

Description & Service ITEM	SPECIFICATIONS		O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relieve	Radio-graphy	Bechtel Welding		WELD END PREPARATION SEE NOTES	CODES			REMARKS	LINE NO.
	MATERIAL	PIPE							Procedure	Rev. Date		ASME BOILER	PRESSURE PIPING	NUCLEAR CASES		
COMPONENT COOLING HEAT EXCHANGER TO RESIDUAL HEAT EXCHANGER.	A-53-A	152	14.000 SCH.40	0.438	E 7018	N.R.	N.R.	-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	-	3056
	A-53-A	152	10.750 SCH.40	0.365				-			(2)	-				3056
	A-53-A	152	8.625 SCH.40	0.322				-			(2)	-				3090
	A-53-A	152	1.315 SCH.40	0.133	E 6010			-	PI-A-C	12 5-17-65	(3)	-				3035
RESIDUAL HEAT EXCHANGER TO REACTOR LOOP "A"	A312,TP-316	2501R	6.625 SCH.160	0.718	ER316 & E316			100%	PR-AT-g	1 3-30-65	(C)	-	SECT. 1	N-1 (b)		3001
	A312,TP-304	601R	6.625 SCH.405	0.280	ER308 & E308			100%			(C)	-				3201
	A312,TP-304	601R	4.500 SCH.405	0.237	ER308 & E308			100%			(B)	-				3003
	A312,TP-304	601R	2.375 SCH.405	0.154	E 308			10%	PR-A	1 3-30-65	(B)	-				3006
	A312,TP-304	601R	1.050 SCH.405	0.113				10%			(E)	-				3026
	A312,TP-304	601R	0.840 SCH.405	0.109				-			(E)	-				-
REACTOR LOOP "C" TO RESIDUAL HEAT REMOVAL PUMPS.	A312,TP-316	2501R	8.625 SCH.160	0.906	ER316 & E316			100%	PR-AT-g	1 3-30-65	(C)	-	SECT. 1	N-1 (b)		5002
	A312,TP-304	601R	8.625 SCH.405	0.322	ER308 & E308			100%			(C)	-				5002
	A312,TP-304	601R	6.625 SCH.405	0.280	ER308 & E308			100%			(C)	-				5002
RESIDUAL HEAT REMOVAL PUMPS TO RESIDUAL HEAT EXCHANGER.	A312,TP-304	601R	6.625 SCH.405	0.280	ER308 & E308			100%	PR-AT-g	1 3-30-65	(C)	-	SECT. 1	N-1 (b)		3015
	A312,TP-304	601R	2.375 SCH.405	0.154	E 308			10%	PR-A	1 3-30-65	(B)	-				3071
	A312,TP-304	601R	1.050 SCH.405	0.113				10%			(B)	-				3021
	A312,TP-304	601R	0.840 SCH.405	0.109				-			(E)	-				-
	A-106-B	HH	1.900 SCH.40	0.145	E 6010			-	PI-A-C	12 5-17-65	(3)	-				3099
RESIDUAL HEAT EXCHANGERS TO COMPONENT COOLING PUMPS.	A-53-A	152	14.000 SCH.40	0.438	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-		3037
	A-53-A	152	12.750 SCH.40	0.406				-			(2)	-				3040
	A-53-A	152	8.625 SCH.40	0.322				-			(2)	-				3049
	A-53-A	152	1.315 SCH.40	0.133	E 6010			-	PI-A-C	12 5-17-65	(3)	-				3035
COMPONENT COOLING PUMPS TO COMPONENT COOLING HEAT EXCHANGERS.	A-53-A	152	14.000 SCH.40	0.438	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-		3048
	A-53-A	152	10.750 SCH.40	0.365				-			(2)	-				3053
	A-53-A	152	8.625 SCH.40	0.322				-			(2)	-				3049
	A-53-A	152	1.900 SCH.40	0.145	E 6010			-	PI-A-C	12 5-17-65	(3)	-				3058
	A-53-A	152	1.315 SCH.40	0.133				-			(3)	-				-
	A-53-A	152	0.840 SCH.40	0.109				-			(3)	-				-

FORM 84, 4-64

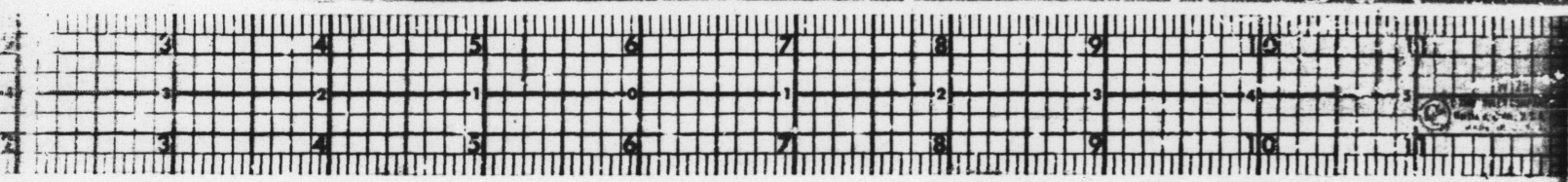
NOTES:

SAN ONOFRE NUCLEAR GEN. STATION
SCHEDULE OF FIELD WELDING PROCEDURES

△	
△	
△	
△	
△	
△	

JOB NO. 3246
DRAWING NO. 3246-N-1585
SHEET 3 OF 21
REV. 0

ISSUED FOR CONST.



17X

8606300200

TI APERTURE CARD