BURNS AND ROE, INC.
WPPSS
NUCLEAR PROJECT
NO. 2

PROJECT ENGINEERING DIRECTIVE

CODE	PROJECT ENGINEERING DIRECTIVE
2 1	2 1 5 - W - 2 7 4 0
DATE 0 3 / 1 4 / 8 0	PRIORITY I

REASON FOR P. E. D.:

This PED is to allow the contractor to prepare for welding to be done by Dual Shield FCAW Process.

INFORMATION COPIES

SHEET 1 OF 1

REFERENCES

SUBJECT Dual Shield FCAW Qualification
LOCATION E/541'-5"
ENG SYSTEM N/A
S/U SYSTEM N/A
QUALITY CLASS I

ORIGINATING DOCUMENTS NCR-215-5688

DESCRIPTION OF WORK:

Contractor shall obtain machinery, welding wire and test materials to qualify a procedure and personnel, suitable to perform necessary capacity of welding to be done on the Sac. Wall.

Contractor shall coordinate all operations with Burns and Roe Welding Engineer in contractors establishment for qualifying procedures and personnel, to inable this program to be expedited.

The procedure and personnel shall be qualified in the horizontal position. The test plate for qualifying the procedure and personnel shall be in accordance with AWS D1.1 and Spec. 215-17D. A 2'x 2' mock-up of the plate thickness (as close as possible), and joint design shall be welded by each welder prior to welding on the Sac. Wall.

Type of Machinery Required

12
Manufacturer: Airco Flux Core Welding Machines

John Brosnann
(415) 658-5010

Type of Filler Metal Required

25 lb. spools
(1500 lbs)
(Dia. .045)
Dual Shield
(E-70T-1)

Manufacturer:
Chemetrom Welding Supply
(206) 682-2880

Gas - Argon - CO_2
98-2%

dupe of 8004070371 1pp

NOTES

1. THIS PED REVISES DIRECTION PREVIOUSLY PROVIDED BY THE FOLLOWING PED(s): N/A
2. THIS PED VOIDS DIRECTION PREVIOUSLY PROVIDED BY THE FOLLOWING PED(s): N/A
3. THIS PED WORK SHOULD BE COORDINATED WITH KNOWN OTHER WORK UNDER THE FOLLOWING PED'S: N/A
4. THIS PED DEPENDS ON THE PRIOR INSTALLATION OF THE FOLLOWING PED'S: N/A

REVISE:
NONE
DRAWINGS N/A
SPECIFICATION

APPROVALS:

M. Gresham (signature) — DISCIPLINE ENGINEER	DATE 3-24-80
R. F. Allen (signature) — LEAD DISCIPLINE ENGINEER	DATE 3-25-80
S/U LIAISON ENGINEER	DATE
RESIDENT PROJECT ENGINEER	DATE

BURNS AND ROE, INC.
WPPSS
NUCLEAR PROJECT
NO. 2

PROJECT ENGINEERING DIRECTIVE

CODE	PROJECT ENGINEERING DIRECTIVE
2 1	· 2 1 5 - C S - 2 7 4 1
1 2	3 4 5 6 7 8 9 10 11 12 13 14 15
DATE	0 3 / 1 3 / 8 0 — PRIORITY II
X	16 17 X 18 19 X 20 21

REASON FOR P. E. D.:

SLOT WELDS REQUIRED PER DETAIL D-2038 (S782) MADE TO TOP OF SHIMS AND DO NOT CONNECT RING 3 (BEAM TYPE (3)) AND RING 4 (BEAM TYPE (2)) AS REQUIRED.

INFORMATION COPIES N/A

SHEET 1 OF 6

REFERENCES	
SUBJECT	SAC. SHIELD WALL WELDS
LOCATION	EL. 541'-5 ALL AROUND
ENG. SYSTEM	N/A
S/U SYSTEM	
QUALITY CLASS	I

ORIGINATING DOCUMENTS NCR 215-5688

DESCRIPTION OF WORK:

REPLACE SLOT WELDS WITH A PARTIAL PENETRATION WELD BETWEEN THE UPPER AND LOWER RINGS AS DETAILED ON SHEETS 3 THRU 5 OF THIS P.E.D.

