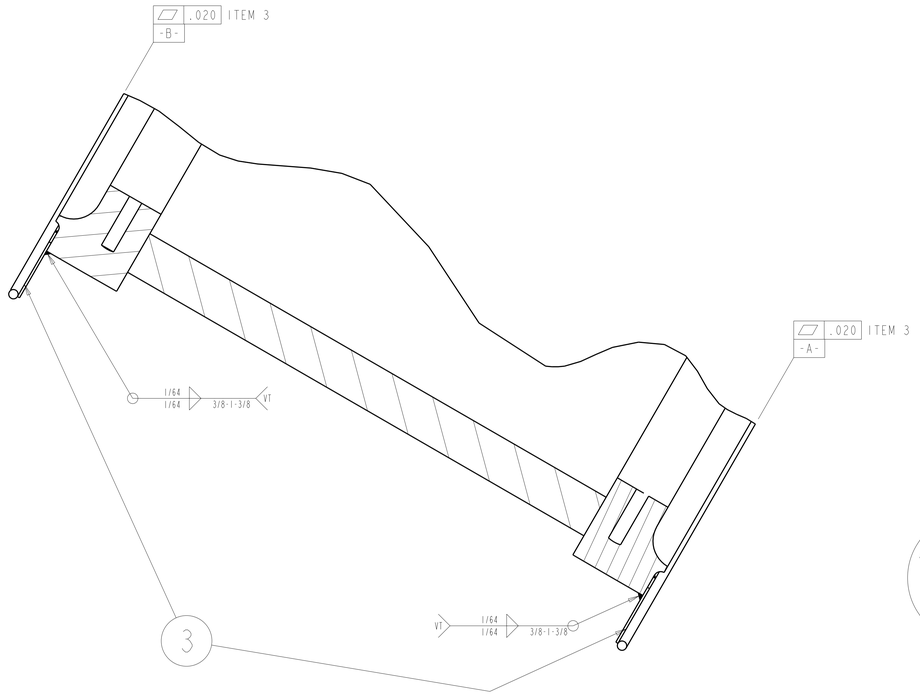
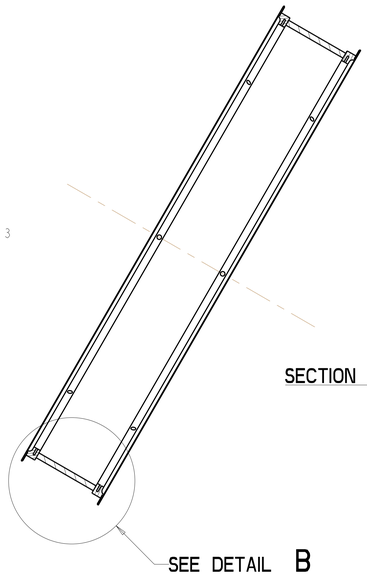




NOTES:
1. INTERPRET DIMENSIONS AND TOLERANCES PER ANSI Y14.5M.

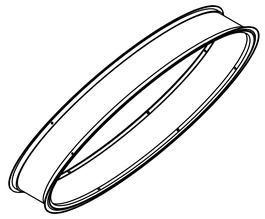
2. DIMENSION ARE IN INCHES.

3. REQUIREMENTS FOR FABRICATING THE SPOOL PIECE ASSEMBLY SEAL WELDMENT ARE DEFINED IN THE DRAWINGS, MODELS, AND NCSX-SOW-121-02-00.

4. GEOMETRY OF SPOOL PIECE ASSEMBLY SEAL WELDMENT IS DEFINED IN CAD MODELS/FILES SE1203-006.ASM, SE1203-002.ASM AND SE1203-008.ASM.

