M20-568773 BECHTEL SECTION

ITEM	Description & Service	SPECIFICATIONS MATERIAL	PIPE	O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relieve	Radiography	Bechtel Welding Procedure	Rev.	Date	WELD END PREPARATION SEE NOTES	CODES ASME BOILER	PRESSURE PIPING B31.1	NUCLEAR CASES	REMARKS	LINE NO.
	MAIN STEAM	A-106-B	EG	24.00 SCH.60	0.968	GAGS & E7018	N.R.	YES	100%	PI-AT-Lh-f	3	2-23-65	① ITEM # 1	Sect. 1	–	–		1
		A-106-B	EG	20.00 SCH.60	0.812	GAGS & E7018		YES	100%	PI-AT-Lh-f	3	2-23-65	① ITEM # 2	Sect. 1	–	–		4
		A-53-B	HH	14.00 STD.	0.375	E7018		N.R.	–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		60
		A-106-B	EGX	12.75 SCH.80	0.687				–				②	–	Sect. 1	–		13
		A-106-B	EG	10.75 SCH.60	0.500				10%				②	Sect. 1	–	–		18
		A-53-B	HH	10.75 STD.	0.365				–				②	–	Sect. 1	–		22
		A-106-B	EGX	8.625 SCH.60	0.406				–				②	–	Sect. 1	–		15
		A-106-B	EG	8.625 SCH.40	0.322				10%				②	Sect. 1	–	–		15
		A-106-B	EG	6.625 SCH.160	0.718	GAGS & E7018			ASME PORTION 10%	PI-AT-Lh-f	3	2-23-65	① ITEM # 4	Sect. 1	Sect. 1	–	ASA B31.1 SECT. I - DNSTM OF 1ST VALVE	50
		A-106-B	EG	6.625 SCH.120	0.562	GAGS & E7018			ASME PORTION 10%	PI-AT-Lh-f	3	2-23-66	① ITEM # 5	Sect. 1	Sect. 1	–	ASA B31.1 SECT. I - DNSTM OF 1ST VALVE	50
		A-106-B	EGX	6.625 SCH.80	0.432	E7018			–	PI-A-Lh	11	2-23-66	②	–	Sect. 1	–		13
		A-106-B	EG	6.625 SCH.40	0.280			⚠	ASME PORTION 10%				②	Sect. 1	Sect. 1	–	ASA B31.1 SECT. I - DNSTM OF 1ST VALVE	19
		A-106-B	EG	4.50 SCH.40	0.232				10%				②	Sect. 1	–	–		15
		A-106-B	EG	3.50 SCH.40	0.216				ASME PORTION 10%				②	Sect. 1	Sect. 1	–	ASA B31.1 SECT. I - DNSTM OF 1ST VALVE	9
		A-106-B	EG	2.375 SCH.80	0.218	E6010			–	PI-A-C	12	5-17-65	③	–	Sect. 1	–		8
		A-106-B	EG	1.315 SCH.40	0.133	E6010			–	PI-A-C	12	5-17-65	③	–	Sect. 1	–		45,10
	TURBINE EXTRACTION LINE.	A-53-B	HH	24.00 STD.	0.375	E7018			–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		33
		A-53-B	HH	20.00 STD.	0.375				–				②	–	Sect. 1	–		29
		A-53-B	HH	18.00 STD.	0.375				–				②	–	Sect. 1	–		25
		A-53-B	HH	16.00 SCH.40	0.500				–				②	–	Sect. 1	–		16
		A-53-B	HH	16.00 STD.	0.375				–				②	–	Sect. 1	–		39
		A-53-B	GG	10.75 SCH.40	0.365				–				②	–	Sect. 1	–		22
	REHEATER TO HEATER	A-53-B	HHX	10.75 SCH.60	0.500	E7018			–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		128
		A-53-B	HH	8.625 SCH.40	0.322	E7018			–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		122
		A-106-B	EG	1.900 SCH.40	0.145	E6010			–	PI-A-C	12	5-17-65	③	–	Sect. 1	–		194
	TO DRAIN RECEIVER	A-106-B	EG	4.500 SCH.40	0.237	E7018			–	PI-A-Lh	11	2-23-66	②	–	Sect. 1	–		120
		A-106-B	EG	1.315 SCH.40	0.133	E7018			–	PI-A-Lh	11	2-23-66	③	–	Sect. 1	–		191
	TO CONDENSER	A-53-B	HHX	10.750 SCH.60	0.500				–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		204
		A-53-B	HH	8.625 SCH.40	0.322				–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		206
	DRAIN RECEIVER TO H.P. HEATER.	A-106-B	EGX	8.625 SCH.60	0.406	E7018			–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		104
		A-106-B	EG	6.625 SCH.40	0.220	E7018			–	PI-A-Lh	11	2-23-65	②	–	Sect. 1	–		102

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NOTES:
① FIRST PASS INERT GAS WITH NO RINGS-END PREPARATION DWG. 3246-M-18629 ITEM
② BUTT WELD-37½° BEVEL WITH RING.
③ SOCKET WELD-2" AND DOWN.
④ INERT GAS WITH NO RINGS-SCHEDULE 10-STAINLESS STEEL.
⑤ INERT GAS WITH RING-2½" AND UP-STAINLESS STEEL.
⑥ DOUBLE BEVEL FLANGE TO PIPE WELD-FULL PENETRATION TYPE.
⑦ GROOVE WELD. CATAGORY C
⑧ GROOVE WELD WITH FILLET CATAGORY D.

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.				
△				
△				
△				
△	5-12-66	GEN. REV.	DWN	HE
△	4-1-66	ISSUED FOR CONST.	DWN CHK ENGR	HE J.S.

BECHTEL

JOB NO. 3246
DRAWING NO. 3246-N-1585 REV. 0
SHEET 8 OF 21

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