

DMB

PRINCIPAL STAFF		
RA	KS	DPRP
D/RA		DE
A/RA		DRMSP
RC		DRMA
PAO		SCS
SGA		ML
ENF		File

orig + 3

DOCUMENTATION TRANSMITTAL

To: Stone & Webster - CIO  
PO Box 1963  
Midland, MI 48640

Transmittal No: CIO- 0054  
Date: May 25, 1984

Attention: Ralph Butler

The documentation listed below \_\_\_ is provided herewith, X was previously provided on 5-22-84 ; as requested by Ralph Butler .

Documentation Description: Nonconformance Reports: C-03719-V  
C-03727-V

CIO \_\_\_ has X has not been placed on routine transmittal for the described documentation.

Joanne Kinne  
Signature

- CC RJCook, NRC Site (w/a, unless voluminous)
- JJHarrison, NRC Region III (w/a, unless voluminous)
- DDJohnson, SMO (w/o)
- JGKeppler, NRC Region III (w/a, unless voluminous)
- BHPeck, SMO (w/o)
- NIRichel, SMO (w/o)
- RAWells, MPQAD (w/o)
- CMThompson - File 24.2 (w/a, unless voluminous)

50-329  
336

MI0384-0001A-QL06

8406050313 840525  
PDR ADOCK 05000329  
S PDR

JUN 1 1984  
IE01

NONCONFORMANCE REPORT

**ORIGINAL**

16 NCR NO.	C-03727-V	
17 DATE ISSUED	5-12-84	18 REV 0
19	PAGE 1 OF 23 <sup>W/5-12-84</sup>	

1 ITEM LOCATION Aux. Bldg. Et. 597'-9"; 4'-N /FK TO FR ... 5.6 TO 7.4  
Mod. 120C, 120D, 120E

2 ITEM DRAWING/PART NO. C-36A-10-4

3 ITEM PART NAME STRUCTURAL STEEL & MISC. METAL

4 ITEM SERIAL NO. N/A

5 ITEM DESCRIPTION SEE ROLLOUT

6 ITEM STARTUP SYSTEM NO. 120C, 120D, 120E

7 REFERENCE DOCUMENT PQC C-2-10 REACT. 2.2-B  
FSK C-113 SHT. 1B/A <sup>2.5 B, 3.2-A</sup>

8 ASME A.R.I. REQUIRED  
 YES  NO

9 INSPECTION RECORD NO. V-C-2.10-2 LOG NO. V3206 REV NO. 0

10 RESPONSIBLE ORGANIZATION Construction

11 NONCONFORMANCE DISCOVERED DURING:  
 POST INSPECT  TURNOVER  DESIGN  RECEIVING  CONST  RELEASE FOR INSPECT  
 POST TURNOVER  PRE-OP TEST  FINAL TURNOVER  OVERINSPECT

- 12 REQUIREMENT ① AISC Pt. 5 1.23.2 Verify that all RE-entrant corners on Copes are shaped notch free to a radius of 1/2" ± 1/4 inch...
- ② C-304 (as Rev. 14 SCN 14001 para. 6.3.9 ... ARC STRIKES ARE ACCEPTABLE, providing the craters do not contain cracks as determined by visual examination.
- ③ C-304 para 5.2 Details ... shall be in accordance with dugs.
- ④ ABC, part 5 struct. joints 3(a) ... plate washers ... are required to cover <sup>W/5-11-84</sup> Long Slotted Holes.
- ⑤ AISC Pt. 5 struct. joints 3(a) ... plate washers ... are required to cover Long Slots.
- ⑥ C-304 para. 8.3... BURNING OF BOLT HOLES TO FINAL DIA. IS NOT ALLOWED.

- 13 NONCONFORMANCE ① BOLTED CONN. ② per rollout DOESN'T HAVE SUFFICIENT RADIUS ON COPE... BEAM 21B4R AND 21B6R ARE TOUCHING AT CENTER OF RADIUS.
- ② Conn. #3 HAS AN ARC STRIKE PRESENT ON A-325 Nut, EAST SIDE OF CONN.
- ③ Conn. #3 Calls for 1/4" cope on Bottom of BEAM. A 1 3/8" COPE EXISTS.
- ④ West side of Conn. 13A HAS Long Slotted Holes WITH NO WASHERS (ALSO EAST SIDE)
- ⑤ West side of Conn. 10A HAS Long Slotted Holes W/NO WASHERS.
- ⑥ HOLES in CLIP on Conn. 13A ARE BURNED TO FINAL DIA. WEST SIDE (TOP & BOTTOM) & EAST SIDE BOTTOM

