



**INSPECTION DATA CHECKLIST**

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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03			A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.412	085-D.GR 10-02-03			A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03			A

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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS	VISUAL INSPECTION	QA		VISUAL	OK	085-D.GR 01-16-04			A

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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		MAGNETIC PERMEABILITY OF ANNEALE	PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR			A

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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

	1.01 MAX						01-16-04		
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Workorder: 64880/1-0 Sub:14 Op:40

Revision: 01/20/04 10:51

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

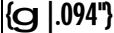
Drawing ID: SE121-001P Rev: A			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG QA			.080 (GOOD) FEELER GAGE	746-G.D 10-29-03	522-R.DU 10-29-03	

A

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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA 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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA			TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03		
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.405	085-D.GR 10-02-03		
*			VISUAL INSPECTION	QA			VISUAL GOOD	085-D.GR		

A

A

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**64880 PPPL NCSX PVVS INSPECTION PLAN**

		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)															10-02-03	
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**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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR			A
								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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR			A
								01-16-04			

**Workorder: 64880/1-0 Sub:15 Op:40**

**Revision: 01/20/04 11:08**

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

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

**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 INSTRUCTIONS			RESULTS		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**

*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA					
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA					
*		 .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**

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

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

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**INSPECTION DATA CHECKLIST**

**64880 PPPL NCSX PVVS INSPECTION PLAN**

**Workorder: 64880/1-0 Sub:16 Op:35**

Revision: 12/11/03 15:14

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

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

**Workorder: 64880/1-0 Sub:16 Op:40**

Revision: 01/20/04 11:08

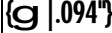
**Part: - - SE121-001P-2 PANEL # 3**

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG QA						

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

**Workorder: 64880/1-0 Sub:17 Op:10**

Revision: 12/11/03 15:15

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

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

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**64880 PPPL NCSX PVVS INSPECTION PLAN**

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

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

**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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR 01-16-04		A

**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			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT

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### INSPECTION DATA CHECKLIST


**64880 PPPL NCSX PVVS INSPECTION PLAN**

1*		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG QA	J-642	.094" NOGO	407-R.TH 01-20-04	363-C.M 01-20-04		A
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**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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		 .094" .094" Max Gap (Part Surface To gauge)	TEMPLATE FEELER GAGE	QA 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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.0 Max. (Panel Blank)	PERMEABILITY GAG	QA		J-1143	TESTED 15 RANDOM LOCATIONS, MAX. MAG. PERMEABILITY =1.000	581-D.ED 09-25-03		A
*		.375 (+.040/-0) (Panel Blank)	ULTRASONIC THICK O.D. MICS	QA		J-160	.415	085-D.GR 10-02-03		A
*		SURFACE FINISH: SMOOTH, CLEAN, NO HEAVY SCRAPES, PITS, OR GOUGES (Panel Blank)	VISUAL INSPECTION	QA		VISUAL	GOOD	085-D.GR 10-02-03		A

**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		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		VERIFY HEAT TREAT CERTIFICATION AND FURNACE CHART COMPLY WITH MTM PURCHASE ORDER REQUIREMENTS	VISUAL INSPECTION	QA			VISUAL	825-B.JA		
								01-07-04		

A

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			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY OF ANNEALE 1.01 MAX	PERMEABILITY GAG	QA		J-1165	UNDER 1.01	085-D.GR		
								01-16-04		

A

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			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
1*		.094" Max Gap (Part Surface To gauge)	FEELER GAGE	MFG QA		J-642	.094" NOGO	407-R.TH	363-C.M	
								01-20-04	01-20-04	

A

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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability 1.01 Max	PERMEABILITY GAG	QA						
*		32 MICRO-INCH SURFACE FINISH (INTERIOR (CONCAVE) SIDE)	PROFILOMETER	QA						
*		{g  .094"}	TEMPLATE	QA						

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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

	.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 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		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			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		32 Micro Surface Finish (Interior)	PROFILOMETER	QA						
*		1.2 Max Magnetic Permeability (Flange To Tube)	PERMEABILITY GAG	QA						

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

Workorder: 64880/1-0 Sub:25 Op:15

Revision: 12/11/03 15:30

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

Drawing ID: SE121-003P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
		MAGNETIC PERMEABILITY 1.01 MAX (AFTER ROLLING / PRIOR TO WELDING)	PERMEABILITY GAG	QA			15 RANDOM LOCATION HIGH=1.007, LOW=1.006	581-D.ED 09-22-03			A

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 / 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: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		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY 1.01 MAX	ULTRASONIC THICK	QA						
*		CLEANLINESS PER PP475		QA						

