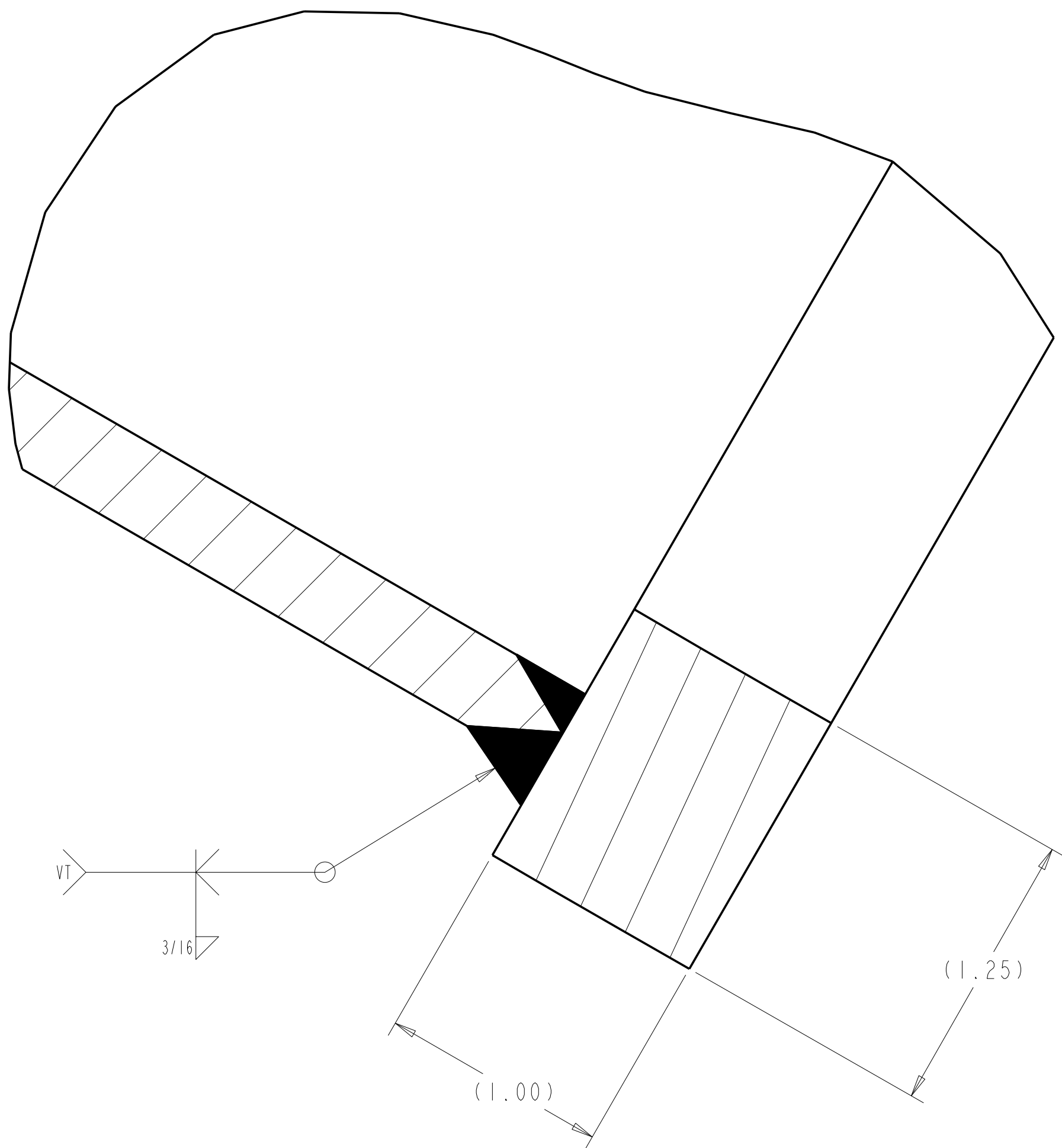