14 NCR ORIGINATED BY (PERSON)  
D.G. STINSON <sup>W/5-12-84</sup> DATE

15 NCR ORIGINATED BY (DISCIPLINE)  
MPQAD-OC-CIVIL

20 NUMBER OF HOLD TAGS (IF APPLIED) 4

21 LOCATION OF HOLD TAGS ADJACENT TO CONNECTIONS.

22 POTENTIAL 50.58(a)  
 YES  NO

24 ACTION ITEM NO. 507908

25 ITEM PRIORITY CODE NO. 1

26 NCR REVIEWED BY: William E. Gange

23 REPORTED TO MPQA MANAGER DATE N/A

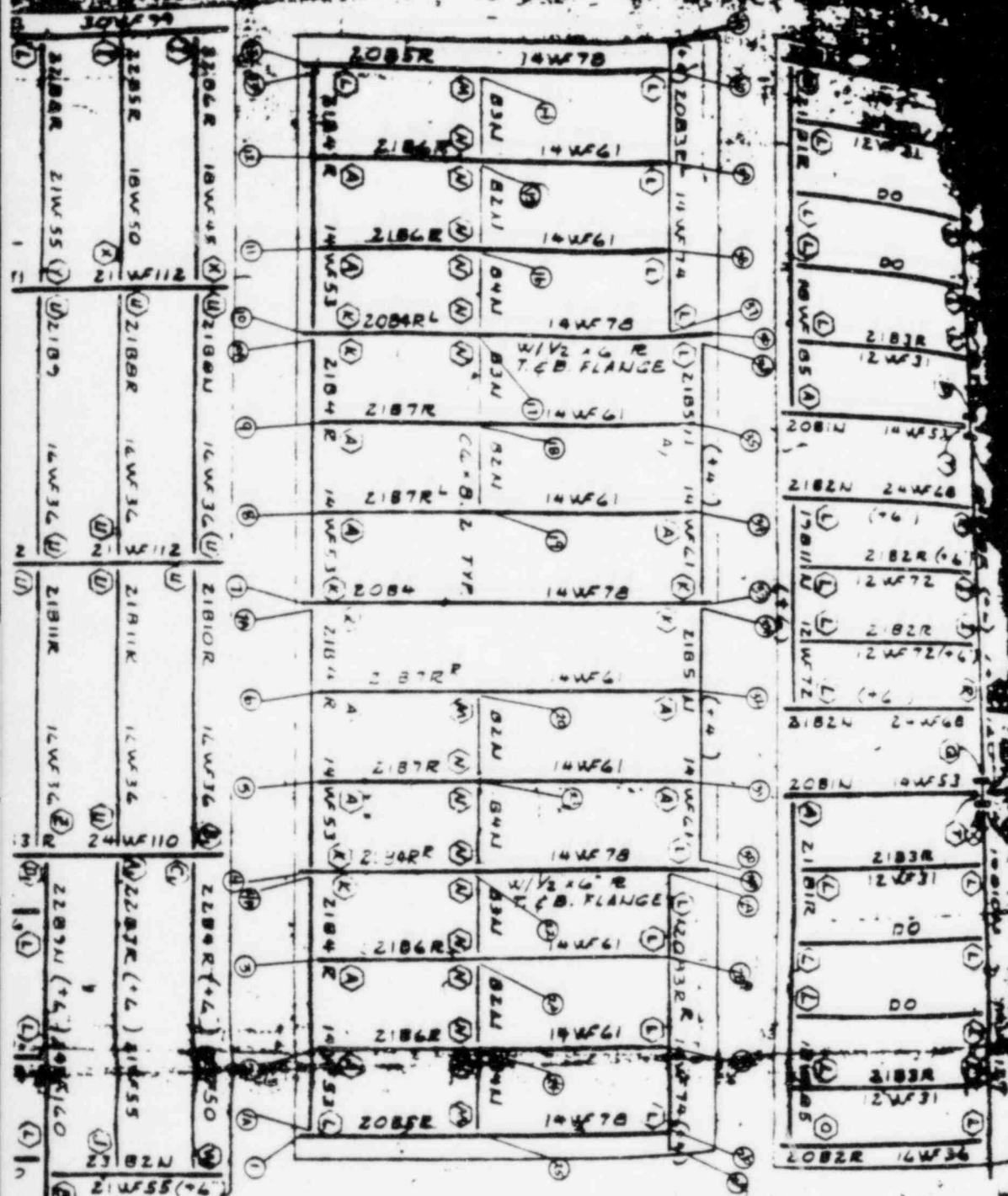
25 DISCIPLINE: S

TREND CODE  
CC-30001 CC-10002  
CC-20001  
CC-40002

DATE: 5/12/84

CONTINUED ON REVERSE

# ORIGINAL



## Q.C. ROLL OUT

Page 3 of 3

FROM PSK - C-113 SHT 18

QCIR # V-C-2 10-2

Log # V3206

CONT. ON P. 1 - OF 3

ATTACHMENT TO WORK  
C-03727-V  
REV 0

2.597.3 U.N.

2.597.3 U.N.

2.597.3 U.N.

5/11/84

16 MCR NO. C-03719-V		17 DATE ISSUED 5/11/84		18 REV 0	
19 PAGE 1 OF 41		<h1 style="text-align: center;">ORIGINAL</h1> <h2 style="text-align: center;">NONCONFORMANCE REPORT</h2> <p style="text-align: right;">DEPARTMENT QUALITY ASSURANCE BOARD PROJECT</p>			
1 ITEM LOCATION Structural Floor Framing, Aux Bldg., 5.6-7.4 ± F - E, T.O.S. 597'-9", Rms. 117, 118 & 119					
2 ITEM DRAWING/PART NO. C-224 rev 7		3 ITEM PART NAME Structural Steel			
4 ITEM SERIAL NO. N/A		5 ITEM DESCRIPTION Welded Connections of Structural Floor Framing			
6 ITEM STARTUP SYSTEM NO. M.D. A120CA120, A120E		7 REFERENCE DOCUMENT See Continuation Sht.			
8 ASME A.N.1. REQUIRED <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		9 INSPECTION RECORD NO. U-CW-100-15			
10 RESPONSIBLE ORGANIZATION Construction		REV NO. 0		LOG NO. U3735	
11 NONCONFORMANCE DISCOVERED DURING: <input type="checkbox"/> DESIGN <input type="checkbox"/> RECEIVING <input type="checkbox"/> CONST <input type="checkbox"/> RELEASE FOR INSPECT <input type="checkbox"/> POST INSPECT GVP <input type="checkbox"/> TURNOVER <input type="checkbox"/> POST TURNOVER <input type="checkbox"/> TEST <input type="checkbox"/> PRE-OP <input type="checkbox"/> FINAL TURNOVER <input type="checkbox"/> OVERINSPECT					
12 REQUIREMENT #1 GWS Structural 4/4.2 Defects in excess of the applicable acceptance standards shall be removed and repaired.					
13 NONCONFORMANCE #1 Unacceptable Base Metal Defects.					
<p>#2 Slag not cleaned from welds</p> <p>#3. welded vertical down</p> <p>#4 welder qualification indeterminate</p> <p>#5 Required weld omitted / Does not conform</p> <p>#6 Cracked Temporary weld</p> <p>#7 Undermin Fillet leg size</p> <p>#8 Overrun Fillet leg size</p> <p>#9 Undermin Fillet weld lengths</p> <p>#10 Underfill Butt welds</p>					
14 MCR ORIGINATED BY (PERSON) Mark A. Winkler		15 MCR ORIGINATED BY (DISCIPLINE) MCRAD / Civil			
DATE 5/11/84		DATE 5/12/84			
20 NUMBER OF HOLD TAGS (IF APPLIED) 19		21 LOCATION OF HOLD TAGS 5.6-7.4 ± F - E			
22 POTENTIAL 50.55(e) <input checked="" type="checkbox"/> YES <input type="checkbox"/> NO		24 ACTION ITEM NO. 507800		26 ITEM PRIORITY CODE NO. 1	
23 REPORTED TO MPOA MANAGER N/A		25 DISCIPLINE: S		27 TREND CODE GG-40018 GG-20048	
DATE		DATE 5/12/84		28 MCR REVIEWED BY: William J. Damp	



29 CAUSE

30 PROCESS CORRECTIVE ACTION

YES  NO QAR NO. \_\_\_\_\_

31 RECOMMENDED DISPOSITION

REMARK  SCRAP/REJECT  REPAIR  USE AS IS

32 CONDITIONAL RELEASE

YES  NO

31A ADDITIONAL INFORMATION

33 DISTRIBUTION FOR ACTION

34 DISPOSITION CONCURRENCE

\_\_\_\_\_  
PROJECT FIELD ENGINEER      DATE

\_\_\_\_\_  
MPQAD CONCURRENCE      DATE

\_\_\_\_\_  
PFQCE (ASME)      DATE

\_\_\_\_\_  
PQAE (ASME)      DATE

\_\_\_\_\_  
LEAD DESIGN ORG      DATE

\_\_\_\_\_  
CP Co SMO (for turned over systems)      DATE

\_\_\_\_\_  
A.N.I. (ASME)      DATE

35 DISPOSITION ACTION TAKEN

36 METHOD OF DISPOSITION ACTION VERIFICATION

RESULT OF DISPOSITION ACTION VERIFICATION

ACCEPTABLE  UNACCEPTABLE

IF UNACCEPTABLE, REFERENCE  
SUPERCEDING NCR NUMBER \_\_\_\_\_

37 NCR CLOSED BY

\_\_\_\_\_  
MPQAD      DATE

\_\_\_\_\_  
A.N.I. (ASME)      DATE

Block 7 cont.

