

ITEM	SPECIFICATIONS		O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relieva	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		
EVAPORATOR TO CONDENSER.	A-53-B	HH	10.75 SCH.60	0.500	E 7018	NR	NR	-	PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	146	
	A-53-B	HH	10.75 SCH.40	0.375							(2)	-	SECT. 1	-	144	
	A-53-B	HH	8.625 SCH.60	0.406							(2)	-	SECT. 1	-	150	
	A-53-B	HH	8.625 SCH.40	0.322							(2)	-	SECT. 1	-	138	
	A-53-B	HH	6.625 SCH.80	0.432							(2)	-	SECT. 1	-	146	
	A-53-B	HH	6.625 SCH.40	0.280							(2)	-	SECT. 1	-	140	
	A-106-B	HH	2.375 SCH.40	0.216	E6010				PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	216	
	A-106-B	HH	1.315 SCH.40	0.133							(3)	-	SECT. 1	-	218	
A-106-B	HH	1.050 SCH.40	0.113							(3)	-	SECT. 1	-	240		
CONDENSER TO AFTER CONDENSER.	A-53-B	HH	6.625 SCH.40	0.280	E 7018				PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	168	
AFTER CONDENSER TO VENT STACK.	A-53-B	HH	8.625 SCH.40	0.322	E 7018				PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	160	
	A-53-B	HH	6.625 SCH.40	0.280							(2)	-	SECT. 1	-	160	
	A-53-B	HH	3.500 SCH.40	0.216							(2)	-	SECT. 1	-	160	
G.S. STEAM CONDENSER TO CONDENSER.	A-106-B	HH	1.900 SCH.40	0.185	E6010				PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	154	
AFTER CONDENSER TO CONDENSER.	A-106-B	HH	2.375 SCH.40	0.185	E6010				PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	237	
	A-106-B	HH	1.315 SCH.40	0.133	E6010				PI-A-C	12 5-17-65	(3)	-	SECT. 1	-	230	
M20-568775																
SUMP PUMP	A-74 B&S LINE		8.625	-									DRILLED PLG	-	SECT. 1	-
	A-21.11 CEMENT		8.625	-									DRILLED PLG	-	SECT. 1	-
	A-21.11 CEMENT		6.625	-									DRILLED PLG	-	SECT. 1	-
	A-21.11 CEMENT		4.500	-									DRILLED PLG	-	SECT. 1	-
	A-53-B	HH	4.500 SCH.40	0.237	E 7018				PI-A-Lh	11 2-23-65	(2)	-	SECT. 1	-	446	

FORM 84, 4-64

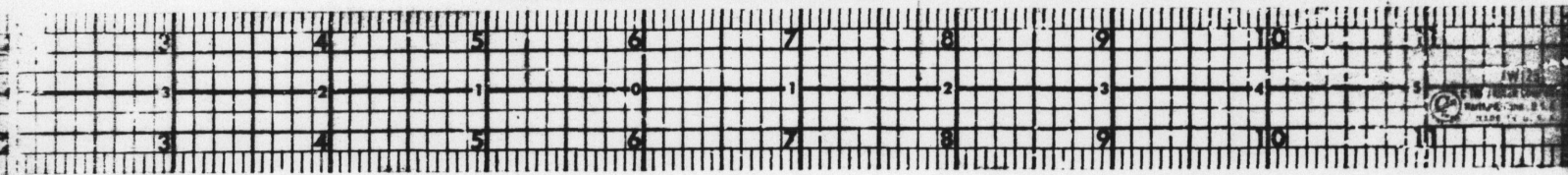
NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.	△			
	△			
	△			
	△	5/14	GEN. REV.	
	△	7-14	ISSUED FOR CONST.	

JOB NO. 3246
 DRAWING NO. 3246-N-1585
 REV. 1
 SHEET 10 OF 21
 BECHTEL INDEXED



17X

8606300226

MTI APERTURE CARD