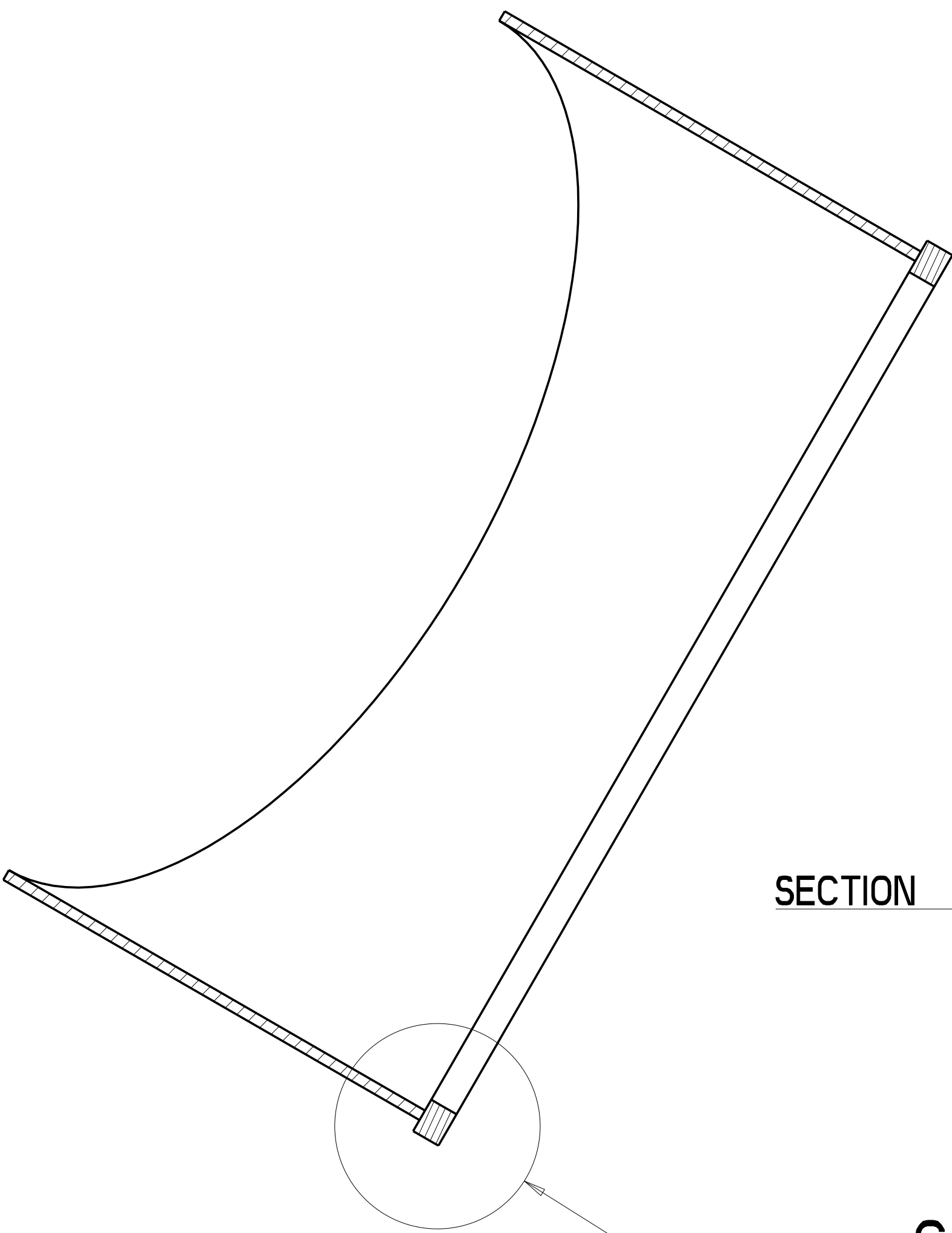