Reference Documents: AWS D1.1 Spec C-304 rev 14, GWS Structural G-27 rev 21,

Dwgs. C-224 rev. 7, C-223 rev. 5, C-244 rev. 15, FSK-C-113 sht 10, 11, 12, 19

Vendor Dwgs. C36A-10-4, C36A-3-6, C36A-9(2)15, C36A-9(2)14

PQCI CW-100 rev 6 Oct. 3.1 + 3.3

Block 12 cont. #5 AWS D1.1 6.5.1 Location of all welds conform to the requirements of the detail Drawings, that no specified welds are omitted.

#6 AWS D1.1 8.14 Temporary welds shall be subject to the same welding procedure requirements as the final welds.

#7 C304 6.2.1a: AWS D1.1 B.15.1.6 Fillet welds in any single continuous weld shall be permitted to underrun the <sup>max/min</sup> nominal fillet size required by  $\frac{1}{16}$ " without correction provided that the undersize weld does not exceed 10% of the weld length.

#8 C304 6.2.1b Maximum overrun for either or both fillet weld legs shall not exceed  $+\frac{3}{16}$ "...

#9 C304 6.2.1d Maximum overrun for fillet weld lengths shall not exceed  $\frac{1}{8}$ " for End returns and  $\frac{1}{4}$ " for all other welds.

#10 C304 6.2.2 Butt welds shall be slightly convex...

#11 C304 6.2.3 Undercut shall not exceed  $\frac{1}{32}$ "...

#12 C304 6.2.5a Field welding of the web framing <sup>angle</sup> to the supporting member, end returns limited to a maximum of twice the specified weld size  $+\frac{1}{2}$ ".

#13 C304 ~~5.5.5~~ Surface Defects shall Not exceed  $\frac{1}{16}$ "

Block 13 cont #10 Full penetration welds under fit. <sup>max</sup>  $\frac{1}{16}$ "

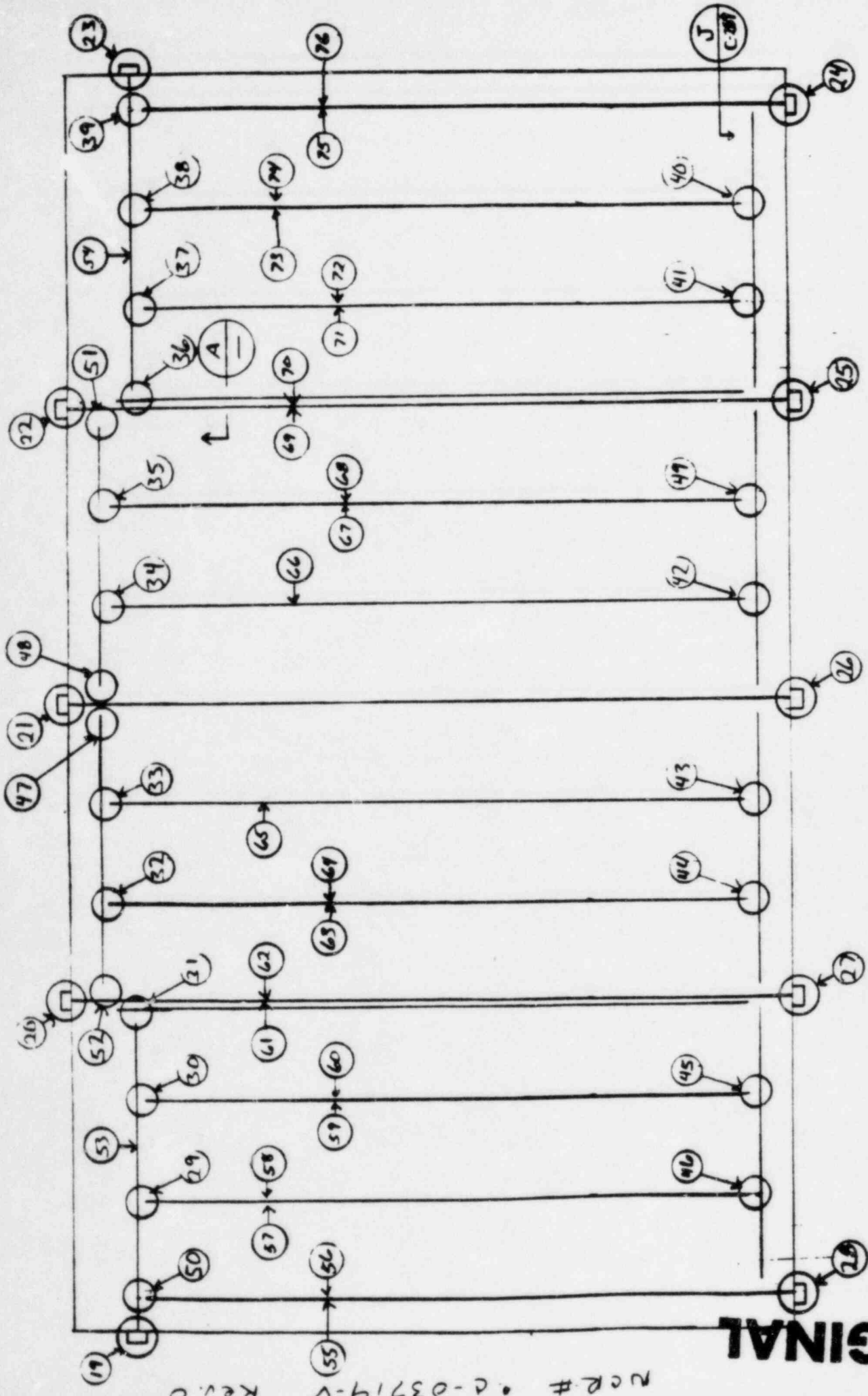
#11 Undercut exceeds acceptable tolerances.

#12 End return lengths exceed <sup>max/min</sup> tolerance

Note: See Attached sketches for detail. <sup>max</sup>  $\frac{1}{16}$ "

#13 Base metal Defects exceed  $\frac{1}{16}$ "

Note: See Attached sketches for detail

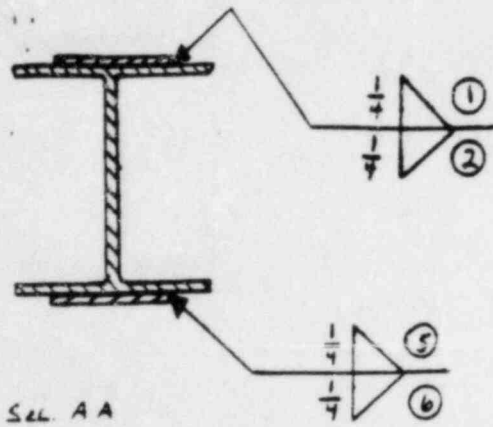


NCR# • C-03719-V Rev. 0

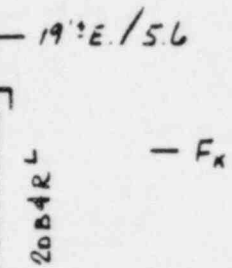
**ORIGINAL**

Ref. C-224 rev. 7 & FSK-C-113 SH-18 rev. 3

pg 4 of pg 41



1/2" x 6" R  
Top & Bot.



