

ITEM	Description & Service	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 B31	NUCLEAR CASES			
	FEEDWATER PURGE LINE TO REFUELING STORAGE TANK.	A312, TP-316	1501R	2.375 SCH. 80S	0.218	E 316	NR	NR	10%	PR-A	1 3-30-65	(B)	-	SECT. 1	N-1(b)		6009	
		A312, TP-304	151R	2.375 SCH. 10S	0.109	E 308			10%			(B)	-				6009	
		A312, TP-316	1501R	1.050 SCH. 80S	0.154	E 316			10%			(B)	-				6023	
	FEEDWATER PUMP RECIRCULATION.	A-106-B	1502N	4.500 SCH. 160	0.531	E 7018			10%	PI-A-Lh	1 3-30-65	(B)	-	SECT. 1			6020	
		A-106-B	1502N	3.500 SCH. 160	0.438	E 7018			10%	PI-A-Lh	11 2-23-65	(B)	-				6021	
		A312, TP-316	1502N	3.500 SCH. 80S	0.300	ER316 & E316			10%	PR-AT-g	1 3-30-65	(C)	-		N-1(b)		6021	
	CHARGING LINES TO REACTOR LOOP IN-SIDE SPHERE.	A312, TP-316	2501-R	2.375 SCH. 160	0.343	E 316			10%	PR-A	1 3-30-65	(E)	-	SECT. 1	N-1(b)		2091	
	REFUELING WATER RETURN LINE TO CHARGING PUMPS.	A312, TP-304	151R	6.625 SCH. 10S	0.120	ER 308			100%	PR-T-g	1 3-30-65	(A)	-	SECT. 1	N-1(b)		6015	
	M20-568770																	
	SAMPLING SYSTEM.	A312, TP-304	151R	1.315 SCH. 10S	0.109	E 308			10%	PR-A	1 3-30-65	(E)	-	SECT. 1	N-1(b)		4008	
		A312, TP-316	2501R	1.050 SCH. 160	0.218	E 316			10%			(E)	-				5029	
		A312, TP-304	601R	0.804 SCH. 40S	0.109	E 308			-			(E)	-				3008	
		A312, TP-304	151R	0.804 SCH. 10S	0.083	E 308			-			(E)	-				2079	
		A213, TUBING	250-R	0.500	0.065				-								S.S. SMLS. TUBING A213 OR A269. 4007	
		A213, TUBING	250 5/8	0.375	0.065				-								" " " " " 4007	

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

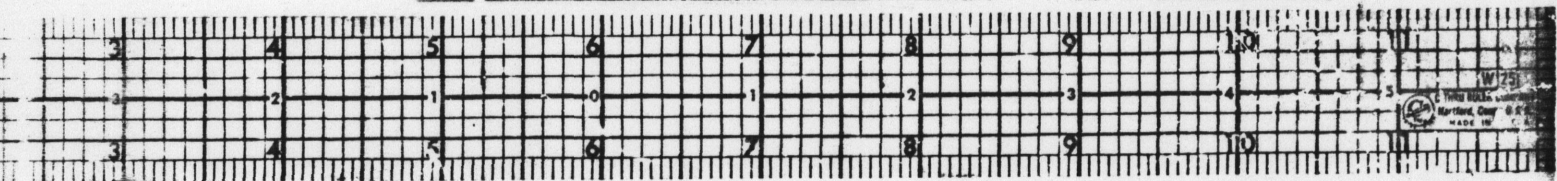
SCHEDULE OF FIELD WELDING PROCEDURES

REV.	△				
	△				
	△	6-3-66 REV. SIS SPEC.	DWP	W.A.B.	DWP
	△	6-3-66 GEN. REV.	J.H.	W.C.S.	M.E.
△	7-1-66 ISSUED FOR CONST.	J.L.	J.S.		

JOB NO. 3246

DRAWING NO. 3246-N-1585 REV. 2

SHEET 5 OF 21



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MTI APERTURE CARD