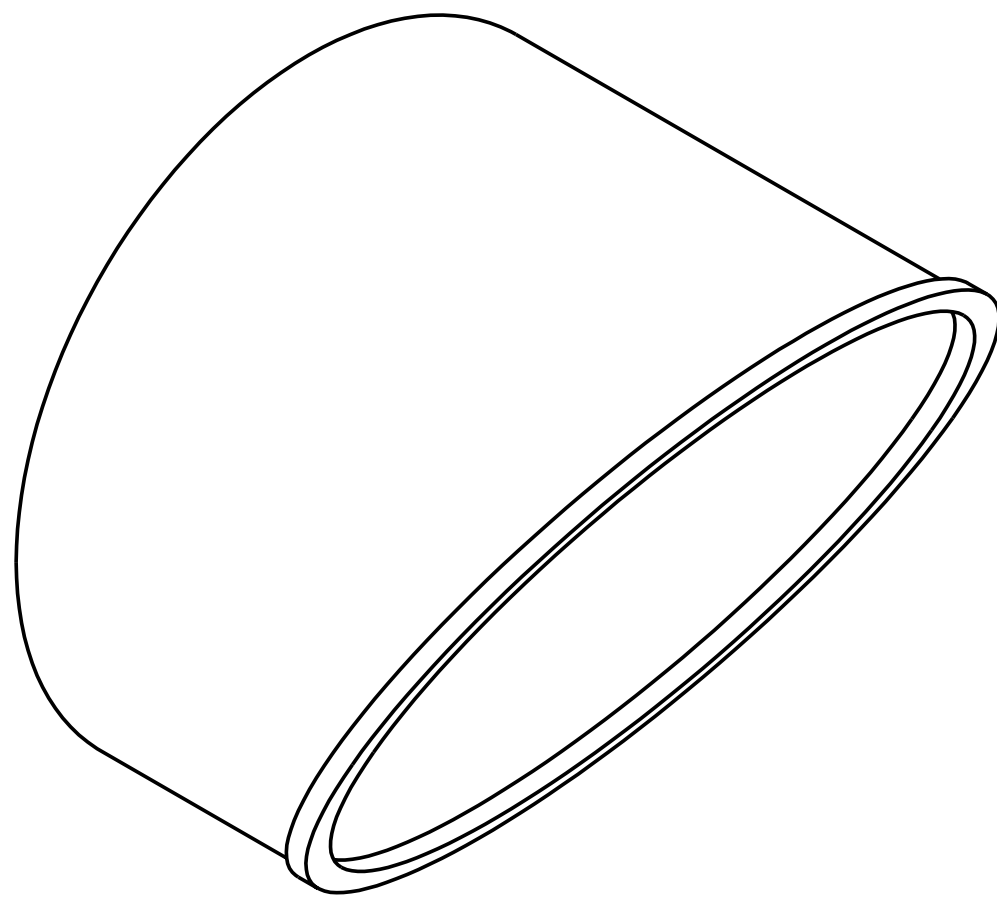
- NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.
 2. DIMENSION ARE IN INCHES.
 3. REQUIREMENTS FOR FABRICATING THE VACUUM VESSEL END STOCK WELDMENT ARE DEFINED IN THE DRAWINGS, MODELS, AND NCSX-SOW-121-02-00.
 4. GEOMETRY OF VACUUM VESSEL END STOCK WELDMENT IS DEFINED IN CAD MODELS/FILES SEI203-005.ASM, SEI203-013.PRT AND SEI203-015.PRT.
 5. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.
 6. WELD INSPECTIONS SHALL BE PERFORMED BY VISUAL EXAMINATION: ALL WELDS ARE TO BE VISUALLY INSPECTED IN ACCORDANCE WITH ARTICLE 9, SECTION V OF THE ASME CODE. WELDS DESIGNATED WITH A "VT" IN THE REFERENCE AREA OF A WELD SYMBOL SHALL ALSO BE VISUALLY EXAMINED WITH 8X MAGNIFICATION, IN ACCORDANCE WITH ARTICLE 6, SECTION V OF THE ASME CODE. THE ACCEPTANCE CRITERIA FOR THE VISUALLY INSPECTED WELDS IS GIVEN IN AWS D1.6, PARAGRAPH 6.29.1. ALL WELDS THAT DO NOT MEET THE STATED ACCEPTANCE CRITERIA SHALL BE DOCUMENTED, REPAIRED AND RE-INSPECTED. VISUAL WELD INSPECTION SHALL BE DONE BY INSPECTORS CERTIFIED TO PERFORM VISUAL INSPECTION OF WELDS IN ACCORDANCE WITH AWS QCI OR SNT-TC-1A, LEVEL II OR LEVEL III.