**ORIGINAL**

① & ② D11A Embedded in Concrete

⑤ WELDER ID I-27 \* MEASUREMENTS WITH RESPECT TO NORTH END OF R

- # 1 1ST FT. INSUFFICIENT THRDT 9/32" LONG
- # 2 2ND FT. UNDERSIZE LEG
- # 3 3RD FT. UNDERSIZE LEG
- # 4 4TH FT. UNDERSIZE LEG

EXCEEDS TOTAL LENGTH PERCENTAGE CRITERIA

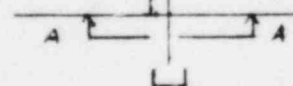
⑥ WELDER ID I-40

\* MEASUREMENTS WITH RESPECT TO SOUTH END OF R

- # 5 3RD FT. OVERSIZE LEG 1/2" ACTUAL FOR 1/4"
- # 6 4TH FT. OVERSIZE LEG 1/2" ACTUAL FOR 1/4"
- # 7 5TH FT. OVERSIZE LEG 1/2" ACTUAL FOR 1/4"
- # 8 6TH FT. OVERSIZE LEG 1/2" ACTUAL FOR 1/4"
- # 9 7TH FT. OVERSIZE LEG 1/2" ACTUAL FOR 1/4"
- # 10 8TH FT. OVERSIZE LEG 1/2" ACTUAL FOR 1/4"

- # 11 3RD FT. BASE METAL DEFECT IN R
- # 12 1/8" DEEP, 1/4" LONG, 9/16" FROM THE
- # 13 EDGE OF THE R

9'6"  
EMBEDDED IN CONCRETE  
8'



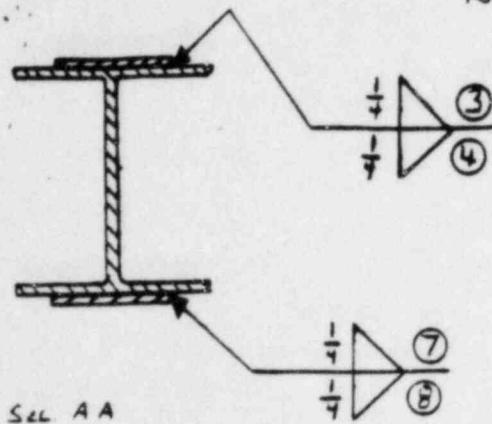
- F<sub>x</sub>

NOTE: DWG. N.T.S.



Note: Inspected in 12" increments

No SCALE



1/2" x 6" R  
Top & Bot.

19 1/2" W. / 7.4

20B4R

- F<sub>K</sub>



**ORIGINAL**

③, ④ D11A Embedded in Concrete

⑦ welder ID, I-27, I-19, I-41

D11A 1<sup>st</sup> 7' Insufficient space to perform inspections

D11A 8<sup>th</sup> to 9 1/2 ft. Embedded in concrete

#11 10<sup>th</sup> ft Undercut > 1/32" exceeding 2" in 12"

#7 15<sup>th</sup> ft Over size leg 1/2" actual size for 1"

#1 Crack in Base metal adjacent to toe of weld @ ≈ 14" from start point.

⑧ welder ID I-19, I-27

D11A 1<sup>st</sup> ft Due to structural supports for Fan

#11 3<sup>rd</sup> ft Undercut > 1/32" exceeds length tolerance.

D11A 4<sup>th</sup> ft last 3" } Structural Supports for Fan

D11A 5<sup>th</sup> ft first 5" }

D11A 8<sup>th</sup> ft

D11A 9<sup>th</sup> ft first 6"

#11 12<sup>th</sup> ft Undercut > 1/16" for 3/16"

9 1/2

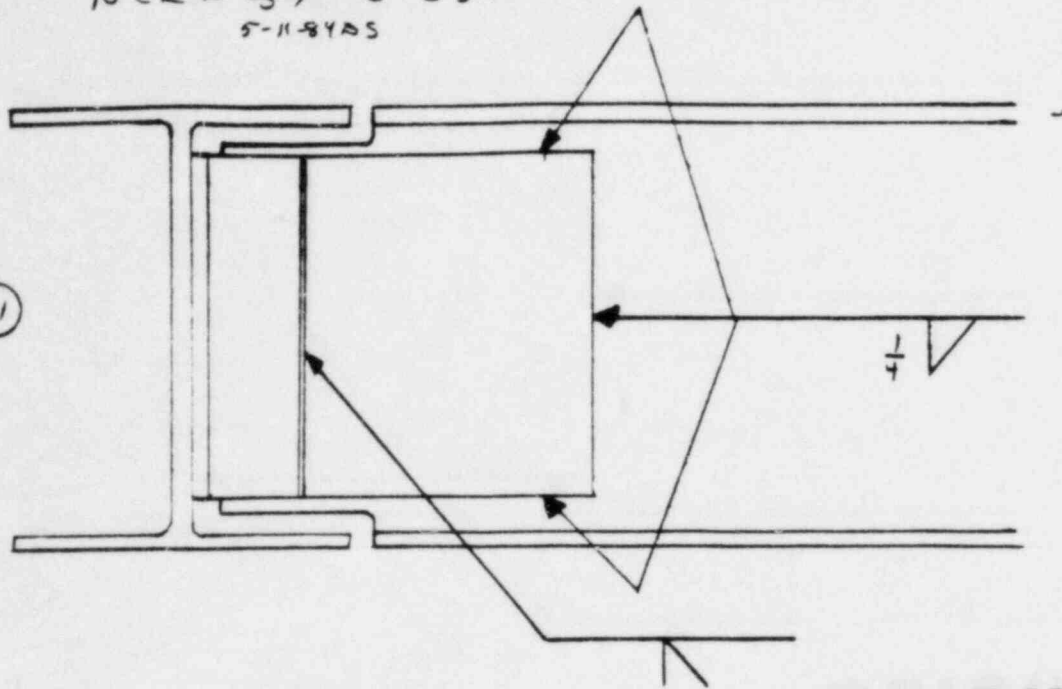
Embedded in Concrete Wall

8

Start — A — A

- F<sub>x</sub>

Joint # 11



**ORIGINAL**

Ref. Sec J C-289

South Side ID I-27

Vert. Fillet No comments

Due to limited space unable to measure rest of weld.

