

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5111

COGNIZANT INDIVIDUAL: Paul Goranson	
ECN TITLE: Weld Prep on Port Extensions	
ASSOCIATED ECP: None	
CC/WP/Job: 9450-1***-1203	AREA OR PROJECT: NCSX

LIMITATION OF SCOPE - NOTE: A Work Planning Form is NOT required if the total change to be accomplished (ENG-032):

- Is not large or complex or does not represent a new installation into a usable space
- Does not have a significant ES&H impact
- Does not involve tritium or other radioactive contaminated or activated equipment
- Does not impact multiple projects, systems, or groups

OR does not change the scope or intent of the original design.

Responsible Line Manager CONCURRENCE: _____
 (Signature indicates that no Work Planning form is required.)

If non-concurrence or associated with a work planning form, enter the WP Number:

DRAWING(S) AFFECTED NUMBER:	NEW Revision	TITLE
SE120-003	See RLM Comment	Vacuum Vessel Period Assembly and Removed Port Extensions

<p>DESCRIPTION OF CHANGE: (State Drawing No., Zone/Group, or List Attachments)</p> <p>Add NOTE to SE120-003 Sheet 3: Weld prep detail for Port 4 shall be bevel the stub only 30-40 degrees and keep the port extension square.</p> <p>Weld prep detail for the Dome VVSA Lot 1 shall be a 60 included angle v-groove and Lot 2 and 3 shall be a 40 degree included angle v-groove (with an approximate 1/16" root opening)</p> <p>RFD-12-019R1 approved this deviation.</p>
--

PPPL ENGINEERING CHANGE NOTICE (ECN) ECN # 5111

REASON FOR CHANGE:

Required for proper function. Provides easier access and enough width at the face to easily get full penetration and not provide an excessive amount of inter-passes to fill.

ENGINEERING CHANGE PROPOSAL: N/A

DATE: 4/17/2006

COGNIZANT INDIVIDUAL MAKING THE CHANGE:

RESONSIBLE LINE MANAGER:

RLM Comments: This ECN will NOT be immediately incorporated. Rather a stamp will be placed on this drawing as Rev 1-a to indicate that this ECN is outstanding.