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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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT	
*		Verify Panel Joint Alignment Weld Seam # 2-5 (.02" Max)	VISUAL INSPECTION	MFG			LESS THAN .020 MISM ATCH	791-D.W	933-DLE		A
				CWI				01-28-04	01-28-04		
*		Verify Panel / Rest Stop Position Panel #2 (0 - .09" Gap)	FEELER GAGE	MFG			LESS THAN .090	791-D.W			A
								01-28-04			
*		Verify Panel / Rest Stop Position Panel #5 (0 - .09" Gap)	FEELER GAGE	MFG			LESS THAN .090	791-D.W			A
								01-28-04			
*		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
								01-28-04			
*		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
								01-28-04			
*		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			A
								01-28-04			

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64880 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMP PRIOR TO OPERATION START AND THROUGH COMPLETION		QA			VERIFIED PER WELDER QUALIFICATION CHECK SYSTEM	791-D.W  01-28-04			A
*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA			WELDER SET AT 140 M AX AMPERAGE AT TAC WELD OP	791-D.W  01-28-04			A

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

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		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER		QA						

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64880 PPPL NCSX PVVS INSPECTION PLAN

		VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMPLIANCE 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:90

Revision: 01/27/04 10:20

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

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .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)								
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Workorder: 64880/1-0 Sub:26 Op:100

Revision:

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

Drawing ID: SE121-001P Rev: 0		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 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						

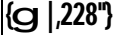
Workorder: 64880/1-0 Sub:26 Op:110

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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  ,228" Profile Tolerance (+.188/-.040") (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:120

Revision:

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

Drawing ID: SE121-001P Rev: 0			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 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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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
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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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		.248" 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

Drawing ID: SE121-001P Rev: 0			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 COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*				QA						

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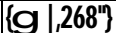
64880 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA PRIOR TO OPERATION START AND THROUGH COMPLETION								
*		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:150

Revision: 01/27/04 10:25

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  ,268" Profile Tolerance (+.188/-.080") (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:160

Revision:

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

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

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64880 PPPL NCSX PVVS INSPECTION PLAN

		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

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		 .288" Profile Tolerance (+.188/-.100") (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						

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**INSPECTION DATA CHECKLIST**

64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:26 Op:180

Revision:

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

Drawing ID: SE121-001P Rev: 0		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 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
*		<b>(g  ,308")</b> Profile Tolerance (+.188/-.120") (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:200

Revision:

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

Drawing ID: SE121-001P Rev: 0			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 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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**64880 PPPL NCSX PVVS INSPECTION PLAN**

		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION							
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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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		   .328" 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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		MAGNETIC PERMEABILITY 1.01 MAX		QA			MAX. RECORDING OF P ERM. OF PLATE 1.002 , 12 PLCS. RANDOMLY CHECKED.	581-D.ED  09-17-03		

Workorder: 64880/1-0 Sub:29 Op:30

Revision: 12/11/03 15:34

**Part: SE212-003P-3 - -**

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

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**INSPECTION DATA CHECKLIST**

**64880 PPPL NCSX PVVS INSPECTION PLAN**

	MAGNETIC PERMEABILITY 1.01 MAX (AFTER ROLLING / PRIOR TO WELDING)					.006		09-22-03	
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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 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		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						
Drawing ID: SE121-002P Rev: --			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
				QA						

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**INSPECTION DATA CHECKLIST**

**64880 PPPL NCSX PVVS INSPECTION PLAN**

	Verify Port Tube Weld Joint Alignment (.02" Max)								
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**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 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		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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		32 MICRO-INCH RA SURFACE FINISH	PROFILOMETER	QA						

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64880 PPPL NCSX PVVS INSPECTION PLAN

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

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

Revision:

Part: - - NAMEPLATE

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

A

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

Revision:

Part: - - NAMEPLATE

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

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 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		CWI						

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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 07Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

Drawing ID: SE121-003P Rev: 0		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		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 07Jan03 BASED ON RELEASE MEETING DISCUSSION PRIMARY STR

Drawing ID: SE121-003P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Magnetic Permeability of all Inconel 625 Material And Weld Zones (1.01 Max)	PERMEABILITY GAG	QA						
*		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						
*		<b>{g  ,375}</b> Finished part profile	SMX	QA						
*		<b>{#  d.125"p48"  A B C}</b> Port Extension position (after re-attachment)	SMX	QA						

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64880 PPPL NCSX PVVS INSPECTION PLAN

		.375 +0.04/-0.06"		QA					
		.125 +/-0.013"		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 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 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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**INSPECTION DATA CHECKLIST**

64880 PPPL NCSX PVVS INSPECTION PLAN

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

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 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 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: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			RESULTS		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