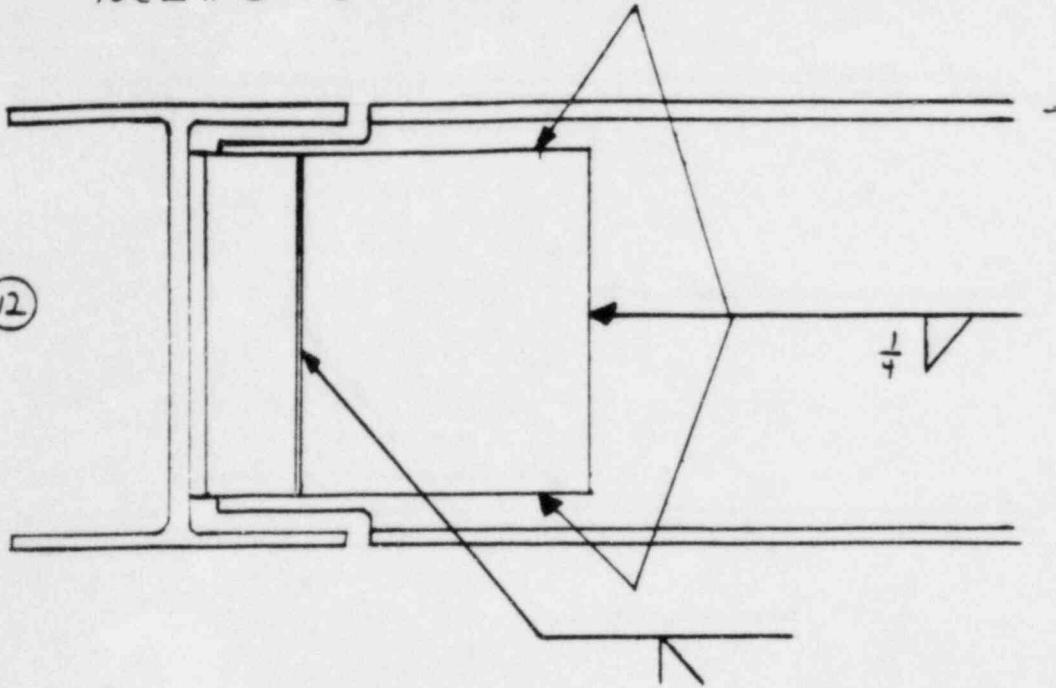
#10 Full Pen. Flush contour

North Side ID I-27

Fillets Consumed Edges

#10 Full Pen. under fill (concave contour)

Joint # 12



South Side

#10 Full Pen Flush Contour  
ID I-24

Fillets ID I-40

Consumed Edge of Base Metal

#7 1 leg Oversize 1/2" actual

North Side ID I-24

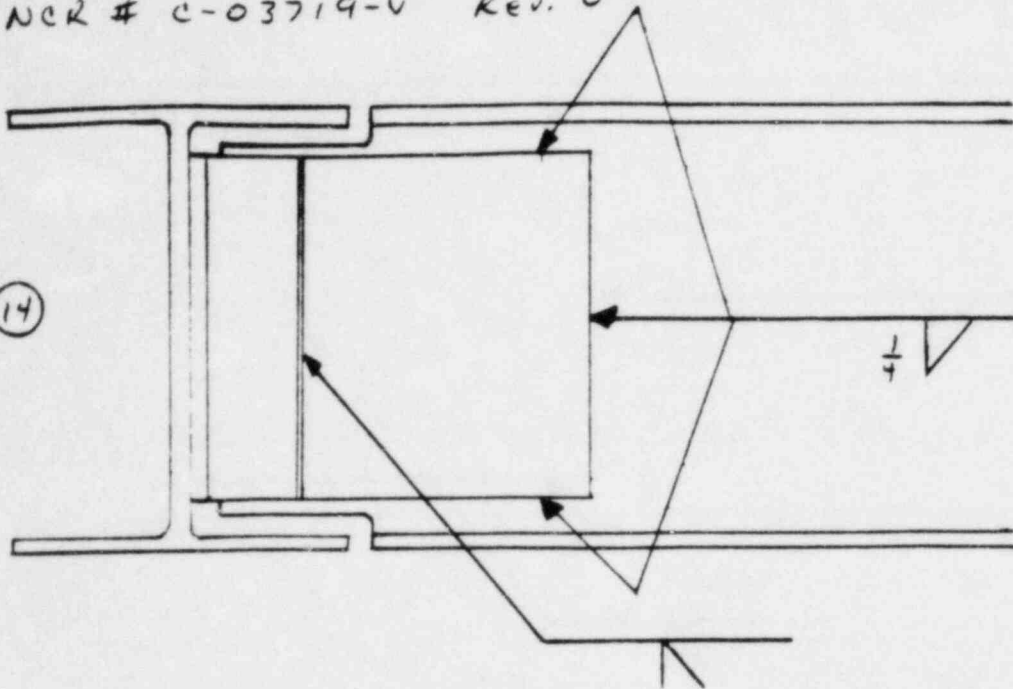
#10 Full Pen Flush Contour

Fillets Consumed Edge of Base Metal

#7 1 leg oversize 5/8" actual (all welds)

NCR # C-03719-V Rev. 0

Joint # (14)



Ref. Sec J C-289

**ORIGINAL**

South Side ID I-32

#10 Full Pen. Flush Contour

Fillets Top Fillet unable to measure. Leg size due to limited space.

Other Fillets No comment

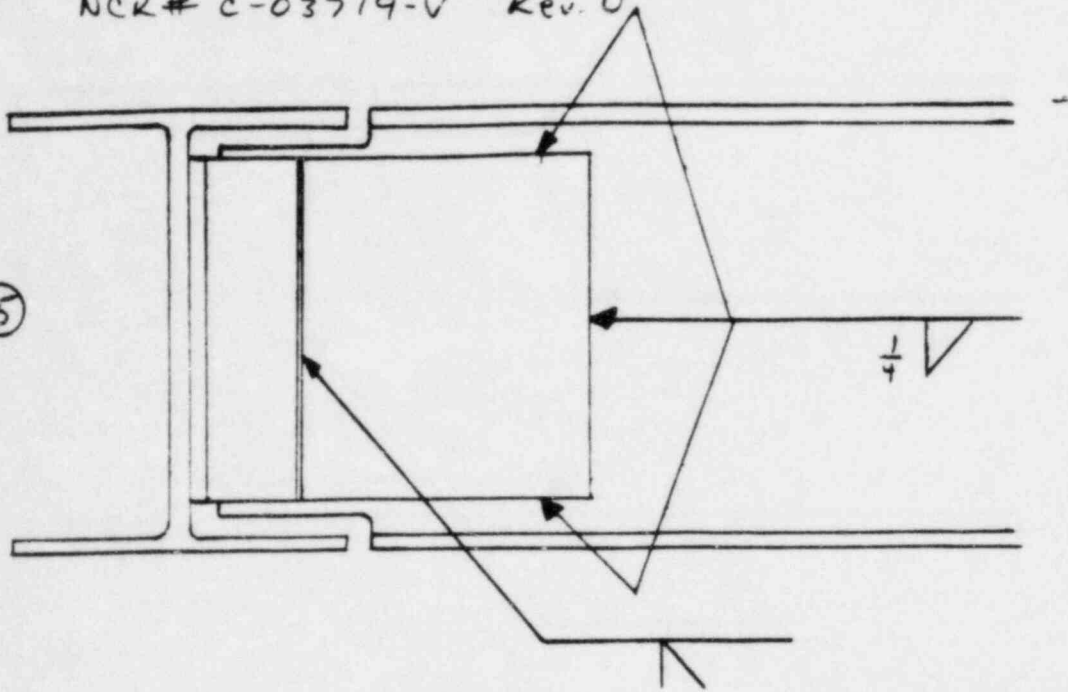
North Side ID I-32

#10 Full Pen. Flush Contour

Fillets No comments



Joint # 15



Ref. Sec. J C-289

**ORIGINAL**

South Side

\*4 #10 Full Pen. Slightly Concave, No welder ID

Fillets ID I-24

Consumed Edge of Base Metal

#8 1 leg oversize 5/8" + actual (all Fillets)

