

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			
	SERVICE WATER	A-53-B	KN	3.500 SCH.40	0.216	E7018	NR	NR	-	PI-A-LH	11 2-23-65	(2)	-	SECT.1	-		817	
		A-106-B	KN	1.900 SCH.40	0.145	E6010			-	PI-A-C	12 5-17-65	(3)	-	SECT.1	-		819	
		A-106-B	KN	1.315 SCH.40	0.133	E6010			-				(3)	-	SECT.1	-		730
	DOMESTIC WATER	A-120	HJ	3.500 SCH.40	0.216				-				SCR'D END	-	SECT.1	-		809
		A-120	HJ	2.875 SCH.40	0.203				-				SCR'D END	-	SECT.1	-		818
M20-568777																		
	CONDENSATE FROM PUMP DISCHARGE	A-106-B	44	1.900 SCH.40	0.145	E6010			-	PI-A-C	12 5-17-65	(3)	-	SECT.1	-		331	
		A-106-B	44	1.315 SCH.40	0.133				-				(3)	-	SECT.1	-		331
		A-106-B	44	1.050 SCH.40	0.113				-				(3)	-	SECT.1	-		328
	PHOSPHATE	A312,TP-304	HH5	1.900 SCH.103	0.109	E308			-	P8-A	1 3-30-65	(4)	-	SECT.1	-		1100	
		A312,TP-304	HH5	1.315 SCH.103	0.109				-				(4)	-	SECT.1	-		1101
		A312,TP-304	HH5	1.050 SCH.103	0.085				-				(4)	-	SECT.1	-		1106
		A312,TP-316	FG1	0.840	-	0.049	E316			-			(4)	-	SECT.1	-		1108
	HYDRAZINE AND AMMONIA	A312,TP-304	HH5	1.900 SCH.103	0.109	E308			-	P8-A	1 3-30-65	(4)	-	SECT.1	-		1127	
		A312,TP-304	HH5	1.315 SCH.103	0.109	E308			-				(4)	-	SECT.1	-		1135
		A312,TP-316	HH5	0.840	-	0.049	E316			-			(4)	-	SECT.1	-		1114

FORM 84, 4-64

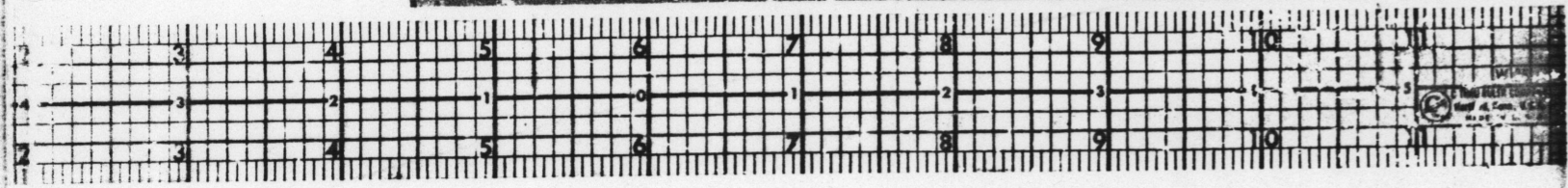
NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

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JOB NO. 3246
 DRAWING NO. 3246-N-1585
 SHEET 13 OF 21
 REV. 0
 BECHTEL
 ISSUED FOR CONST. INDEXED



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