23 A solid shape is made by removing a hemisphere, shown shaded, from a cone as shown in the diagram.

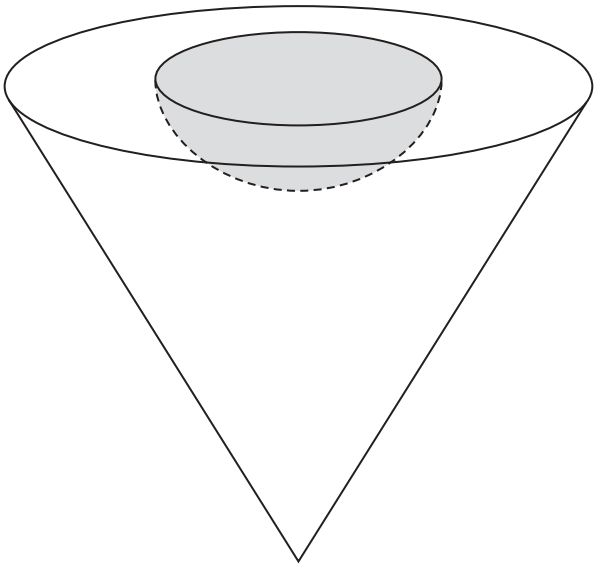


Diagram **NOT** accurately drawn

The radius of the hemisphere is $2x$ cm
The radius of the base of the cone is $5x$ cm
The vertical height of the cone is $6x$ cm

The volume of the solid shape is 6948π cm^3

Work out the **total** surface area of the solid hemisphere that has been removed from the cone.
Give your answer correct to the nearest integer.

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..... cm^2

(Total for Question 23 is 5 marks)