M20-568782 BECHTEL SECTION

ITEM	Description & Service	SPECIFICATIONS MATERIAL	PIPE	O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relieve	Radio-graphy	Bechtel Welding Procedure	Rev.	Date	WELD END PREPARATION SEE NOTES	CODES ASME BOILER	PRESSURE PIPING B31.1	NUCLEAR CASES	REMARKS	LINE NO.
	VENT HEADER TO CONTAINMENT EXHAUST DUCT.	A-106-B	HH S	2.375 SCH.40	0.154	E6010	NR	NR	—	P1-A-C	12	5-17-65	(2)	—	SECT. 1	—	SEE SHT. 20 FOR S.S. PORTION AT CONTAINMENT SPHERE BETWEEN MONOPLANGE VALVES UNDER ASME SECTION III SUBSECTION B. (A)	961
M20-568783																		
	SAMPLING SYSTEM	A312,TP-304	HH S	2.375 SCH.10S	0.109	E308			—	P8-A	1	3-30-65	(4)	—	SECT. 1	—		1231
		A312,TP-304	HH S	1.315 SCH.10S	0.109				—				(4)	—	SECT. 1	—		1229
		A312,TP-304	EGI	1.050 SCH.40S	0.113				—				(3)	—	SECT. 1	—		1207
		A312,TP-304	EGI	0.675 SCH.40S	0.091				—				(3)	—	SECT. 1	—		1207
		A312,TP-304	HH S	0.675 —	0.035				—				COMP. FITTINGS	—	SECT. 1	—		1221
		A312,TP-304	HH S	0.540 —	0.035				—				COMP. FITTINGS	—	SECT. 1	—		1210
		A312,TP-316	HH S	0.840 —	0.049				—				COMP. FITTINGS	—	SECT. 1	—		1220
M20-568784																		
	NITROGEN SYSTEM	A-106-B	HH	1.900 SCH.40	0.145	E6010			—	P1-A-C	12	5-17-65	(3)	—	SECT. 1	—		1411
		A-106-B	HH	1.315 SCH.40	0.133				—				(3)	—	SECT. 1	—		1410
		A-106-B	HH	1.050 SCH.40	0.113				—				(3)	—	SECT. 1	—		1409
	HYDROGEN SYSTEM	A-106-B	HH	1.315 SCH. 40	0.133	E6010			—	P1-A-C	12	5-17-65	(3)	—	SECT. 1	—		1404
	CO_2 SYSTEM	A-106-B	KN	1.900 SCH.40	0.145	E6010			—	P1-A-C	12	5-17-65	(3)	—	SECT. 1	—		1406
	TURBINE PLANT SAMPLE COOLING SYSTEM	A-106-B	KN	2.375 SCH.40	0.154	E6010			—	P1-A-C	12	5-17-65	(3)	—	SECT. 1	—		1402
		A-106-B	KN	0.840 SCH.40	0.109	E6010			—	P1-A-C	12	5-17-65	(3)	—	SECT. 1	—		1400

FORM 84, 4-64

NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.				
△				
△				
△				
△	5-26-66	ADDED NOTE LINE 961		
△	7-1-66	ISSUED FOR CONST.		

BECHTEL

INDEXED

JOB NO. 3246

DRAWING NO. 3246-N-1585 REV. 1

SHEET 16 OF 21

17X

8606300239

TI APERTURE CARD