

M20-568776

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		
	FLASH EVAPORATOR	A-21.4 CEMENT		4.500 -	-							BOLTED FLG.	-	SECT. 1	-		
	CONDENSATE TO STORAGE TANKS.	A-53-B	HH	4.500 SCH.40	0.237	E7018	NR	NR	-	PI-A-Lh	11	2-23-65	(2)	-	SECT. 1	-	719
		A312, TP-304	HP	4.500 SCH.103	0.120	ER308			-	PR-T-g	1	3-30-65	(3)	-	SECT. 1	-	710
		A312, TP-304	HP	3.500 SCH.103	0.120	ER308			-	PR-T-g	1	3-30-65	(3)	-	SECT. 1	-	700
		A312, TP-304	HP	2.375 SCH.103	0.109	E308			-	PR-A	1	3-30-65	(4)	-	SECT. 1	-	700
	REFUELING MAKE-UP WATER (FROM TANKS)	A-53-B	KN	18.000 STD.	0.375	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT. 1	-	740
		A-53-B	KN	16.000 STD.	0.375	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT. 1	-	754
		A312, TP-304	HP	14.000 SCH.103	0.250	ER308 E308			-	PR-A-T-g	1	3-30-65	(5)	-	SECT. 1	-	721
		A312, TP-304	HP	8.625 SCH.103	0.148	E5333			-	PR-T-g	1	3-30-65	(5)	-	SECT. 1	-	729
		A312, TP-304	HP	6.625 SCH.103	0.134				*				(5)	-	SECT. 1	-	734
		A312, TP-304	HP	4.500 SCH.103	0.120				*				(5)	-	SECT. 1	-	710
		A312, TP-304	HP	3.500 SCH.103	0.120				*				(5)	-	SECT. 1	-	711
		A312, TP-304	HP	2.375 SCH.103	0.109	E308			*	PR-A	1	3-30-65	(4)	-	SECT. 1	-	711
		A312, TP-304	HP	1.915 SCH.103	0.109				*				(4)	-	SECT. 1	-	2045
		A312, TP-304	HP	1.050 SCH.103	0.083				*				(4)	-	SECT. 1	-	862
		A312, TP-304	HP	4.500 SCH.103	0.120	ER308			*	PR-T-g	1	3-30-65	(5)	-	SECT. 1	-	736
		A312, TP-304	HP	8.625 SCH.103	0.198	ER308			*	PR-T-g	1	3-30-65	(5)	-	SECT. 1	-	728
		A312, TP-304	HP	2.375 SCH.103	0.109	E308			*	PR-A	1	3-30-65	(4)	-	SECT. 1	-	891
		A312, TP-304	HP	2.375 SCH.103	0.109	E7018			*	PI-A-Lh	11	2-23-65	(2)	-	SECT. 1	-	742
	TURBINE PLANT COOLERS WATER SYSTEM.	A-53-B	KN	16.000 STD.	0.375				-				(2)	-	SECT. 1	-	742
		A-53-B	KN	14.000 STD.	0.375				-				(2)	-	SECT. 1	-	742
		A-53-B	KN	12.000 STD.	0.375				-				(2)	-	SECT. 1	-	743
		A-53-B	KN	8.625 SCH.40	0.322				-				(2)	-	SECT. 1	-	767
		A-53-B	KN	6.625 SCH.40	0.280				-				(2)	-	SECT. 1	-	746
		A-53-B	KN	4.500 SCH.40	0.237				-				(2)	-	SECT. 1	-	773
		A-53-B	KN	3.500 SCH.40	0.216				-				(2)	-	SECT. 1	-	745
		A-106-B	KN	2.375 SCH.40	0.154	EG010			-	PI-A-C	12	5-17-65	(3)	-	SECT. 1	-	899
		A-106-B	KN	1.915 SCH.40	0.133				-				(3)	-	SECT. 1	-	798
		A-106-B	KN	1.900 SCH.40	0.145				-				(3)	-	SECT. 1	-	744
		A-106-B	KN	0.840 SCH.40	0.109				-			(3)	-	SECT. 1	-	744	
	FIRE PROTECTION SYSTEM.	A-53-B	KN	8.625 SCH.40	0.322	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT. 1	-	814
		A-53-B	KN	6.625 SCH.40	0.255				-				(2)	-	SECT. 1	-	814
		A-53-B	KN	4.500 SCH.40	0.237				-				(2)	-	SECT. 1	-	843
		A-53-B	KN	3.500 SCH.40	0.216				-				(2)	-	SECT. 1	-	842
		A-106-B	KN	2.375 SCH.40	0.154	EG010			-	PI-A-C	12	5-17-65	(3)	-	SECT. 1	-	844
	CONTAINMENT COOLING	A-53-B	KN	8.625 SCH.40	0.322	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT. 1	-	756
		A-53-B	KN	6.625 SCH.40	0.280				-				(2)	-	SECT. 1	-	756
		A-53-B	KN	4.500 SCH.40	0.237				-				(2)	-	SECT. 1	-	805
		A-53-B	KN	3.500 SCH.40	0.216				-				(2)	-	SECT. 1	-	801
		A-106-B	KN	1.900 SCH.40	0.145	EG010			-	PI-A-C	12	5-17-65	(3)	-	SECT. 1	-	892

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.	1								
2									
3									
4									
5									

JOB NO. 3246

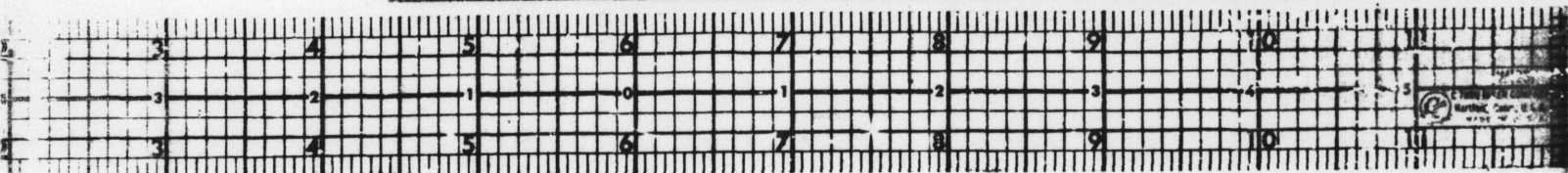
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REV. 0

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MT APERTURE CARD