

M20-568778

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 B311	NUCLEAR CASES		
AUXILIARY STEAM	A-53-B	HH	12.750 STD.	0.375	E7018	N.R.	N.R.	-	PI-A-Lh	11	2-23-65	(2)	-	SECT.1	-	1313
	A-53-B	HH	8.625 STD.	0.312				-				(2)	-	SECT.1	-	1316
	A-53-B	HH	6.625 STD.	0.280				-				(2)	-	SECT.1	-	1312
	A-53-B	HH	4.500 STD.	0.237				-				(2)	-	SECT.1	-	1323
	A-53-B	HH	3.500 STD.	0.216				-				(2)	-	SECT.1	-	1317
	A-106-B	EG	1.900 SCH.80	0.200	E6010			-	PI-A-C	12	5-17-65	(3)	-	SECT.1	-	1311
A-106-B	HH	1.900 SCH.80	0.145	E6010			-	PI-A-C	12	5-17-65	(3)	-	SECT.1	-	1306	
M20-568779																
CONDENSER TO CONDENSATE PUMPS.	A-53-B	HH	24.000 STD.	0.375	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT.1	-	301
	A-53-B	HH	20.000 STD.	0.375	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT.1	-	301
CONDENSATE PUMPS TO FEEDWATER PUMPS.	A-53-B	GG	16.000 STD	0.375	E7018			-	PI-A-Lh	11	2-23-65	(2)	-	SECT.1	-	317
	A-53-B	GG	14.000 STD	0.315				-				(2)	-	SECT.1	-	315
	A-53-B	GG	12.750 STD	0.375				-				(2)	-	SECT.1	-	307
	A-53-B	GG	10.750 STD	0.365				-				(2)	-	SECT.1	-	305
	A-53-B	GG	8.625 SCH.40	0.322				-				(2)	-	SECT.1	-	337
	A-53-B	HH	6.625 SCH.40	0.280				-				(2)	-	SECT.1	-	371
FEEDWATER PUMPS TO STEAM GENERATORS.	A-106-B	EG	18.000 SCH.80	0.937	GAGG & E7018		YES	-	PI-AT-Lh-f	3	2-23-65	(1)	ITEM #7	SECT.1	-	325
	A-106-B	EG	12.750 SCH.80	0.687			N.R.	-				(1)	ITEM #6	SECT.1	-	319
	A-106-B	EG	10.750 SCH.80	0.593				ASME PORTION 10%				(1)	ITEM #11	SECT.1	SECT.1	AS.M.E. BOILER CODE SECT.1, DIVISION OF CH.V. 329
	A-106-B	EG	3.500 SCH.80	0.300				ASME PORTION 10%				(1)	ITEM #13	SECT.1	SECT.1	AS.M.E. BOILER CODE SECT.1, DIVISION OF CH.V. 326
FEEDWATER PUMPS TO CONDENSER (RECIRCULATION)	A-106-B	EG	3.500 SCH.80	0.200	GAGG & E7018			-	PI-AT-Lh-f	3	2-23-65	(1)	ITEM #13	SECT.1	-	339
	A-106-B	HH	2.375 SCH.40	0.132	E6010			-	PI-A-C	12	5-17-65	(3)	-	SECT.1	-	379
	A-106-B	EG	1.900 SCH.80	0.200				-				(3)	-	SECT.1	-	339
	A-106-B	HH	1.315 SCH.40	0.132				-				(3)	-	SECT.1	-	379
	A-106-B	GG	1.050 SCH.40	0.113				-				(3)	-	SECT.1	-	386

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.	△	
	△	
	△	
	△	6/26 GEN. REV.
	△	4/66 ISSUED FOR CONST.



JOB NO. 3246	REV.
DRAWING NO. 3246-N-1585	↑
SHEET 14	OF 21

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MTI APERTURE CARD