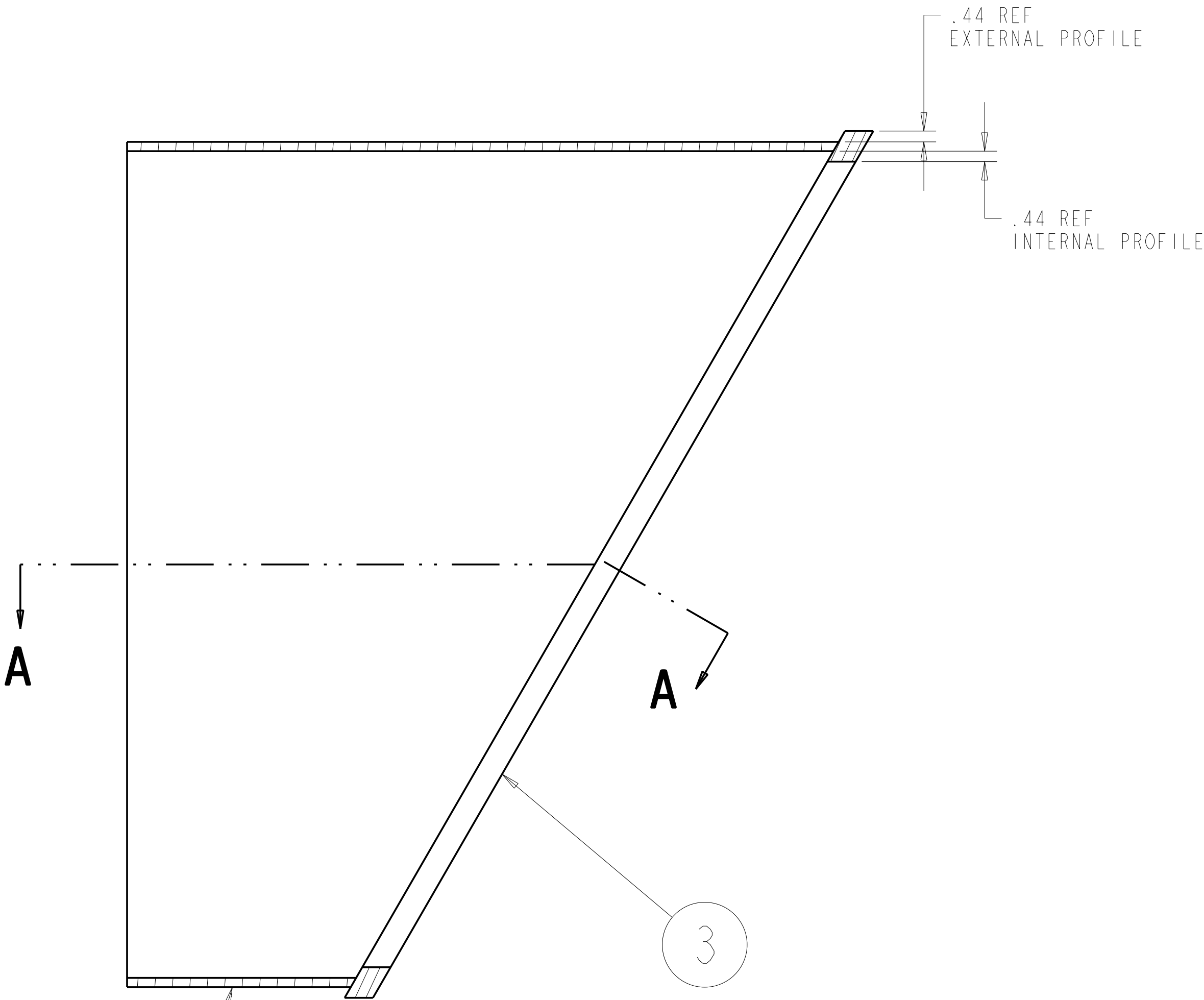
DETAIL C
SCALE 2.000



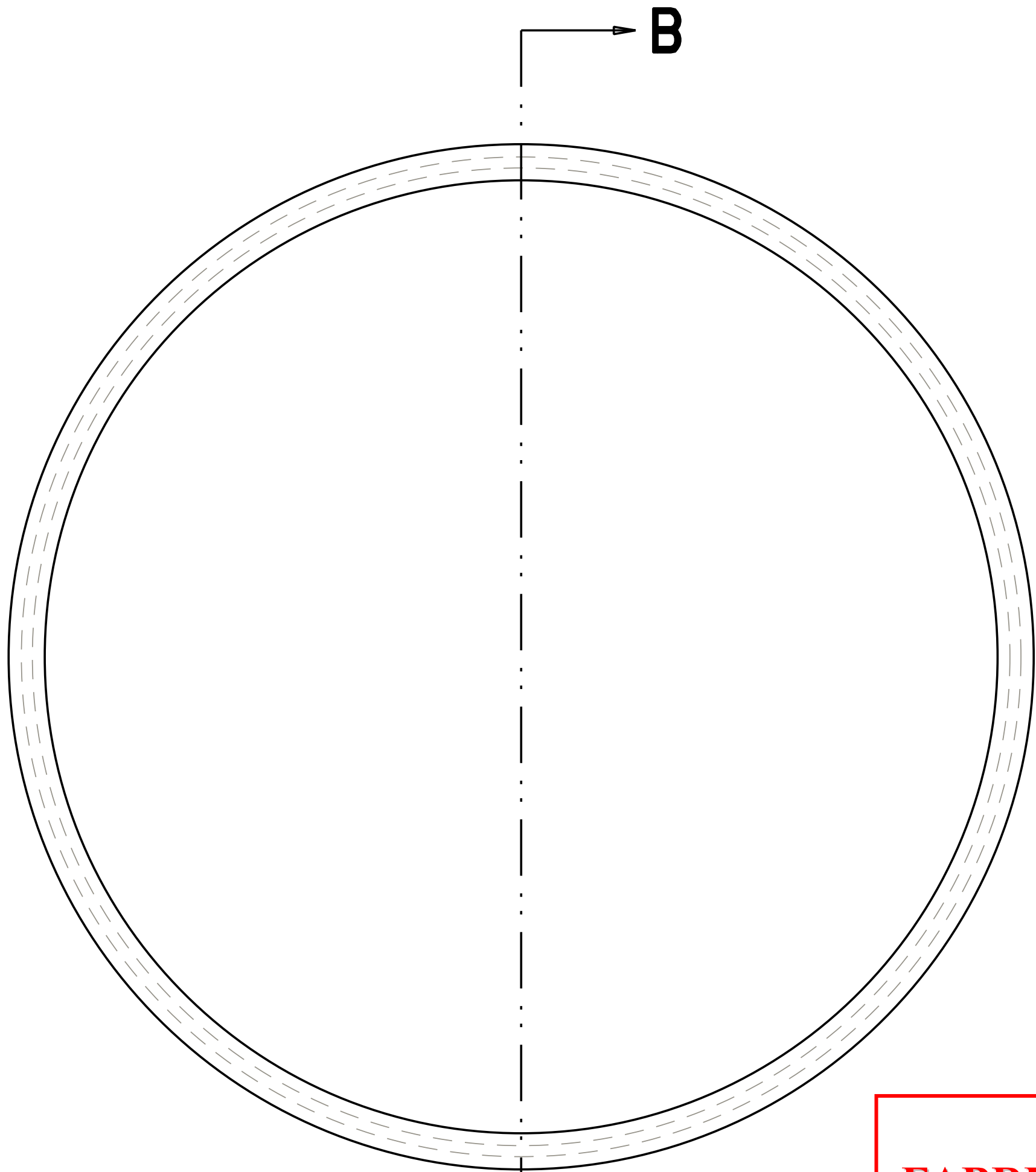
SECTION A-A



REFERENCE VIEW
SCALE 0.125



SECTION B-B



SCALE 0.250

RELEASED FOR
FABRICATION / INSTALLATION
PPPL Drafting:

next assembly	I	SEI203-015	VVFWJ FLANGE STOCK	INCONEL	UNS N06625	3
	I	SEI203-012	VVFWJ END PIECE BODY	INCONEL	UNS N06625	2
	I	SEI203-005	VVFWJ END PIECE STOCK	INCONEL	UNS N06625	1
	CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
NEXT ASSEMBLY						PARTS LIST

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THIS DRAWING PRODUCED
ON PRO-ENGINEER

REV	DESCRIPTION	BY	DATE	CHK	DEPT	DATE	PE	REQ	DATE	ORNL	DOE	DATE
REVISION OR ISSUE PURPOSE												
REVISION APPROVAL												

SCALE AS NOTED		DES: P. GORANSON	27MAR04	Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-00OR22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee	
TOLERANCES UNLESS OTHERWISE SPECIFIED		DRW: G. FORTIER	28MAR04	UT-BATTELLE	
FRACTIONS		CHK: G. LOVETT	6APR04	PROJECT NAME	
XX DECIMALS ±.01		SECT: :	:	NATIONAL COMPACT STELLARATOR EXPERIMENT	
XXX DECIMALS ±.005		DEPT: :	:	VACUUM VESSEL END STOCK WELDMENT	
ANGLES ±0°15'		PE: :	:	PPPL DRFT	
BREAK SHARP EDGES .06 MAX		CR: :	:	PPPL WELD ENGR - R. Parsells	
FINISH .125 UNLESS OTHERWISE SPECIFIED		PJ: :	:	4/6/04	
		REQ: :	:	VERSION NO.	
				PLANT ORNL	
				BLDG 5700	
				FL 3	
				SHT 1	
				TYPE D	
				CLASS U	
				REV 0	
				DRAWING APPROVALS	
				DATE	
				RELEASE LEVEL	
				Fabrication	
				SEI203-005	