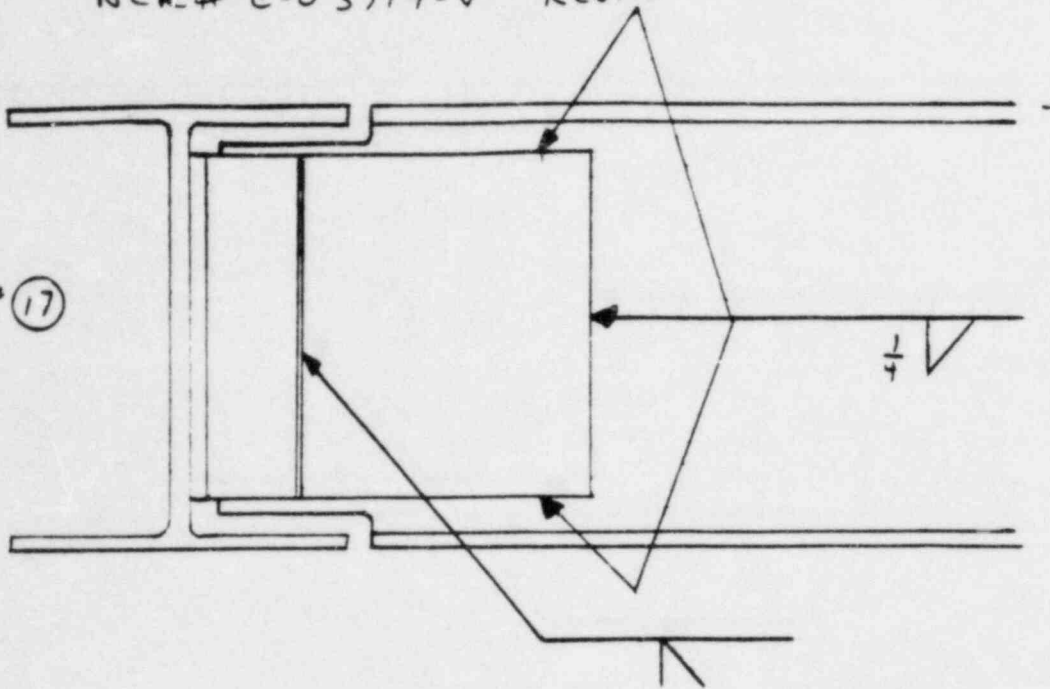
North Side ID I-24

#10 Full Pen Flush to Slightly Concave Contour

Fillets Top Fillet consumed Edge of Base Metal

#8 Vert. & Bot. Fillets 1 leg Oversize 5/8" + Actual

Joint # (17)



Ref Sec J C-289

**ORIGINAL**

South Side ID I-33<sup>ms 1718</sup> 17

Full Pen No Comments

Fillets Consumed Edge of Base Metal

#8 1 leg Oversize 5/8" actual (all Fillets)

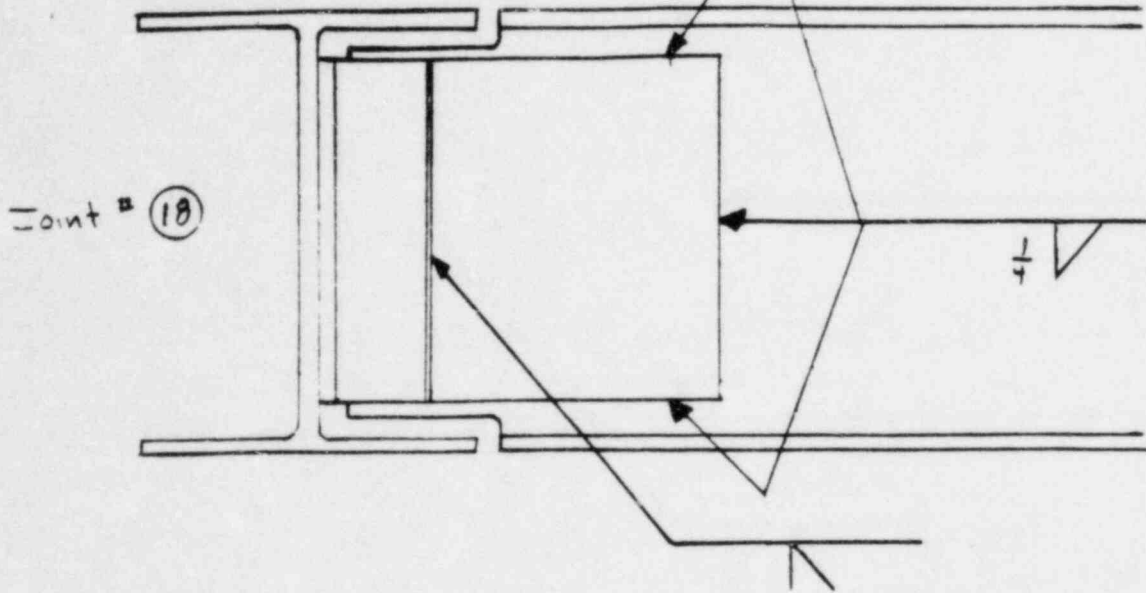
North Side ID I-33

#10 Full Pen. Slightly Concave

Fillets Consumed Edge of Base Metal

#8 1 leg Oversize 5/8" actual (all Fillets)

