

M20-568775

BECHTEL SECTION

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 B31J	NUCLEAR CASES			
	CIRCULATING WATER SYSTEM.	CONCRETE	AWWA	90.000 C-302	-		NR	NR										
		CONCRETE	AWWA	72.000 C-302	-													
		CONCRETE	AWWA	20.000 C-302	-													
		A-53-B	KP	24.000 STD.	0.375	E7018				PI-A-Lh	11	2-23-65	(2)		SECT. 1			408
		A-53-B	KP	20.000 STD.	0.375	E7018				PI-A-Lh	11	2-23-65	(2)		SECT. 1			408
	CONDENSER DISCHARGE	CONCRETE	AWWA	72.000 C-302	-													
		A-53-B	KP	4.500 SCH. 40	0.237	E7018				PI-A-Lh	11	2-23-65	(2)		SECT. 1			432
	FLASH EVAPORATOR RECIRCULATING SYSTEM.	A-53-B	HH	10.750 SCH. 40	0.375	E7018				PI-A-Lh	11	2-23-65	(2)		SECT. 1			
		A-53-B	HH	6.625 SCH. 40	0.250								(2)		SECT. 1			476
		A-53-B	HH	3.500 SCH. 40	0.216								(2)		SECT. 1			480
		A-106-B	HH	2.375 SCH. 40	0.154	E6010				PI-A-C	12	5-17-65	(3)		SECT. 1			428
		A312, TR304	HP	6.625 SCH. 103	0.134	ER308				PR-T-g	1	3-30-65	(3)		SECT. 1			428
		A312, TR304	HP	4.500 SCH. 103	0.120	ER308				PR-T-g	1	3-30-65	(3)		SECT. 1			419
		A312, TR304	HP	1.315 SCH. 103	0.109	E308				PR-A	1	3-30-65	(3)		SECT. 1			419
		B-42	KP3	4.500 -	0.134									BRAZED JT.	SECT. 1			420
		B-42	KP3	3.500 -	0.109									BRAZED JT.	SECT. 1			425
	B-42	KP3	2.875 -	0.075									BRAZED JT.	SECT. 1			425	
	B-42	KP3	1.315 -	0.065									BRAZED JT.	SECT. 1			421	
	SALT WATER SYSTEM	CONCRETE	AWWA	36.000 C-302	-													
		A-126-B	C.J.	20.000 -	-										SECT. 1			
		A-126-B	C.J.	12.750 -	-										SECT. 1			
		A-126-B	C.J.	3.625 -	-										SECT. 1			
		A-126-B	C.J.	6.625 -	-										SECT. 1			
		A-126-B	C.J.	3.500 -	-										SECT. 1			
		A-126-B	C.J.	1.900 -	-										SECT. 1			
		B-42	KP2	3.500 STD.	0.219										SECT. 1			430
		B-42	KP2	2.375 STD.	0.154										SECT. 1			430
		B-42	KP2	1.900 STD.	0.150										SECT. 1			467
	A-106-B	KN	1.315 SCH. 40	0.133	E6010				PI-A-C	12	5-17-65	(3)		SECT. 1			464	
	SERVICE WATER	A-53-B	KN	3.500 SCH. 40	0.216	E7018				PI-A-Lh	11	2-23-65	(2)		SECT. 1			815
		A-106-B	KN	2.375 SCH. 40	0.154	E6010				PI-A-C	12	5-17-65	(3)		SECT. 1			815
		A-106-B	KN	1.900 SCH. 40	0.133										SECT. 1			878
		A-106-B	KN	1.315 SCH. 40	0.133										SECT. 1			815
		A-106-B	KN	1.050 SCH. 40	0.113										SECT. 1			815
		A-106-B	KN	0.840 SCH. 40	0.109										SECT. 1			880

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

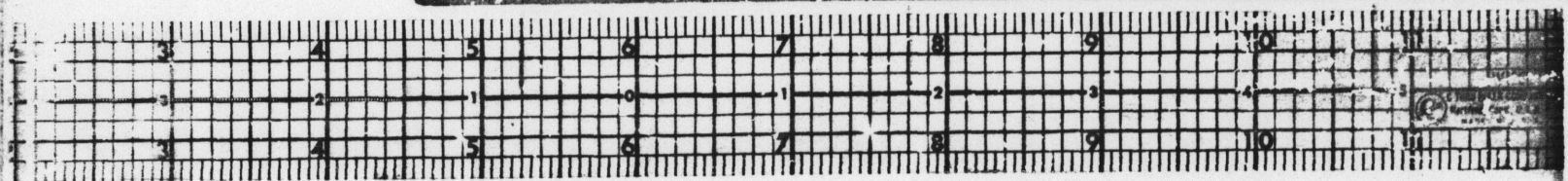
SCHEDULE OF FIELD WELDING PROCEDURES

REV.	△		
	△		
	△		
	△		
	△		

JOB NO. 3246
DRAWING NO. 3246-N-1585
SHEET 11 OF 21
REV. 0

BECHTEL INDEXED

ISSUED FOR CONST. 9/24/65



17X

9606300229

MT APERTURE CARD