

CONTAINMENT SPHERE PENETRATIONS - FIELD WELDS.

Description & Service ITEM	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							Procedure	Rev. Date		ASME BOILER	PRESSURE PIPING B31J	NUCLEAR CASES			
C-2A NITROGEN TO REACTOR COOLANT SYSTEM DRAIN TANK	A-300 OF A-212-B	A-212-B	8.625 SCH. 80	0.500 0.700 P	E7018	NR	NR	DET. L.P.	PI-A-Lh	11	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M-20-568772 - N-1576 DETAILS 1 & 3	1410
C-2B SPARE (NON-IMPACT TEST COVER A-293-C)	A-300 OF A-212-B	A-212-B	8.625 SCH. 80	0.500 0.700 P	E7018			* L.P.	PI-A-Lh	11	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M1-568573 DET. 1	-
C-2C YENT TO RAD. WASTE GAS COLLECTION HDR.	A-333 GR. TO A-312, T1-304	A-312, T1-304	8.625 SCH. 80	0.500	E-309			DET. 100%	PG, PI-A	1	7-9-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568772 WELD SPLIT RINGS. DET. 1 & 3	7073
C-3A FEEDWATER	A-333-GR. TO A-350-LF1	A-350-LF1	18.000 SCH. XS	0.500 1.5" P	E7018			DET. 1 L.P.	PI-A-Lh	11	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M20-568779. N-1577. DET. 1	393
C-3B FEEDWATER	A-333-GR. TO A-350-LF-1	A-350-LF-1	18.000 SCH. XS	0.500 1.5" P	E7018			DET. 1 L.P.		11	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M20-568779. N-1577. DET. 1	398
C-3C FEEDWATER	A-333-GR. TO A-350-LF1	A-350-LF1	18.000 SCH. XS	0.500 1.5" P	E7018			DET. 1 L.P.		11	2-23-65	(7)	SECT. III SUBSECT. B	-	-	DWG. M20-568779. N-1577. DET. 1	392
D-1 MAIN STEAM	A-333-GR. O	A-333-GR. O	24.000 48.000	0.547 0.500	GA65 E7018		YES	DET. 1 & 2 100%	PI-AT-Lh-f PI-A-Lh	3 11	2-23-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568773. N-1579. WELD SPLIT RINGS. DET. 1 & 2	1
D-1 MAIN STEAM	A-333-GR. O	A-333-GR. O	24.000 48.000	0.547 0.500	GA65 E7018		YES	DET. 1 & 2 100%	PI-AT-Lh-f PI-A-Lh	3 11	2-23-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568773. N-1579. WELD SPLIT RINGS. DET. 1 & 2	2
E-1 VENTILATION	A-350-LF1	A-350-LF1	24.000 SCH. XS	0.500	E7018		NR	DET. 1-100%	PI-A-Lh	11	2-23-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568782. N-1580. USE IMPACT TESTED BOLTS. A320LT	-
E-1 VENTILATION	A-350-LF1	A-350-LF1	24.000 SCH. XS	0.500	E7018			DET. 1-100%	PI-A-Lh	11	2-23-65	(2)	SECT. III SUBSECT. B	-	-	DWG. M20-568782. N-1580. USE IMPACT TESTED BOLTS. A320LT. N-1580-DETAILS 1 & 4 WELD SPLIT RINGS.	-
F-1 TRANSFER TUBE	A-330-GR. O	A-330-GR. O	36.000 SCH. 20	0.500 P 1" FLG.	E7018			100%	PI-A-Lh	11	2-23-65	(2) AND (6)	SECT. III SUBSECT. B	-	-	DWG. - N-1581 WELD SPLIT RINGS.	-
TYPE II PS CAN (ELECTRICAL)	A-333-GR. O TO A312, T1-304	A312, T1-304	11.000	0.250	E-309			100%	PG, PI-A	1	7-9-65	(7)	SECT. III SUBSECT. B	-	-	DWG. JKR-3246-EL-O. RADIOGRAPH PRIOR TO INSTALLING ELECT. COMPONENTS.	-
TYPE III POWER CAN (ELECTRICAL)	A-333-GR. O	A-333-GR. O	21.50	0.250				* L.P.					SECT. III SUBSECT. B	-	-	DWG. 3246-SK-B-416-B.	-

FORM 84, 4-64

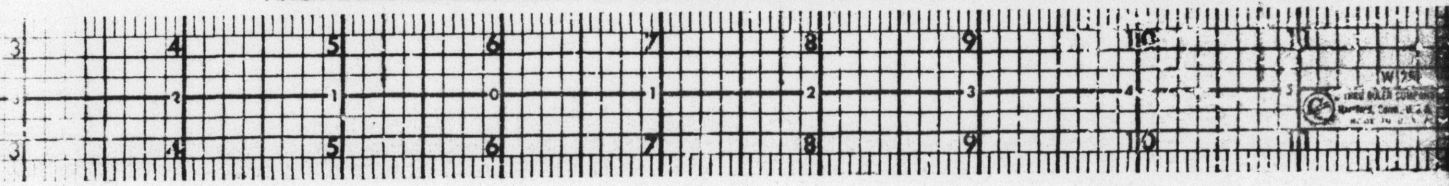
NOTES:

SAN ONOFRE NUCLEAR GEN. STATION

SCHEDULE OF FIELD WELDING PROCEDURES

REV.	DATE	DESCRIPTION	BY	CHECKED
4	5-19-66	GEN. REV.	J.S.	J.S.
3	3-25-66	REV. AS NOTED	J.S.	J.S.
2	1-25-66	REV. AS NOTED	J.S.	J.S.
1		REV. AS NOTED	J.S.	J.S.
	1-8-66	ISSUED FOR CONST.	J.S.	J.S.

JOB NO.	3246
DRAWING NO.	3246-N-1585
SHEET	21 OF 21



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