WELD PREPARATION SHALL BE AS DIRECTED ON P.E.D. 215-W-2742.

WELD QUALIFICATION SHALL BE AS DIRECTED ON P.E.D. 215-W-2749.

REPAIR OF GAPS AT SHIMS (NCR 215-4884) SHALL BE AS DIRECTED ON PED 215-M-2746. WELD SHALL BE MADE AS DIRECTED ON P.E.D. 215-W-1604.

NOTES

1. THIS PED REVISES DIRECTION PREVIOUSLY PROVIDED BY N/A THE FOLLOWING PED(s):
2. THIS PED VOIDS DIRECTION PREVIOUSLY PROVIDED BY N/A THE FOLLOWING PED(s):
3. THIS PED WORK SHOULD BE COORDINATED WITH KNOWN OTHER WORK UNDER THE FOLLOWING PED'S: 215-W-1604, 215-W-2742, 215-W-2749, 215-M-2746
4. THIS PED DEPENDS ON THE PRIOR INSTALLATION OF N/A THE FOLLOWING PED'S:

REVISE:
NONE
DRAWINGS X
SPECIFICATION

APPROVALS:

DISCIPLINE ENGINEER	DATE 3/24/80
LEAD DISCIPLINE ENGINEER	DATE 3.24.80
S/U LIAISON ENGINEER	DATE
RESIDENT PROJECT ENGINEER	DATE

REV 1 BR 803-2

8004070371

PROJECT ENGINEERING DIRECTIVE			CODE	PROJECT ENGINEERING DIRECTIVE
WNP-2	BURNS & ROE, INC.	PAGE 2 OF 62		215 - CS - 2741

REFERENCE DRAWINGS

REVISE	DRAWING NO.	SHEET NO.	SUFFIX	REV.
Y	5782			12
Y	5835			06
Y	5838			01
N	5783			11
N	5837			05

REFERENCE DRAWINGS

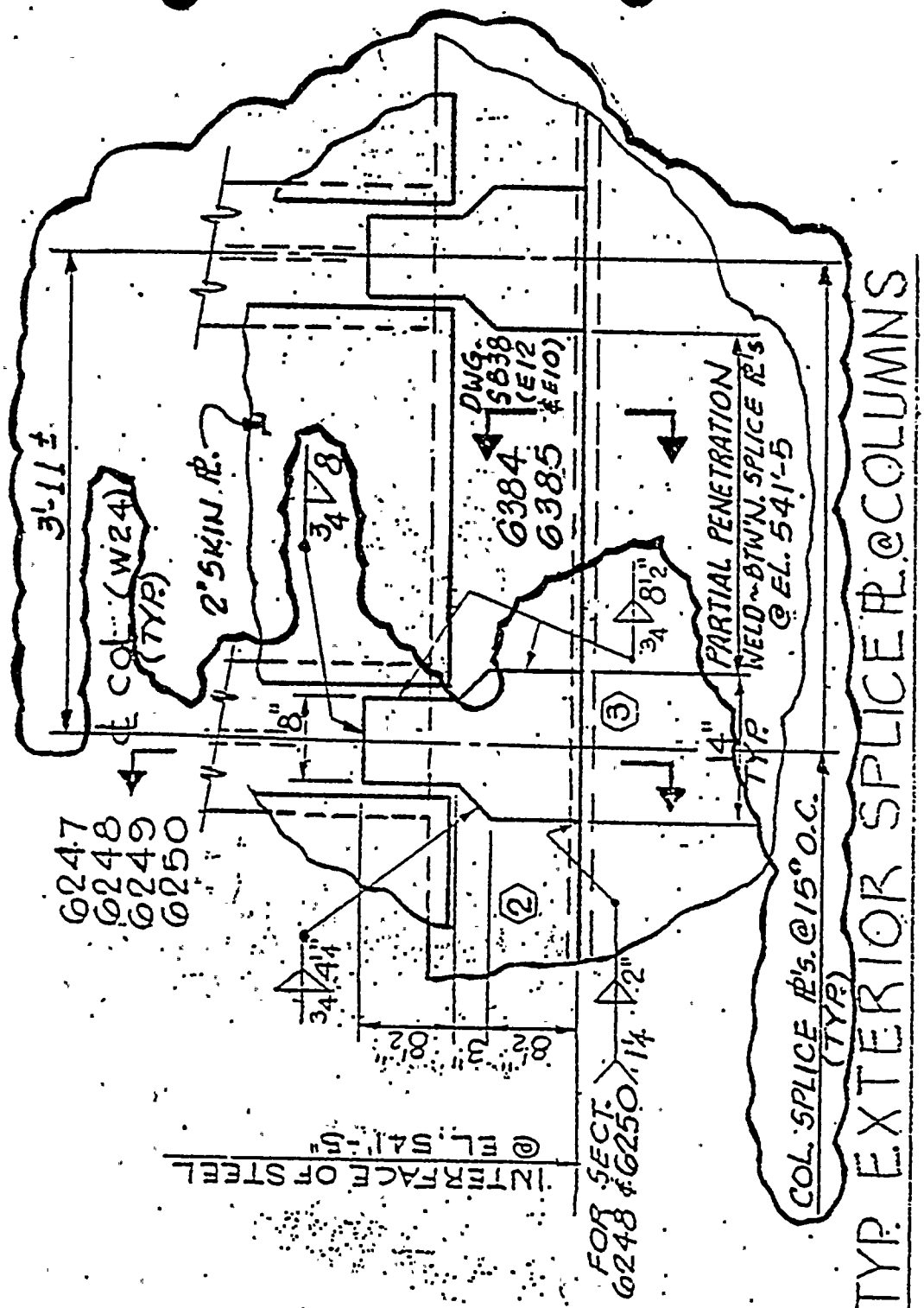
REVISE	DRAWING NO.	SHEET NO.	SUFFIX	REV.

