DWG. M20-568766 WESTINGHOUSE SECTION

ITEM	Description & Service	SPECIFICATIONS MATERIAL	PIPE	O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relieve	Radiography	Bechtel Welding Procedure	Rev.	Date	WELD PREPARATION SEE NOTES	CODES ASME BOILER	PRESSURE PIPING B31.1	NUCLEAR CASES	REMARKS	LINE NO.
	REACTOR COOLANT LOOP.	-	2501R	36.250 —	2.813	ER316 & E316	N.R.	N.R. ⚠1	100%	P8-AT-g	1	3-30-65	(F)	SECT. I	-	-	MAT'LS: SA-376-TP-316; A-182-F316; A403-WP-316; SA-351-CF-8M.	5001
		-	2501R	34.125 —	2.563				100%				(P)	SECT. I	-	-		5005
		-	2501R	32.500 —	2.500				100%				(P)	SECT. I	-	-		5001
		A312,TP-316	2501R	8.625 SCH.160	0.906				100%				(G)	-	SECT. I	N-1-(b)		5002
		A312,TP-316	2501R	2.375 SCH.160	0.343				10%	P8-A	1	3-30-65	(E)	-				5003
		A312,TP-304	151R	1.315 SCH.10S	0.109	E308			10%				(E)	-				5041
		A312,TP-316	2501R	1.050 SCH.160	0.218	E316			10%				(E)	-				5001
		A312,TP-304	151R	0.840 SCH.10S	0.083	E308			-				(E)	-				5048
	LEAK DETECTION & REFUELING LEVEL MEASUREMENT.	A312,TP-304	151R	2.375 SCH.10S	0.109	E308			10%	P8-A	1	3-30-65	(E)	-	SECT. I	N-1 (b)		5019
		A312,TP-316	2501R	1.315 SCH.160	0.250	E316			10%				(E)	-				5018
		A312,TP-304	151R	1.315 SCH.10S	0.109	E308			10%				(E)	-				5022
		A312,TP-316	2501R	1.050 SCH.160	0.218	E316			10%				(E)	-				5022
		A312,TP-304	151R	0.840 SCH.10S	0.083	E308			-				(E)	-				5020
		A213 S.S.	2505R											-			S.S. TUBING SMLS. A213 OR A268	5013
	PRESSURIZER	A312,TP-316	2501R	10.750 SCH.160	1.125	ER316 & E316			100%	P8-AT-g	1	3-30-65	(C)	SECT. I	-	-		5013
		A312,TP-304	601R	10.750 SCH.40S	0.365	ER308 & E308			100%				(Q)	-	SECT. I	N-1-(b)		5035
		A312,TP-316	2501R	3.500 SCH.160	0.438	ER316 & E316			100%				(C)	-				5011
		A312,TP-316	2501R	2.375 SCH.160	0.343	E316			10%	P8-A	1	3-30-65	(E)	-				5034
		A312,TP-304	601R	2.375 SCH.10S	0.109	E308			10%				(E)	-				5035
		A312,TP-316	2501R	1.050 SCH.160	0.218	E316			10%				(E)	-				5033
		A-106-B	602R	10.750 SCH.40	0.365	GAGS & F7018			100%	P1-AT-LH	0	4-16-65	(2)	-				5035
		A-106-B	602R	6.626 SCH.40	0.280								(2)					5028
		A-106-B	602R	4.500 SCH.40	0.237				100%				(2)					5035
		A-106-A	602R	0.840 SCH.40	0.109	E6010			-	P1-A-C	12	5-17-65	(3)	-				-
	PRESSURIZER RELIEF TANK.	A312,TP-304	151R	2.375 SCH.10S	0.109	E308			10%	P8-A	1	3-30-65	(E)	-	SECT. I	N-1 (b)		715
		A312,TP-304	151R	0.840 SCH.10S	0.083	E308			10%	P8-A	1	3-30-65	(E)	-				-
		A-53-A	152R	1.050 SCH.40	0.113	E6010			-	P1-A-C	12	5-17-65	(3)	-				5039

* WHERE REFUELING WATER PIPING IS USED FOR SAFETY INJECTION WATER RECIRCULATION, 100% RADIOGRAPH IS REQ'D FOR THE PORTION OUTSIDE OF THE SPHERE & RANDOM 10% RADIOGRAPH IS REQ'D FOR THE PORTION INSIDE OF THE SPHERE.

N.R. = NOT REQUIRED.

NOTES -

FOR NOTES 1 THRU 7 SEE SHEET 6 OF 21 SHEETS.

THE ROOT PASS ALL (W) SPECIFICATION "R" BUTT WELDS AND ALL FINISHED (W) SPECIFICATION "N" "R" WELDS ARE TO BE GIVEN THE (W) REQUIRED LIQUID PENETRANT INSPECTION. EXCLUDE ROOT PASS WHEN FINAL ONLY.

(W) FABRICATION SPECIFICATIONS DETAIL WELDING AND INSPECTION REQUIREMENT NOS 676239 & 676171.

FOR FIELD WORK WHERE FIT-UP, WELDING AND INSPECTION ARE INVOLVED.

REFERENCE (W) EQUIPMENT SPECIFICATIONS

NOTES: WESTINGHOUSE DRAWING 498B-732

(A) STAINLESS STEEL - SQUARE ENDS FOR WALL THICKNESS LESS THAN 1/8" - 2½" AND UP.
(B) " " - FOR WALL THICKNESS 1/8" TO LESS THAN 1/4" - " " "
(C) " " - FOR WALL THICKNESS 1/4" TO 1 3/8" - " " "
(D) " " - FOR WALL THICKNESS GREATER THAN 1 3/8" - " " "
(E) " - SOCKET WELD - 2" AND UNDER.
(F) (W) DRAWING ED SK-301954

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.			
△			
△			
△			
⚠1	5-9-66	GEN. REV.	O'BRIEN PACE MC DONALD WELDS
⚠2	11-1-66	ISSUED FOR CONST.	O'BRIEN PACE MC DONALD WELDS

BECHTEL

JOB NO. 3246
DRAWING NO. 3246-M-1585
REV. 1
SHEET 1 OF 21

INDEXED

N-1585

FORM 84, 4-64

17X

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TI APERTURE CARD