

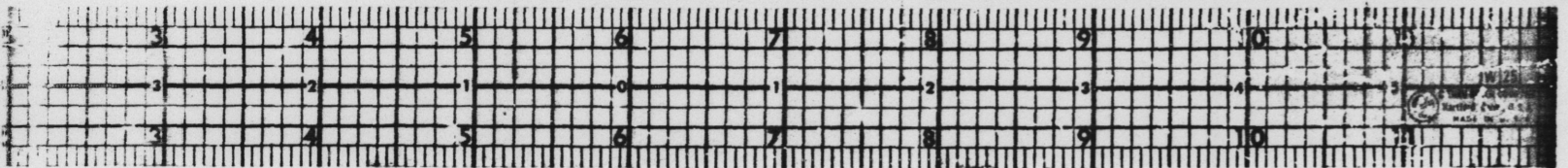
Description & Service ITEM	SPECIFICATIONS		O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relievr	Radiography	Bechtel Welding		WELD END PREPARATION SEE NOTES	CODES			REMARKS	LINE NO.
	MATERIAL	PIPE							Procedure	Rev. Date		ASME BOILER	PRESSURE PIPING B311	NUCLEAR CASES		
STEAM GENERATOR TO BLOWDOWN TANK.	A-106-B	EGX	2.375 SCH.80	0.218	EG010	NR	NR	-	PI-A-C	12 5-17-65	(3)	-	SECT.1	-	343	
	A-106-B	EG	2.375 SCH.80	0.218	EG010			-	PI-A-C	12 5-17-65	(3)	SECT.1	SECT.1	-	ASA B311 SECT.1, DRUST.ION OF 2ND VALVE 343	
GLAND SEAL	A-53-B	GG	8.625 SCH.40	0.322	ET018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT.1	-	337	
	A-106-B	GG	3.500 SCH.40	0.216	ET018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT.1	-	368	
	A-106-B	GG	2.375 SCH.40	0.154	EG010			-	PI-A-C	12 5-12-65	(3)	-	SECT.1	-	334	
	A-106-B	GG	1.900 SCH.40	0.145				-			(3)	-	SECT.1	-	331	
	A-106-B	GG	1.315 SCH.40	0.133				-			(3)	-	SECT.1	-	335	
	A-106-B	GG	0.840 SCH.40	0.109				-			(3)	-	SECT.1	-	361	
M20-568720																
COMPRESSED AIR	A-53-B	HHZ	6.625 SCH.40	0.286	ET018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT.1	-		
	A-53-B	HHZ	4.500 SCH.40	0.237				-			(2)	-	SECT.1	-	903	
	A-53-B	HHZ	3.500 SCH.40	0.216				-			(2)	-	SECT.1	-	906	
	A-106-B	HHZ	1.900 SCH.40	0.145	EG010			-	PI-A-C	12 5-17-65	(3)	-	SECT.1	-	909	
	A-106-B	HHZ	0.840 SCH.40	0.109	EG010			-	PI-A-C	12 5-17-65	(3)	-	SECT.1	-	965	
	B-42	HN	3.500 STD.	0.219				-				BRAZED JT.	-	SECT.1	-	902
	B-42	HN	2.375 STD.	0.156				-				BRAZED JT.	-	SECT.1	-	914
	B-42	HN	1.315 STD.	0.126				-				BRAZED JT.	-	SECT.1	-	921 922
M20-568781																
LUBE OIL	A-53-B	HH	6.625 SCH.40	0.286	ET018			-	PI-A-Lh	11 2-23-65	(2)	-	SECT.1	-	627	
	A-53-B	HH	4.500 STD.	0.237				-			(2)	-	SECT.1	-	606	
	A-53-B	HH	3.500 STD.	0.216				-			(2)	-	SECT.1	-	608	
	A-106-B	HH	2.375 STD.	0.154	EG010			-	PI-A-C	12 5-17-65	(3)	-	SECT.1	-	603	
	A-106-B	HH	1.900 STD.	0.145				-			(3)	-	SECT.1	-	613	
	A-106-B	HH	1.315 STD.	0.133				-			(3)	-	SECT.1	-	627	
	A-106-B	HH	1.050 STD.	0.123				-			(3)	-	SECT.1	-	622	
	A-106-B	HH	0.840 STD.	0.109				-			(3)	-	SECT.1	-	627	

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION
SCHEDULE OF FIELD WELDING PROCEDURES

REV.	△								
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JOB NO. 3246 DRAWING NO. 3246-N-1585 SHEET 15 OF 21 ISSUED FOR CONST.									



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