

Wm. H. Zimmer Nuclear Power Station
Hydrostatic/Pneumatic Test Report
(Page 1)

Test No. PR-216

A. Test Parameters

1. System to be tested REACTOR RECIRCULATION (RR)
Cleanliness Class "B"
2. Bldg. or Location of test RL BLDG.
3. Orientation and Terminal Points of test SEE ATTACHED P&ID
elevation of high point 553' elevation of low point 534'
el. _____
4. Attached Drawing Numbers & Revision Numbers M-47-1 REV: G
5. Pipe Fabricator: KEI Other _____
6. Type Test: Hydrostatic ☒ Pneumatic ☐
7. Test Media EYRQUEL EHL HYDRAULIC FLUID
(USB SYSTEM HYDRAULIC UNIT FOR
8. Test Plan (Select One) PRESSURE SOURCE)
Hydrostatic KEI 10-101 ☒ Pneumatic KEI 10-103 ☐
Hydrostatic KEI 10-102 ☐
9. A. Required Test Pressure 200 P.S.I.G. (minimum at highest elev.
1. From S&L Piping Line List
2. 1.25 times design pressure Ref. ASME Code
3. 1.5 times design pressure Ref. ANSI B31.1
4. As specified by CG&E Construction Engineer for Class D Systems only
N/A
Signature/Date _____
B. Maximum pressure to which system can be pressurized 215 PSIG
(material or component restraint)

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Hydrostatic/Pneumatic Test Report
(Page 2)Test No. RR-210C. Gauge location (elevation) 530' expected static pressure reading10 PSIGD. Specified test pressure (9A + 9C) 210 PSIGE. Greater of 3/4 test pressure or design pressure (ASME test only)160 PSIGF. Holding test pressure (~~96~~ 95) 160 PSIG10. Test Parameters completed by Steve C. Rhee 9-5-78
Signature/Date

Verified

KEI Q.A. EngineerB. Test Prerequisites1. Valve Lineup completed by [Signature] 9-5-78
Signature/date2. Water Analysis Report available N/A and acceptable.
KEI-QA Signature/Date R.3. Test Gauges: Note Range shall be more than $1\frac{1}{2}$ times test pressure
but less than 4 times test pressure.S/N 1076-11 Range ± 100 Psi Calib. date 2-1-79 Due date 5-6-79S/N 1076-12 Range ± 100 Psi Calib. date 1-5-79 Due date 7-1-79S/N Range $\pm$ Psi Calib. date Due date

EXPLANATION: ① VALVE 333 F327 C. NOT USED IN TEST
OF TEST. WELD DID NOT MEET SPEC.

SEE HYDRA TEST # RR-53

F-22-79

zlo

4-5-78

Wm. H. Zimmer Nuclear Power Station
Hydrostatic/Pneumatic Test Report
(Page 3)

Test No. RR-26

C. Test Results

1. Ambient temp. 70° Media temp. 70°
2. Time test started 1:15 PM Time test pressure reached 1:25 PM
Hold time 10 min Time test completed 2:00 PM
Test Gauge Pressure Reading at test 210 PSI
3. Test Results & Remarks: No Leaks

4. Test conducted by: [Signature] 2-26-79
Signature/date

5. Remove test tags, remove test equipment, etc. [Signature] 2-26-79
Signature/date

D. Test Witnessed and Accepted By:

1. KEI Hydrotest Super. and/or Engineer [Signature] 2-26-79
Signature/date

2. Quality Assurance Representative [Signature] 2-26-79
Signature/date (WITH RECEIPT ON BACK)

3. CG&E Representative/Ohio Special Insp. R. L. Wood 2/26/79
Signature/date

4. Authorized Nuclear Inspector [Signature] 2/26/79
Signature/date

HYDROSTATIC TEST VALVE LINE UP

Hydro RR-26

VALVE NUMBER	POSITION	COORDINATES	DRAWING NUMBER
1B33F3: C	OPEN	1-4	M-47-1
1B33F3: 50	Closed	3-4	M-47-1

Note: Protect all instruments in panels, on racks, etc. from Hydro Test Pressure.