REFERENCE SPEC. PARAGRAPHS

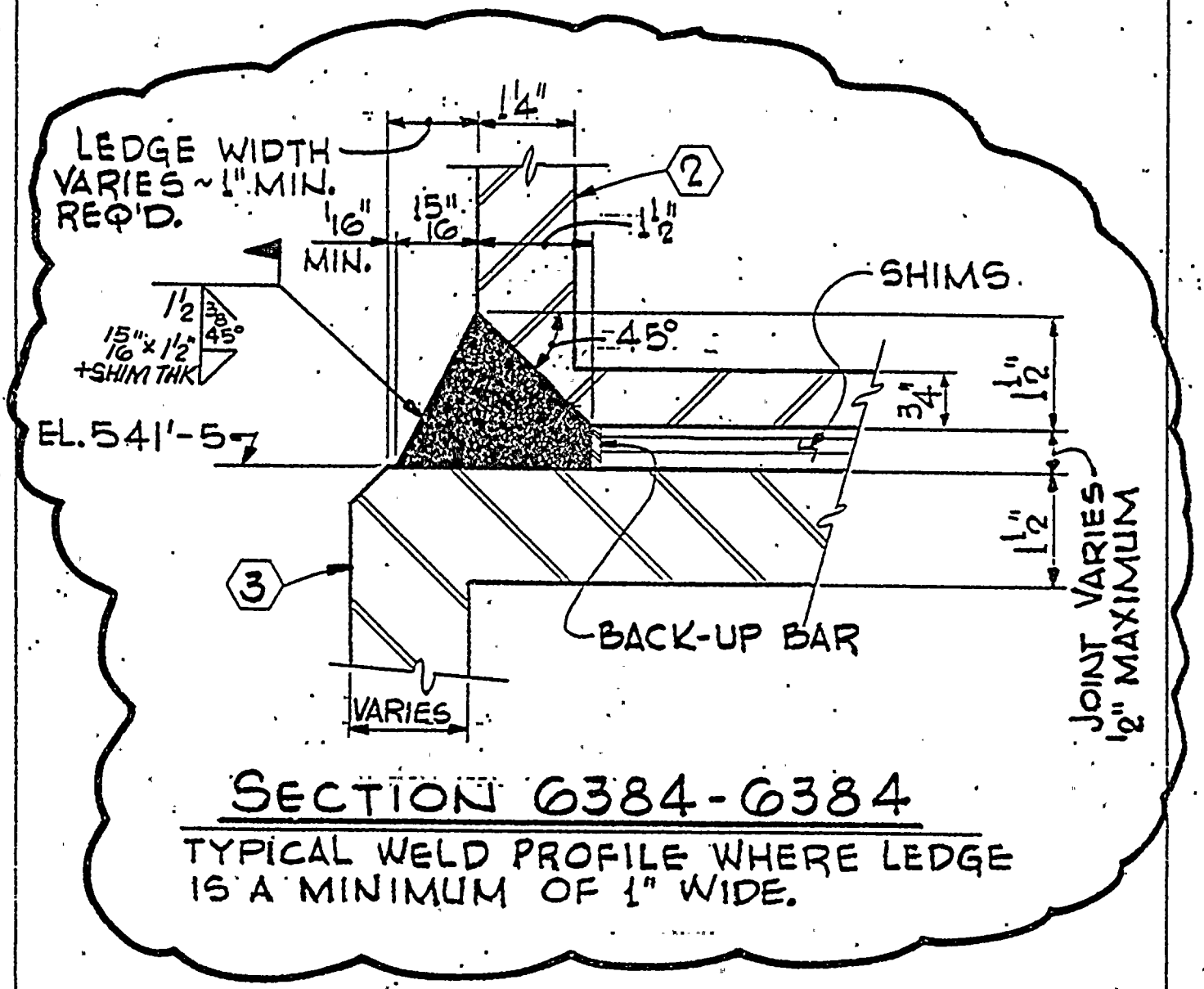
REVISE	SECTION	PARAGRAPH	PAGE	REV.