NCR# C-03719-V Rev. 0



Ref. Sec J L-289

**ORIGINAL**

South Side 011A

Insufficient access for inspection

North Side IO-I-32

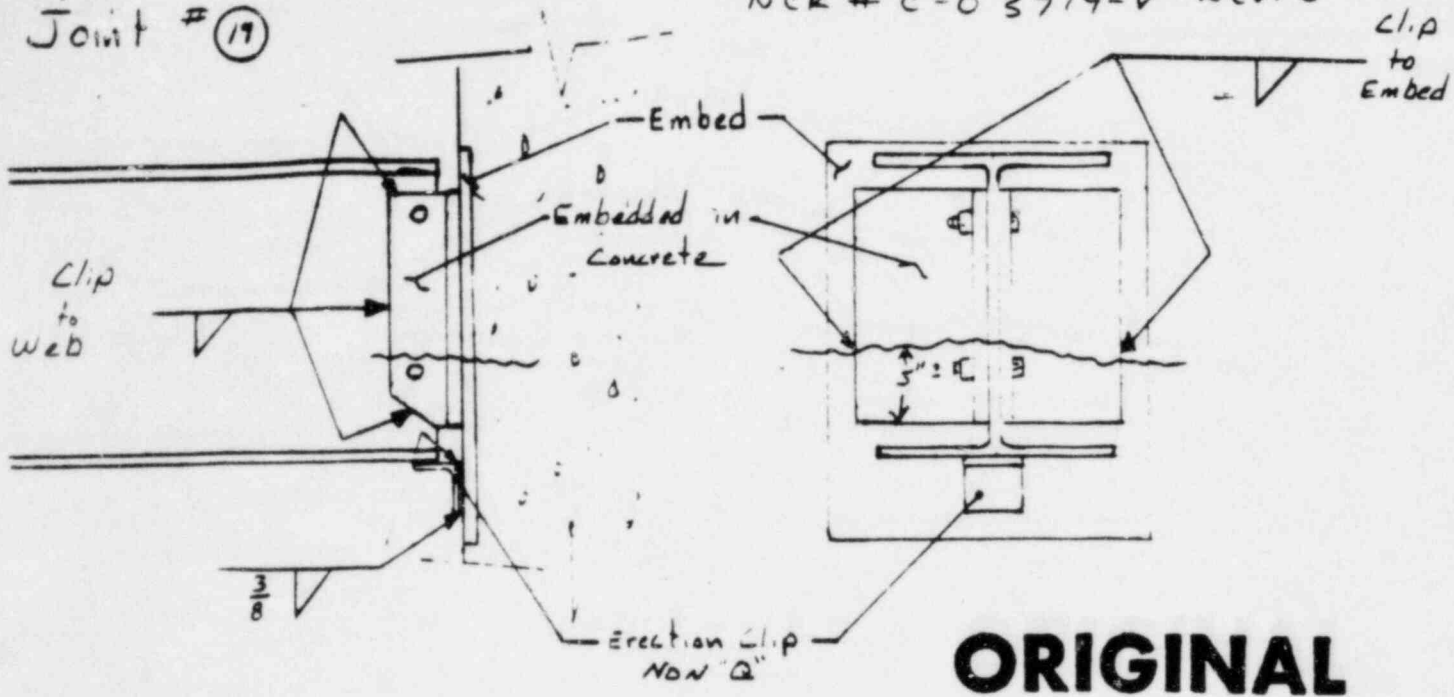
#10 Full Pen. Smooth Contour (Ground Flush)

Fillets Consumed Edge of Base Metal

#8 Oversize legs 5/8" actual

Joint # 19

NCR # C-03719-V Rev. C



**ORIGINAL**

Ref. FSK-L-113 SH 13 NO SCALE

Top weld of erection clip, Check for Base Metal Defects D11A

Bottom weld of erection clip, Base Metal No Comments

South Side IO D11A

Fillets No Comments

#5 No Bottom End returns

5" inspected, Remainder D11A

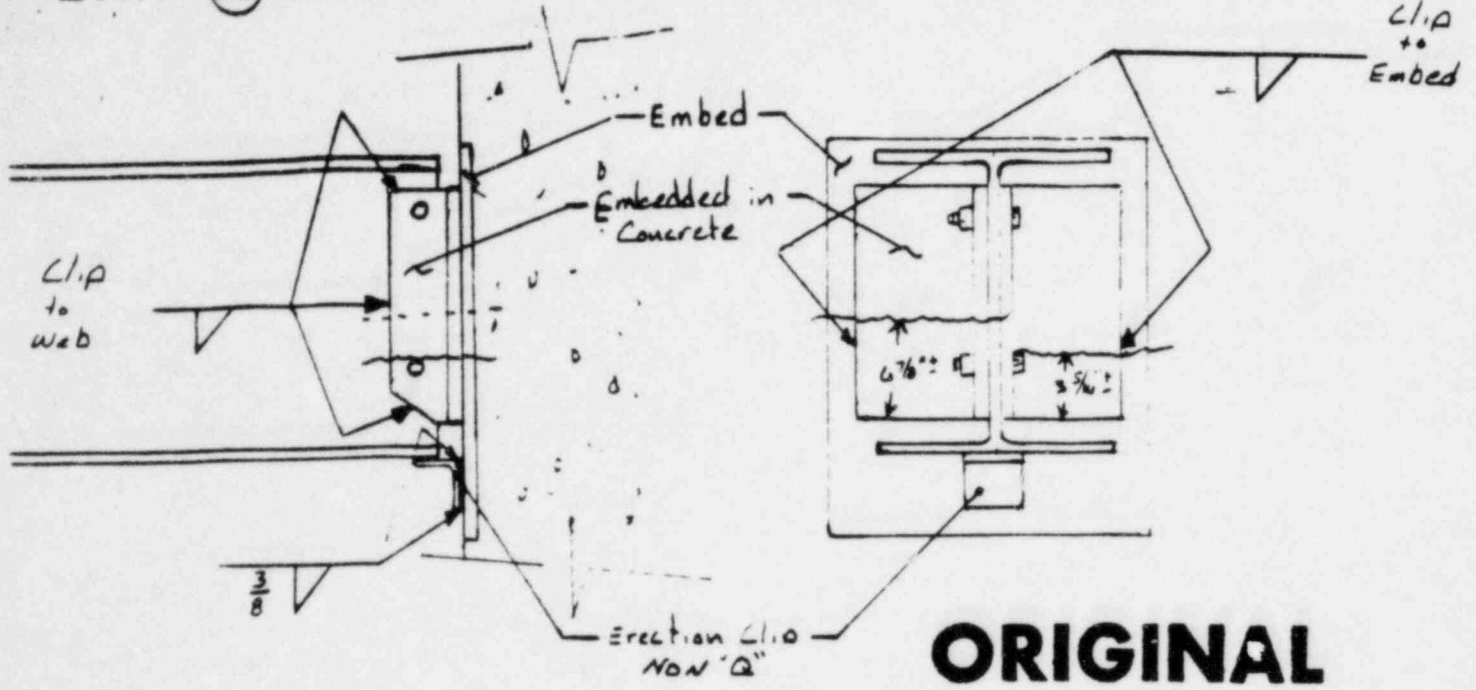
North Side IO D11A

Fillets ~~No Comments~~ <sup>now</sup> clip to web, Diag. Consumed Edge of Base Metal

#5 No Bottom End return

5" inspected Remainder D11A





**ORIGINAL**

Ref. FSK-L-113 sht. 1B NO SCALE

Top weld of erection clip, check for Base Metal Defects DIIA  
 Bottom weld of erection clip, Base Metal No Comments

