

M20-568774

BECHTEL SECTION

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 B31J	NUCLEAR CASES		
H.P. AND L.P. HEATERS TO CONDENSER.	A-53-B	HH	8.625 SCH. 40	0.406	E 7018	NR	NR	-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	156	
	A-106-B	HH	1.900 SCH. 40	0.145	E 6010			-	PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	194	
	A-106-B	HH	1.315 SCH. 40	0.133				-			(3)	-	SECT. 1	-		
	A-106-B	GG	1.050 SCH. 40	0.113				-			(3)	-	SECT. 1	-	238	
HEATER TO HEATER	A-53-B	HH	10.75 SCH. 40	0.500	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	112	
	A-53-B	GG	8.625 SCH. 40	0.406				-			(2)	-	SECT. 1	-	108	
	A-53-B	HH	8.625 SCH. 40	0.322				-			(2)	-	SECT. 1	-	109	
	A-53-B	GG	6.625 SCH. 40	0.280				-			(2)	-	SECT. 1	-	106	
	A-53-B	HH	4.500 SCH. 40	0.297				-			(2)	-	SECT. 1	-	186	
	A-106-B	HH	2.375 SCH. 40	0.154	E 6010			-	PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	208	
HEATER TO DRAIN PUMPS.	A-53-B	HH	14.000 STD.	0.375	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	114	
HEATER TO CONDENSER	A-53-B	HH	16.000 SCH. 40	0.500	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	132	
	A-53-B	HH	14.000 STD.	0.375	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	130	
HEATER TO BLOWDOWN TANK.	A-53-B	HH	12.750 STD.	0.375	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	182	
	A-53-B	HH	10.750 STD.	0.363				-			(2)	-	SECT. 1	-	181	
	A-53-B	HH	6.625 SCH. 40	0.280				-			(2)	-	SECT. 1	-	184	
	A-53-B	HH	4.500 SCH. 40	0.297				-			(2)	-	SECT. 1	-	184	
BLOWDOWN TANK TO VENT STACK.	A-53-B	HH	16.000 STD.	0.375	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	180	
DRAIN PUMPS TO HEATERS	A-53-B	GG	10.750 STD.	0.365	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	116	
	A-53-B	GG	3.500 SCH. 40	0.214	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	236	
HEATER TO FLASH EVAPORATOR	A-106-B	HH	2.375 SCH. 40	0.154	E 6010			-	PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	212	
CONDENSER TO CONDENSER.	A-53-B	HH	24.000 STD.	0.375	E 7018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	159	

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

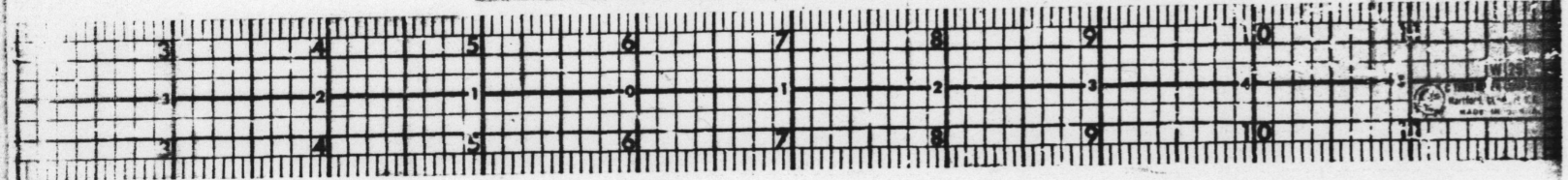
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DRAWING NO.	REV.
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APERTURE CARD