3-13-80

REV 1 BR 803-1



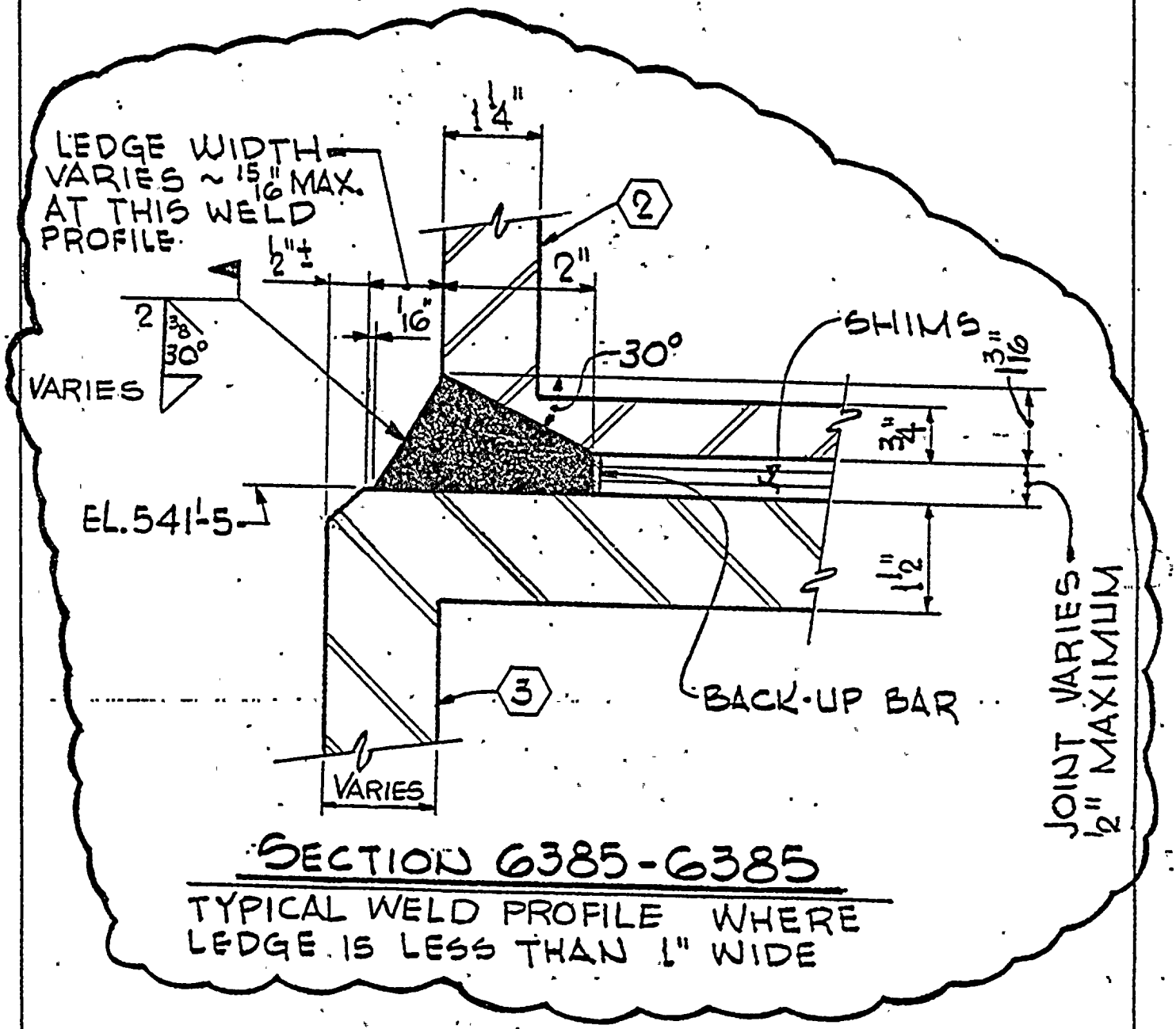
REF. DOC.: PCN —— ~~REF~~ NCR 215-5688			WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: —— PAGE: —— PARA: ——			BURNS AND ROE, INC.
REF. DWG.: 5835 REV. 5		DWG. ZONE: B14	PED 215-C5-2741 SHT 3 OF 6
SCALE: N.T.S.	DRAWN BY: KERNER DATE 10/24/79		TITLE: REACTOR BUILDING SAC SHIELD WALL SHT. 8
	CHKD BY: JORDAN DATE 3/12/80	APP'VD: WMM DATE: 3/24	



SECTION 6384-6384

TYPICAL WELD PROFILE WHERE LEDGE IS A MINIMUM OF 1" WIDE.