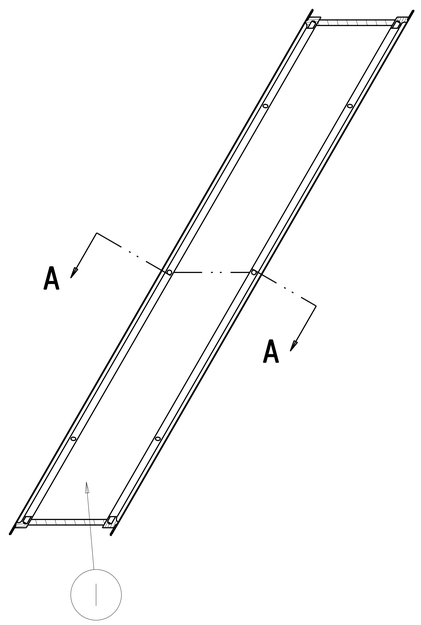
5. WELDING PROCEDURES AND PERFORMANCE QUALIFICATIONS SHALL BE PERFORMED IN ACCORDANCE WITH THE REQUIREMENTS OF ASME CODE, SECTION IX. WELDS MAY BE MADE BY THE GTAW OR GMAW PROCESSES. WELDS USING SMAW PROCESS ARE NOT PERMITTED.

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 QC1 OR SNT-TC-1A, LEVEL II OR LEVEL III.

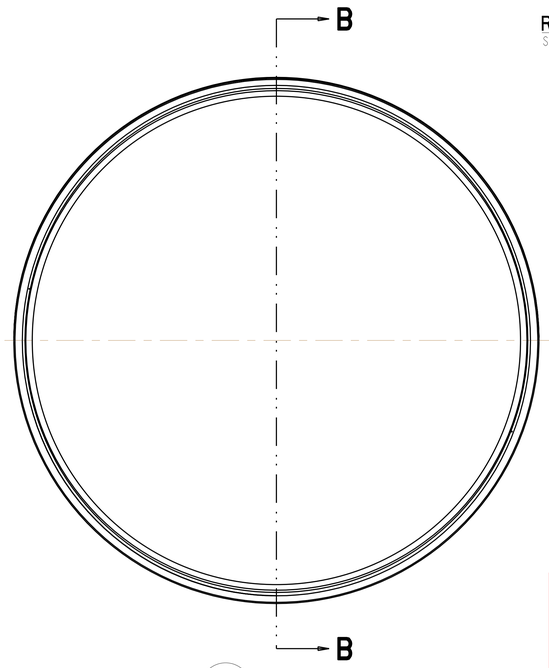


REFERENCE VIEW
SCALE 0.125

DETAIL B
SCALE 2.000



SECTION B-B



2 SCALE 0.250

RELEASED FOR FABRICATION / INSTALLATION
PPPL Drafting: Jerry Siegel 2004.04.26 12:38:42 -05'00'

next assy		CAGE CODE	PART OR IDENTIFYING NO	NOMENCLATURE OR DESCRIPTION	MATERIAL	SPECIFICATION	FIND NO
	2		SE1203-008	VVFWJ SPOOL SEAL WELDMENT	--	--	3
	1		SE1203-006	SPOOL PIECE ASSEMBLY - WELDMENT	INCONEL	UNS N06625	2
	1		SE1203-002	VVFWJ SPOOL PIECE MACHINING	INCONEL	UNS N06625	1
	-1	← NEXT ASSEMBLY		PARTS LIST			

SE1203-006

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P 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
TOLERANCES UNLESS OTHERWISE SPECIFIED
FRACTIONS
XX DECIMALS ±.01
XXX DECIMALS ±.005
ANGLES ±0°15'
BREAK SHARP EDGES .06 MAX
FINISH .125 UNLESS OTHERWISE SPECIFIED

DRAWING APPROVALS		DATE
DES	P.GORANSON	27MAR04
DRW	G.FORTIER	28MAR04
CHK	G.LOVETT	6APR04
SECT	:	:
DEPT	:	:
PE	:	:
CR	:	:
PJ	:	:
REQ	:	:
PPPL DRFT	:	:
PPPL WELD ENGR - R. Parsells		4/6/04
	:	:

UT-BATTELLE
Oak Ridge National Laboratory managed for the DEPARTMENT OF ENERGY under U.S. GOVERNMENT contract DE-AC05-000R22725 UT-BATTELLE, LLC. Oak Ridge, Tennessee

PROJECT NAME: NATIONAL COMPACT STELLARATOR EXPERIMENT

SPOOL PIECE ASSEMBLY
SEAL WELDMENT

VERSION NO.	PLANT	BLDG	FL	SHT	OF	TYPE	CLASS
	ORNL	5700	3	1	1	D	U

RELEASE LEVEL: Fabrication
SE1203-006
REV 0