*		Verify Panel Joint Alignment Weld Seam # 1-2 (.02" Max)	VISUAL INSPECTION	MFG					
				CWI					
		Verify Panel Joint Alignment Weld Seam # 3-4 (.02" Max)		MFG					
				CWI					
*		Verify Panel / Rest Stop Position Panel #1 (0 - .09" Gap)	FEELER GAGE	MFG					
*		Verify Panel / Rest Stop Position Panel #3 (0 - .09" 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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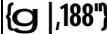
64880 PPPL NCSX PVVS INSPECTION PLAN

	VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
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Workorder: 64880/1-0 Sub:40 Op:80

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
*		  ,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: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 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 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

*		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: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			RESULTS		INSPECTED BY		
SHEET	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			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		QA						

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**64880 PPPL NCSX PVVS INSPECTION PLAN**

		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**

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
*		  .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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		CWI / TEAM LEADER		QA						

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64880 PPPL NCSX PVVS INSPECTION PLAN

		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: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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  .248" Profile Tolerance (+.188/-.060") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

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**INSPECTION DATA CHECKLIST**

64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:40 Op:150

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			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 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			RESULTS		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**

*		{g  ,268"} 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: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 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 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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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

	AND THROUGH COMPLETION								
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Workorder: 64880/1-0 Sub:40 Op:180

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
*		Ⓞ  ,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 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 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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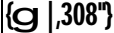
64880 PPPL NCSX PVVS INSPECTION PLAN

		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
*		  ,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 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 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: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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		   .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
*		CWI / TEAM LEADER VERIFY SHIELDING GAS AND PURGE GAS COMPLIANCE		QA						

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64880 PPPL NCSX PVVS INSPECTION PLAN

		PRIOR TO OPERATION START AND THROUGH COMPLETION							
*		CWI / TEAM LEADER VERIFY WELD FILLER MATERIAL COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
*		CWI / TEAM LEADER VERIFY WELDER QUALIFICATIONS COMPLIANCE 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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		<b>(g  .328")</b> Profile Tolerance (+.188/-.140") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		<b>(#  .125  p48")</b>	SMX	QA						

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**INSPECTION DATA CHECKLIST**

64880 PPPL NCSX PVVS INSPECTION PLAN

Workorder: 64880/1-0 Sub:40 Op:250

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
*		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
*		<b>(g  ,348<sup>m</sup>)</b> Profile Tolerance (+.188/-.160") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		<b>(#  .150 p48<sup>m</sup>)</b>	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.**

Drawing ID: SE121-001P Rev: 0			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 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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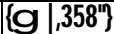

**64880 PPPL NCSX PVVS INSPECTION PLAN**

*		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:280**

**Revision: 01/16/04 9:07**

**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
*		  .358" Profile Tolerance (+.188/-.170") (within approximately 6" of port attachment point)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		  .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 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 COMPLIANCE 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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		<b>{g  ,368}</b> Profile Tolerance (+.188/-.160") (within approximately 6" of port attachment po t)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						
		<b>{#  .150 p48}</b>	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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*			VISUAL INSPECTION	MFG						

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64880 PPPL NCSX PVVS INSPECTION PLAN

	Verify Panel Joint Alignment Weld Seam # 4-5 (.02" Max)		CWI						
*	Verify Panel / Rest Stop Position Panel #4 (0 - .09" Gap)	FEELER GAGE	MFG						
*	Verify Panel / Rest Stop Position Panel Sub-Set #2-5 (0 - .09" 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 VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						

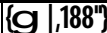
Workorder: 64880/1-0 Sub:41 Op:20

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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		   .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 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 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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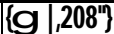
64880 PPPL NCSX PVVS INSPECTION PLAN

*		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION		QA					
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Workorder: 64880/1-0 Sub:41 Op:40

Revision:

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

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

Drawing ID: SE121-001P Rev: 0			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 COMPLI PRIOR TO OPERATION START AND THROUGH COMPLETION		QA						
*		CWI / TEAM LEADER VERIFY PURGE DAM MATERIAL COMPLIA		QA						

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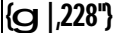
64880 PPPL NCSX PVVS INSPECTION PLAN

		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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  .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:41 Op:70

Revision: 01/12/04 16:34

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

Drawing ID: SE121-001P Rev: 0			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						
*				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							
*		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			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  ,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:41 Op:90

Revision: 01/12/04 16:35

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

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

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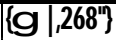
64880 PPPL NCSX PVVS INSPECTION PLAN

*		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:100

Revision:

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

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

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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

Record range (high / low)									
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Workorder: 64880/1-0 Sub:41 Op:110

Revision: 01/12/04 16:35

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

Drawing ID: SE121-001P Rev: 0		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 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			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:41 Op:130

