

CONTAINMENT SPHERE PENETRATIONS - FIELD WELDS.

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							Procedyre	Rev. Date		ASME BOILER	PRESSURE PIPING B31J	NUCLEAR CASES			
A-8	SPHERE SUMP PUMPS TO DECONTAMINATION TANK.	A-333 GR.0 TO A-312-TP-304.		3.500 SCH.40	0.216	E 309	NR	NR	DET.1 100%	P8, PI-A	1	7-9-65	(2)	SECT. III SUBSECTION B	-	DWG. M20-568772. N-1575	7078	
A-9A	SUPPLY CONTAINMENT COOLING & VENTILATING UNIT.	A-53-B		8.625 SCH.40	0.322	E7018			-	PI-A-LH	11	2-23-65	(2)	-	SECT. I	-	DWG. M20-568776. N-1571.	743
A-9B	SUPPLY CONTAINMENT COOLING & VENTILATING UNIT.	A-53-B		8.625 SCH.40	0.322	E7018			-				(2)	-	SECT. I	-	DWG. M20-568776. N-1571	756
A-10	NON-EXISTANT																	
A-11	SERVICE WATER HEADER	A-106-B		2.375 SCH.160	0.343	E6010			-	PI-A-C	12	5-17-65	(3)	-	SECT. I	-	DWG. M20-568776. N-1572.	730
A-12	SERVICE AIR HEADER	A-106-B		2.515 SCH.160	0.343	E6010			-				(3)	-	SECT. I	-	DWG. M20-568780 N-1572	953
A-13	INSTRUMENT AIR TO REACTOR INSTRUMENTATION.	(A-105 II)		1.960 SCH.160	0.281	E6010			-				(3)	-	SECT. I	-	DWG. M20-568780. N-1572.	928
A-14	RETURN CONTAINMENT COOLING & VENTILATING UNIT.	A-53-B		4.500 SCH.80	0.337	E7018			-	PI-A-LH	11	2-23-65	(2)	-	SECT. I	-	DWG. M20-568776. N-1571.	892
A-15	SPARE (NON-IMPACT TEST COVER A283-D)	A-300 OF A-212B		6.625 SCH.40	0.280 0.700	E7018			* L.P.				(1)	SECT III SUBSECTION B	-	DWG N-1576, DETAIL 1	-	
B-1A	SAFETY INJECTION SYSTEM.	A-333-GR.0 TO A-312-TP304		12.75 SCH. X5	0.500	E 309			DET.1 100%	P8, PI-A	1	7-9-65	(2)	SECT. III - SUBSECT. B	-	DWG. M20-568769. N-1574.	6006	
B-1B	SAFETY INJECTION SYSTEM.	A-333-GR.0 TO A-312-TP304		12.75 SCH. X5	0.500	E-309			DET.1 100%				(2)	SECT. III - SUBSECT. B	-	DWG. M20-568769. N-1574.	6007	
B-1C	SAFETY INJECTION SYSTEM.	A-333-GR.0 TO A-312-TP304		12.75 SCH. X5	0.500	E-309			DET.1 100%				(2)	SECT. III - SUBSECT. B	-	DWG. M20-568769. N-1574.	6008	
B-2	MAKE-UP WATER TO PRESSURIZER RELIEF TANK.	A-333-GR.0 TO A-312-TP-304		6.625 SCH. 20	0.432	E 309			DET.1 100%				(1)	SECT. III - SUBSECT. B	-	DWG. M20-568766. N-1575.	715	
B-3	SPARE (IMPACT TEST COVER A-300)			6.625 SCH. 20	0.432	E7018			-	PI-A-LH	11	2-23-65		SECT. III - SUBSECT. B	-	DWG. M1-568573.	-	
B-4	SPARE (IMPACT TEST COVER A-300)			6.625 SCH. 20	0.432	E7018			-	PI-A-LH	11	2-23-65		SECT. III - SUBSECT. B	-	DWG. M1-568573	-	

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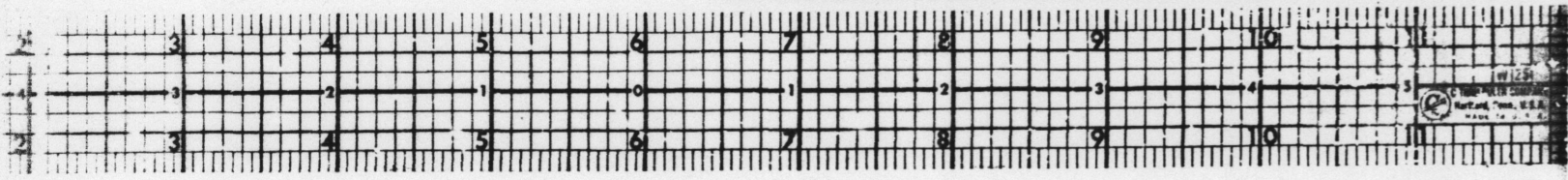
NOTES: * L.P. = 100% LIQUID PENETRANT EXAMINATION.

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.	5-12-64	GEN. REV.	J.S.
	3-25-64	REV. AS NOTED	J.S.
	3-11-64	REV. AS NOTED	J.S.
	1-25-64	REV. AS NOTED	J.S.
	5-12-64	ISSUED FOR WELDING AND METALLURGY CHANGES	J.S.
	10-8-65	ISSUED FOR CONST.	J.S.

JOB NO. 3246	
DRAWING NO.	REV.
3246-N-1585	5
SHEET 18	OF 21



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