

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 #	
		MATERIAL	PIPE							Procedure	Rev. Date		ASME BOILER	PRESSURE PIPING B31	NUCLEAR CASES			
B-5	CHARGING PUMP TO REGENERATIVE HEAT EXCHANGER.	A-333-GR.0	A-312 T304	6.625 SCH.80	0.500	E-309	NR	NR	DET.1-100%	P8, PI-A	I	7-9-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568767. N-1575. WELD SPLIT RINGS. DET. 1	2002
B-6	RESIDUAL HEAT EXCHANGER TO DEMINERALIZERS	A-333-GR.0	A-312 T304	6.625 SCH.80	0.432				DET.1-100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568767. N-1575. WELD SPLIT RINGS. DET. 1	3006
B-7A	CHARGING LINES	A-333-GR.0	A-312 T304	6.625 SCH.80	0.432				DET.1-100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568767. N-1575. WELD SPLIT RINGS. DET. 1	2011
B-7B	CHARGING LINES	A-333-GR.0	A-312 T304	6.625 SCH.80	0.432				DET.1-100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568767. N-1575. WELD SPLIT RINGS. DET. 1	2008
B-7C	CHARGING LINES	A-333-GR.0	A-312 T304	6.625 SCH.80	0.432				DET.1-100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568767. N-1575. WELD SPLIT RINGS. DET. 1	2005
B-8	SEAL WATER FROM REACTOR COOLANT PUMPS.	A-333-GR.0 TO A-312-TP 304	A-312-TP 304	6.625 SCH.80	0.500				DET.1-100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568767. N-1574. WELD SPLIT RINGS. DET. 1	2014
B-9	SPARE (NON-IMPACT TEST COVER A283-C)	A-300 OF A-312	A-283-C	12.750 SCH.XS	0.500 0.700	E7018			* L.P.	PI-A-Lh	II	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M1-568573. N-1576-DET. 1	-
B-10	REACTOR DRAIN TANK TO FLASH TANK	A-333 GR.0 TO A-312, T-304	A-312, T-304	6.625 SCH.80	0.432	E-309			DET.1, 100%	P8, PI-A	I	7-9-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568772. N-1575. WELD SPLIT RINGS. DET. 1	7076
B-11	REACTOR CAVITY TO RECIRCULATING HEAT EXCHANGER	A-333-GR.0 TO A-312-TP 304	A-312-TP 304	12.750 SCH.XS	0.500				DET.1, 100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568776. N-1574, DET. 1	737
B-12	REACTOR COOLANT SAMPLING SYSTEM	A-333-GR.0 TO A-312, TP 304 B	A-312, TP 304 B	14.000 SCH.60	0.523				DET.1 100%				(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568783. N-1586, DET. 1	3008 1201
B-13	SPARE (NON-IMPACT TEST COVER A283-C)	A300 OF A-312	A-283-C	12.750 SCH.XS	0.500 0.700	E7018			* L.P.	PI-A-Lh	II	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M1-568573. N-1576, DET. 1	-
B-14A	SPARE (IMPACT TEST COVER A-300)			12.750 SCH.80	0.687									SECT. III SUBSECT. B	-	-	DWG. M1-568573.	-
B-14B	SPARE (IMPACT TEST COVER A-300)			12.750 SCH.80	0.687									SECT. III SUBSECT. B	-	-	DWG. M1-568573.	-
B-14C	SPARE (IMPACT TEST COVER A-300)			12.750 SCH.80	0.687									SECT. III SUBSECT. B	-	-	DWG. M1-568573.	-
B-14D	SPARE (IMPACT TEST COVER A-300)			12.750 SCH.80	0.687									SECT. III SUBSECT. B	-	-	DWG. M1-568573.	-
B-14E	SPARE (IMPACT TEST COVER A-300)			12.750 SCH.80	0.687									SECT. III SUBSECT. B	-	-	DWG. M1-568573.	-
B-14F	SPARE (IMPACT TEST COVER A-300)			12.750 SCH.80	0.687									SECT. III SUBSECT. B	-	-	DWG. M1-568573.	-

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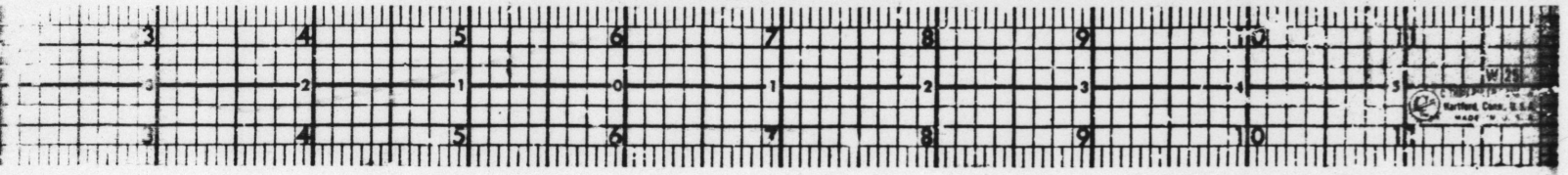
NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.	3-24-66	GEN. REV.	J.S.
	3-25-66	REV. AS NOTED	J.S.
	3-14-66	REV. AS NOTED	J.S.
	3-25-66	REV. AS NOTED	J.S.
	5-24-66	ISSUED FOR WELDING AND METALLURGY CHANGE	J.S.
	8-8-65	ISSUED FOR CONST.	J.S.

JOB NO. 3246	REV.
DRAWING NO. 3246-N-1585	5
SHEET 19	OF 21



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TI APERTURE CARD