

CONTAINMENT SPHERE PENETRATIONS - FIELD WELDS.

ITEM	Description & Service	SPECIFICATIONS		O.D.	Maximum Thickness	Filler Metal	Preheat	Stress Relieve	Radiography	Bechtel Welding		WELD END PREPARATION SEE NOTES	CODES			REMARKS	LINE NO.	
		MATERIAL	PIPE							Procedure	Rev. Date		ASME BOILER	PRESSURE PIPING B311	NUCLEAR CASES			
B-15A	SPARE (NON-IMPACT COVER A-283-C)	A-300 OF A-212 B		8.625 SCH. 80	0.900 0.700 R	E7018	NR	NR	* L.P.	PI-A-Lh	11 2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. N-1576, DET. 1	-	
B-15B	SPARE (NON-IMPACT COVER A-283-C)	A-300 OF A-212 B		8.625 SCH. 80	0.500 0.700 R				* L.P.			(7)	SECT. III SUBSECT. B	-	-	DWG. N-1576, DET. 1	-	
B-15C	SPARE (NON-IMPACT COVER A-283-C)	A-300 OF A-212 B		8.625 SCH. 80	0.500 0.700 R				* L.P.			(7)	SECT. III SUBSECT. B	-	-	DWG. N-1576, DET. 1	-	
B-16A	SPARE (IMPACT TEST COVER A-300)			10.750 SCH. 80	0.593								SECT. III SUBSECT. B	-	-	DWG. MI-568573	-	
B-16B	SPARE (IMPACT TEST COVER A-300)			10.750 SCH. 80	0.592								SECT. III SUBSECT. B	-	-	DWG. MI-568573	-	
B-17A	SAFETY INJECTION PURGE LINE	A-333 GRO TO A-312 TP 304		6.625 SCH. 80	0.432	E309			DET. 1 100%	PB, PI-A	1 7-9-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568769, N-1575, WELD SPLIT RINGS, DETAIL 1	6009	
B-17B	VENT HEADER TO EXHAUST DUCT	A-333 GRO TO A-312 TP 304		6.625 SCH. 105	0.134"	E309			DET. 3 100%	PA, PI-A	1 7-9-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568782, N-1582-1	961	
B-18A	VAPOR CONT. COOLING SPRAY WATER	A-333 GRO TO A-312 TP 304		2.375 SCH. 105	0.105"	ER-308 / E-308			DET. 2 100%	PB-AT-g	1 3-30-65	(C)	SECT. III SUBSECT. B	-	-	WELD SPLIT RINGS DET. 1 & 2 SEE SHT. 16 FOR REMAINDER OF LINE	HP	
B-18B	GAS SAMPLE LINE (2 REQ'D)	A-333 GRO TO A-312 TP 304		8.625 SCH. 80	0.500	E-309			DET. 1 100%	PB, PI-A	1 7-9-65	(1)	SECT. III SUBSECT. B	-	-	DWG. M20-568776, N-1573, DET. 1	734	
	TYPE II No. 12 INSTRUMENT TUBING DPT-434	A-333 GRO TO A-300 CL1		1.050 SCH. 160	.700 R	E7018			DET. 1 *L.P.	PI-A-Lh	11 2-23-65	(B)	SECT. III SUBSECT. B	-	-	DWG. M20-568766, N-1583, DET. 1 & 2 3246-SK-M-1199-1	DPT-434 (INST)	
		A-312 TP-304 TO A-333 GRO		1.050 SCH. 160	.218	E-309			DET. 2 100%	PB, PI-A	1 9-9-65	(2)						
	TYPE II No. 9 SPHERE AIR TEST AND SENSING LINES	A-333 GRO TO A-300 CL1		1.315 SCH. 80	.700 R	E7018			DET. 1 *L.P.	PI-A-Lh	11 2-23-65	(B)	SECT. III SUBSECT. B	-	-	DWG. N-1583 DET. 1 & 2	9002 9001 9002 9001	
		A-351 GRCEB TO A-333 GRO		1.315 SCH. 80	.179"	E-309			DET. 3 100%	PB, PI-A	1 7-9-65	(E)	SECT. III SUBSECT. B	-	-			
				1.050 SCH. 160	.218"				AUS *L.P.									
	C-1A STEAM GENERATOR BLOWDOWN			8.625 SCH. 80	0.500 0.700 R	E7018			* L.P.	PI-A-Lh	11 2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M20-568779, N-1576, WELD SPLIT RINGS DETAIL 1	341	
	C-1B STEAM GENERATOR BLOWDOWN			8.625 SCH. 80	0.500 0.700 R	E7018			* L.P.	PI-A-Lh	11 2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M20-568779, N-1576, WELD SPLIT RINGS DETAIL 1	342	
	C-1C STEAM GENERATOR BLOWDOWN			8.625 SCH. 80	0.500 0.700 R	E7018			* L.P.	PI-A-Lh	11 2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M20-568779, N-1576, WELD SPLIT RINGS DETAIL 1	343	

FORM 84, 4-64

NOTES:

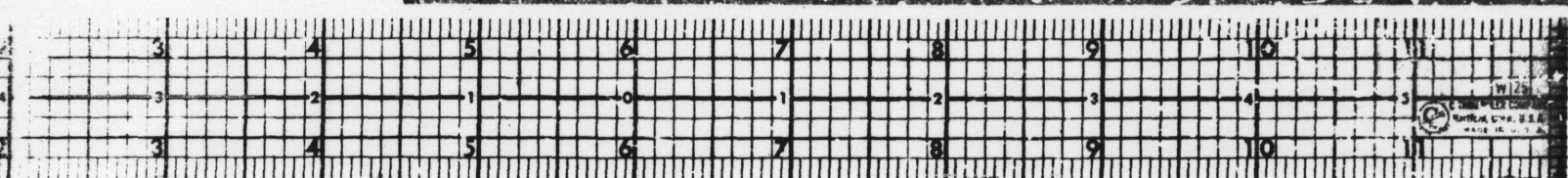
SAN JOSE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV	10-21-66	REV DET 1 ADDED DETS B17B, 9000, 9001, 9002	DNP
	7-27-66	ADDED 9002	DNP

REV.	1-3-66	REMOVED HOLD B-17B	J.S.
	5-12-66	GEN. REV.	J.S.
	3-15-66	REV. AS NOTED	J.S.
	3-11-66	REV. AS NOTED	J.S.
	1-25-66	REV. AS NOTED	J.S.
	6-10-66	REV. AS NOTED	J.S.
	10-8-65	ISSUED FOR CONST.	J.S.

JOB NO.	3246
DRAWING NO.	3246-N-1585
REV.	8
SHEET	20 OF 21



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TI APERTURE CARD