOP-RT-1, Rev. 03.

5.0 Procedure:

- The densitometer method of calibration shall be used with Section 15.2 of the Technico Procedure.
- All welded joints shall be inspected.
- See Technico -- Quality Control and Technical Operations Procedure for Radiographic Examination (General) QC-TOP-RT-1, Rev. 03.
- Acceptance criteria shall be as per ASME VIII, Division 1, UW-51.