HYDRO-PP-26
TAK-ONE

DESIGNED BY SPITZER DATE

CHECKED BY

DATE

ISK	IN HYDRO	LN FT	BLDG / EL	ISK	IN HYDRO	LN FT	BLDG / EL
181				211			
182				222			
183				223			
184				224			
185				225			
186				226			
187				227			
188				228			
189				229			
190				230			
191				231			
192				232			
193				233			
194				234			
195				235			
196				236			
197				237			
198				238			
199				239			
200				240			
201				241	X	22	P/C 533
202				242			
203				243			
204				244	X	24	P/C 533
205				245			
206				246			
207				247	X	3	P/C 533
208				248			
209				249			
210				250			



ITEM	HEAT NUMBERS
A.	
B.	
C.	
D.	
E.	
F.	
G.	
H.	
I.	
J.	
K.	
L.	
M.	
N.	
O.	
P.	
Q.	
R.	
S.	
T.	
U.	
V.	
W.	
X.	
Y.	
Z.	

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SP-11-78

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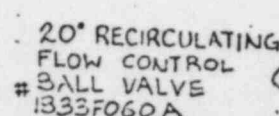


TOTAL WELDS

THOMAS H. ZIMMER NUCLEAR POWER STATION UNIT 1

**KAISER
ENGINEERS**

CONSUMERS ENGINEERING, INC.
1000 AVD 1010



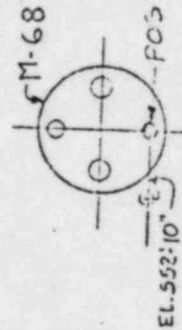
MATERIAL - TAKE OFF CLASS B EGG TAIL			
2540 WZ		2	
MATERIAL DESCRIPTION & SPEC			
A	24 EA 1/2"	STE	STE ASTM A36 2" X 1/2" X 1/2"
B	3 EA 1/2"	STE	STE ASTM A36 2" X 1/2" X 1/2"
C	1 EA 1/2"	STE	STE ASTM A36 2" X 1/2" X 1/2"
D			
E			
F			
G			
H			
J			
K			

KE-I-WELD DATA—SMALL BORE PIPING			
Weld Proc. Code #	5-1-2	Welding Machine	Gas Temp
Preheat & Interpass Temp	300°F	1. Voltage Range	
Filler Metal Type	ER 308	2. Amperage	
Filler Metal Size	3/32" 1/16"	3. Shielding Gas	
Joint Size (See Dimensions)		4. Preheat Temp	
Special Instructions		5. Post Heat Temp	
Good Weld only		6. Final PT Temp	
APPROVALS		7. Final PT Temp	
Welder's Signature		8. Final PT Temp	
Inspector's Signature		9. Final PT Temp	
QA Eng		10. Final PT Temp	
QA Insp		11. Final PT Temp	
QA Insp		12. Final PT Temp	

The welding data noted on this ICK shall not apply to groove weld connections to large bore pipe.

CITAN. CLASS	B	DESIGN CLASS	2
DESIGN TEMP	160°F	DESIGN PRESS	150 PSIG
REF SPEC	H-225G	INSULATION	N/A
WELD PROCEDURE			
LINE NO	IRRE-9AC 1/2"		
HANGER NO			
PIECE NOS	RR-242-A, B, C, D, E		
REF ONLY	M-47-1, M-464-3		
APEN	AA-533 REACTOR BLOC		
DRAWN BY	R.L.S.		
SYSTEM	REACTOR RECIRCULATION		

FOR CONT. SEE
DWG. M-454-1
LINE NO. 18846 AC 1/2



THE UNIVERSITY OF CHICAGO

ALL BIDDING PER FED
CONSTRUCTION PROJECT 2-233

82-117-
D-117-
D-117-

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HEAD
DETAIL
SITE NO. 11-2254

TOTAL WTLBS

WGA, H. ZIMMER NUCLEAR POWER STATION UNIT 1

ENGINEERING

RAISER ENGINEERS, INC.
JOB. NO. 7070

REACTOR RECIRCULATION (R.R.)