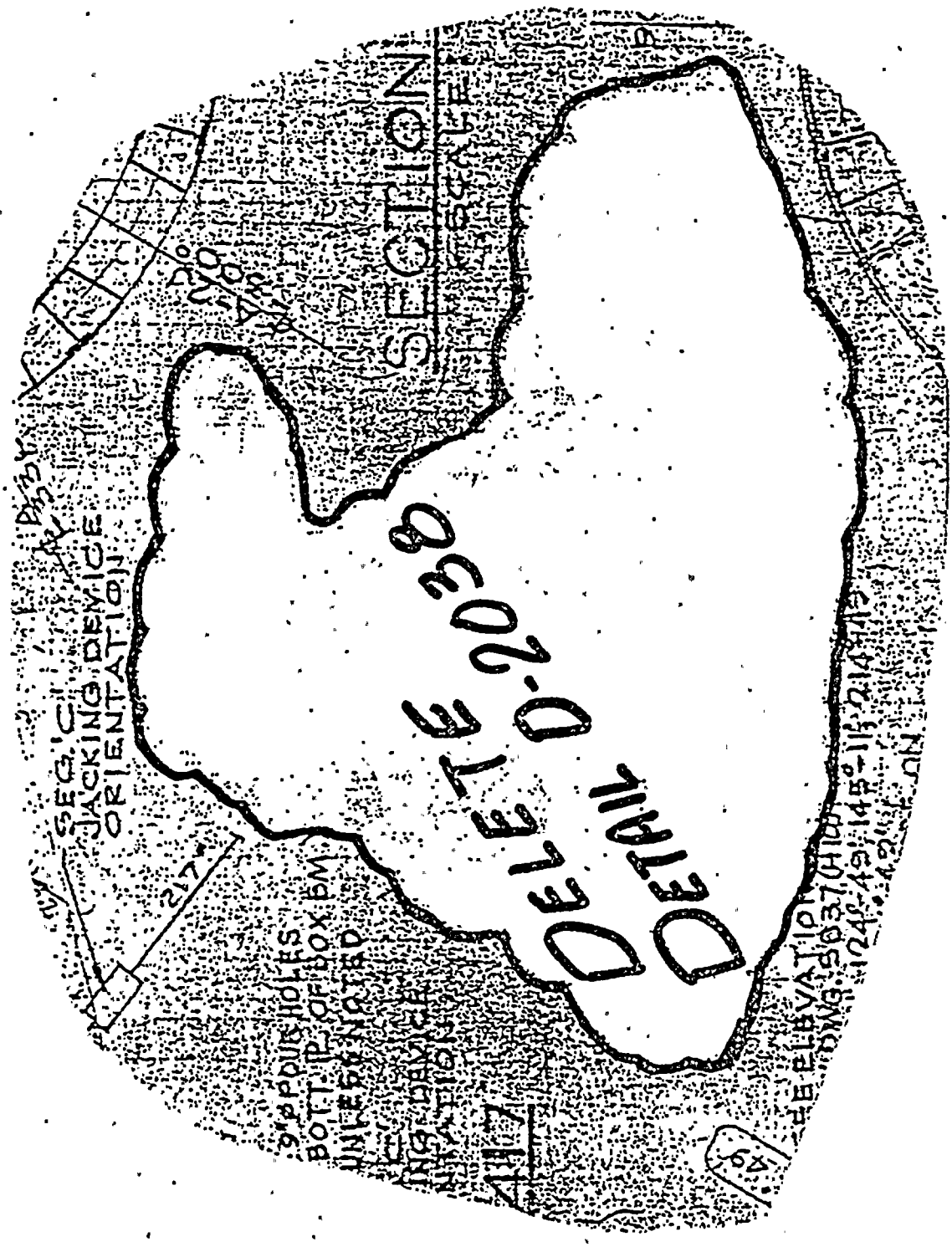
REF. DOC.: PCN —— ~~REF~~ NCR 215-5688			WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: —— PAGE: —— PARA: ——			BURNS AND ROE, INC.
REF. DWG.: 5838 REV. 1	DWG. ZONE: E12		PED 215-CS-2741 SHT. 4 OF 6
SCALE: N.T.S.	DRAWN BY: KERNER DATE: 8/29/79		TITLE: REACTOR BUILDING SAC. SHIELD WALL SHT. 11
	CHKD BY: JORDAN DATE: 3/13/80	APVD: [illegible] DATE: 3/24	



SECTION 6385-6385

TYPICAL WELD PROFILE WHERE LEDGE IS LESS THAN 1" WIDE

REF. DOC.: PCN ~~NCR~~ NCR 215-5688			WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: PAGE: PARA:			BURNS AND ROE, INC.
REF. DWG.: 5838 REV. 1	DWG. ZONE: E10		PED 215-CS-2741 SHT. 5 OF 6
SCALE: N.T.S.	DRAWN BY: KERNER DATE: 3/12/80		TITLE: REACTOR BLDG. SAC. SHIELD WALL SHT. 11
	CHKD BY: Jordan DATE: 3/13/80	APPVD: WMS DATE: 3/24	



REF. DOC.: PCN —— NCR 215-5688			WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: —— PAGE: —— PARA: ——			BURNS AND ROE, INC.
REF. DWG.: S782 Rev. 12	DWG. ZONE: D5		PED 215-C5-2741 SHT. 6 OF 6
SCALE: N.T.S.	DRAWN BY: KERNER DATE: 12/29/89		TITLE: REACTOR BUILDING SAC. SHIELD WALL SHT. 1
	CHKD BY: Jackson DATE: 3/13/90	APPVD: WMH DATE: 3/14	