Revision: 01/12/04 16:37

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

Drawing ID: SE121-001P Rev: 0			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 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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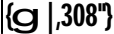
**64880 PPPL NCSX PVVS INSPECTION PLAN**

		VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION							
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Workorder: 64880/1-0 Sub:41 Op:140

Revision:

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  ,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 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 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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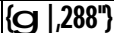
64880 PPPL NCSX PVVS INSPECTION PLAN

*		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:160

Revision:

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		   .288" 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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 1-3 (.02" Max)	VISUAL INSPECTION	MFG  CWI						
*		Verify Panel / Rest Stop Position Panel #1 (0 - .09" Gap)	FEELER GAGE	MFG						
*		Verify Panel / Rest Stop Position	FEELER GAGE	MFG						

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64880 PPPL NCSX PVVS INSPECTION PLAN

		Panel #3 (0 - .09" Gap)							
*		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:

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		   .188" Upper Half Of Bilateral Tolerance (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)								
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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 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 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 INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	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:43 Op:50

Revision: 01/12/04 16:39

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			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 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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64880 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
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Workorder: 64880/1-0 Sub:43 Op:60

Revision: 01/07/04 17:47

Part: - - PANEL SUB-SET 1,3

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

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64880 PPPL NCSX PVVS INSPECTION PLAN

		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

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

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64880 PPPL NCSX PVVS INSPECTION PLAN

		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			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		<b>g  ,268"</b> 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:43 Op:110

Revision: 01/12/04 16:40

Part: - - PANEL SUB-SET 1,3

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						

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**64880 PPPL NCSX PVVS INSPECTION PLAN**

		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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  .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

Part: - - PANEL SUB-SET 1,3

Drawing ID: SE121-001P Rev: 0			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 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

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
*		<b>g  ,308"</b> 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:43 Op:150

Revision: 01/12/04 16:41

**Part: - - PANEL SUB-SET 1,3**

Drawing ID: SE121-001P Rev: 0			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 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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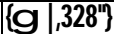
**64880 PPPL NCSX PVVS INSPECTION PLAN**

	PRIOR TO OPERATION START AND THROUGH COMPLETION								
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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: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		   .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:45 Op:10

Revision: 01/12/04 16:26

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

Drawing ID: SE121-001P Rev: 0			INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY		
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		Verify Panel Joint Alignment Weld Seam # 2-5 (.02" Max)	VISUAL INSPECTION	MFG						
*		Verify Panel / Rest Stop Position Panel #2 (0 - .09" Gap)	FEELER GAGE	MFG						
*		Verify Panel / Rest Stop Position Panel #5 (0 - .09" 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			
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: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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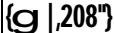
64880 PPPL NCSX PVVS INSPECTION PLAN

SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		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:45 Op:40

Revision:

Part: - - PANEL SUB-SET 2-5

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

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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

	Magnetic Permeability 1.01 Max. Record range (high / low)								
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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 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 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:60

Revision:

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64880 PPPL NCSX PVVS INSPECTION PLAN

Part: - - PANEL SUB-SET 2-5

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  ,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 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 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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64880 PPPL NCSX PVVS INSPECTION PLAN

		CWI / TEAM LEADER VERIFY PARAMETER COMPLIANCE PRIOR TO OPERATION START AND THROUGH COMPLETION								
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Workorder: 64880/1-0 Sub:45 Op:80

Revision:

Part: - - PANEL SUB-SET 2-5

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

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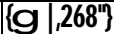
64880 PPPL NCSX PVVS INSPECTION PLAN

		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:45 Op:100

Revision:

Part: - - PANEL SUB-SET 2-5

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

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64880 PPPL NCSX PVVS INSPECTION PLAN

		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:45 Op:120

Revision:

Part: - - PANEL SUB-SET 2-5

Drawing ID: SE121-001P Rev: 0		INSPECTION INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		<b>g  ,288"</b> 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			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*				QA						

NOTE: the recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, title 18, chapter 47.


64880 PPPL NCSX PVVS INSPECTION PLAN

		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 INSTRUCTIONS			RESULTS		INSPECTED BY			
SHEET	ZONE	CHARACTERISTIC	GAGE/EQUIP	BY	SAMPLE	SER#	DATA/REMARKS	INSP	VERFD	AUDIT
*		  .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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INSPECTION DATA CHECKLIST

64880 PPPL NCSX PVVS INSPECTION PLAN

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 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 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		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  ,328") Profile Tolerance (+.188/-.140") (tack welded vessel)	SMX	QA						
*		Magnetic Permeability 1.01 Max. Record range (high / low)	PERMEABILITY GAG	QA						

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