Welder ID DIIA

West Side Inspected 6 7/8" of weld remainder DIIA

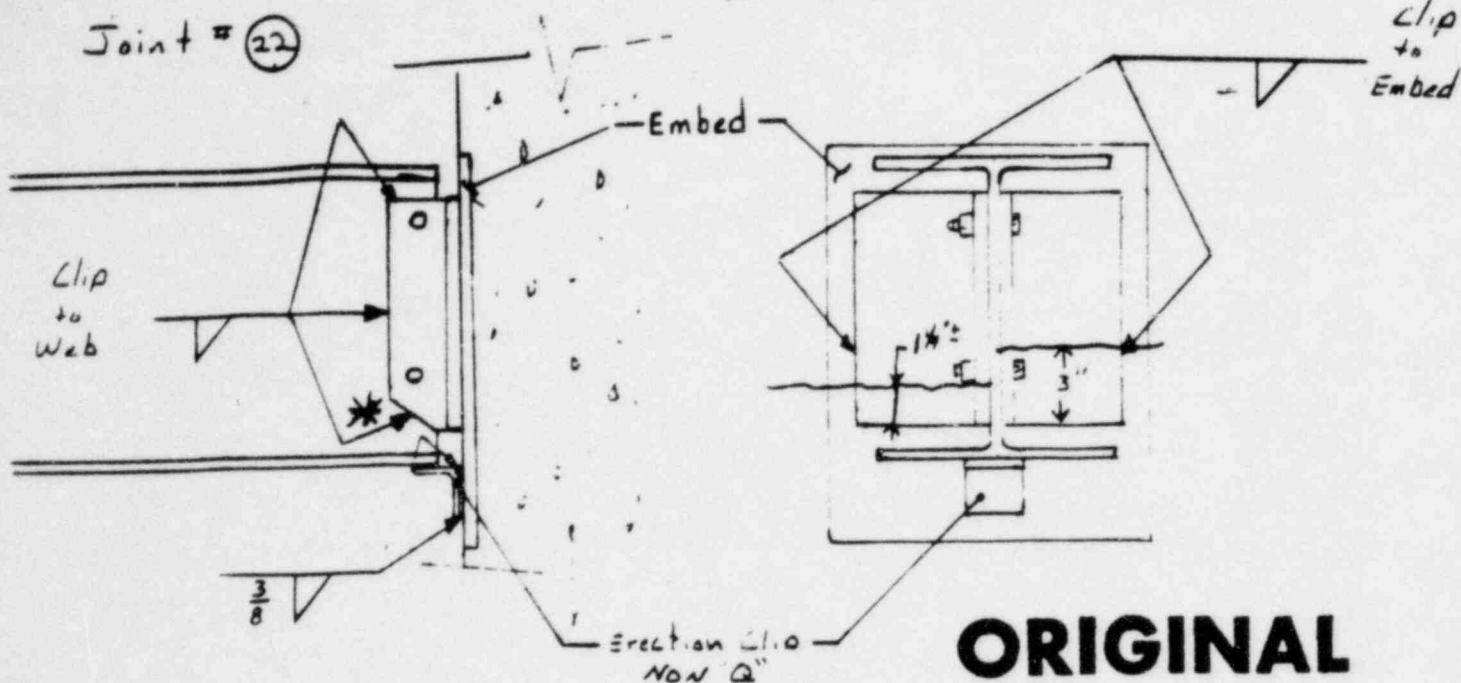
#5 No Bottom End

East Side Inspected 3 5/8" of weld remainder DIIA

#5 No Botto return

Joint #21 DIIA unable to Inspect Due to Congestion of conduit & cable trays.

Joint # 22



**ORIGINAL**

Ref FSK-C-113 SH 1B NO SCALE

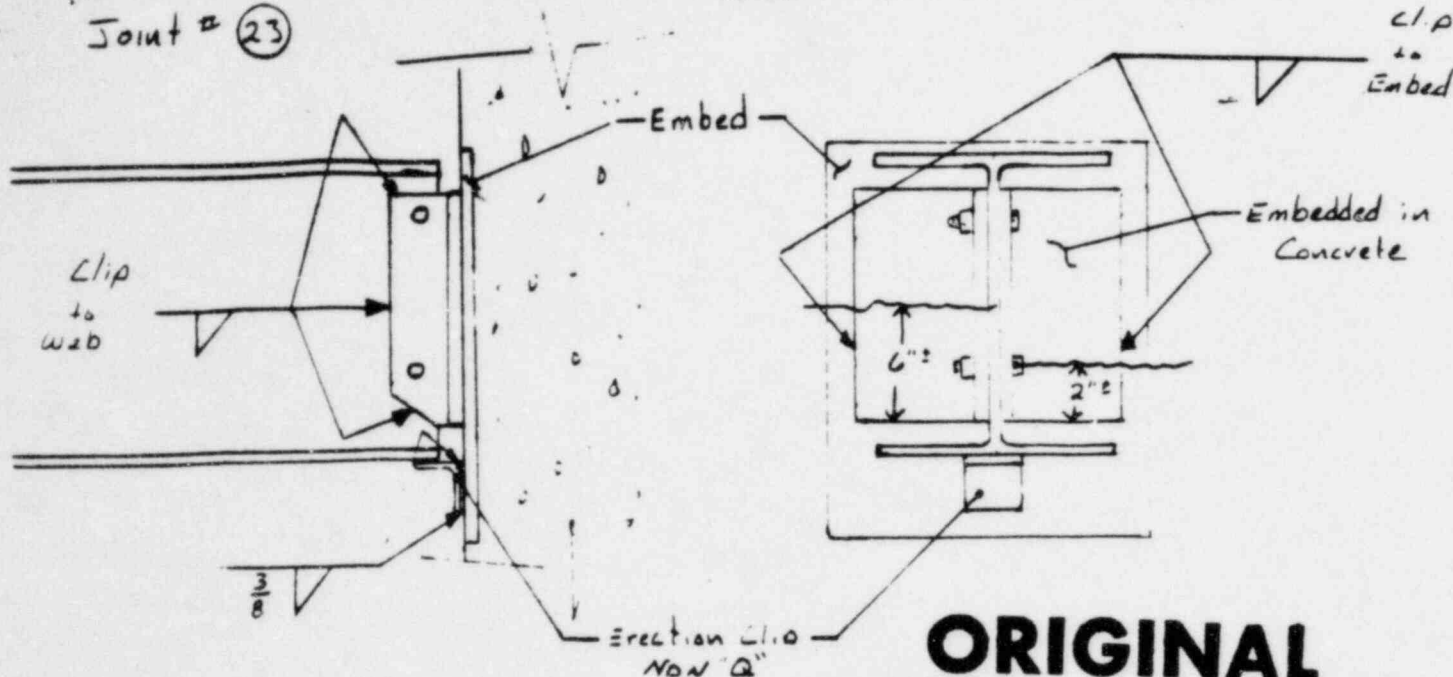
Top Weld of erection clip, check for Base Metal Defects D11A  
 Bottom weld of erection clip. No Comments  
 welder IO D11A  
 West Side Fillets no comments  
 Inspected 1/4" of weld remainder D11A

East Side

Inspected 3" remainder D11A

Clip to web undersize 100% of weld length  
 #2 #7 Insufficient Throat 100% of weld length  
 Slag along toe of weld } Diag. weld Only\*

Joint # 23



Ref. FSK-L-113 Sht. 1B No Scale

Top Weld of erection clip, check for Base Metal Defects, D11A  
 Bottom Weld of erection clip, Base Metal No Comments

Welder ID D11A

South Side

Clip to Web D11A (Embedded in concrete)

Clip to Embed Inspected 2" : Remainder D11A

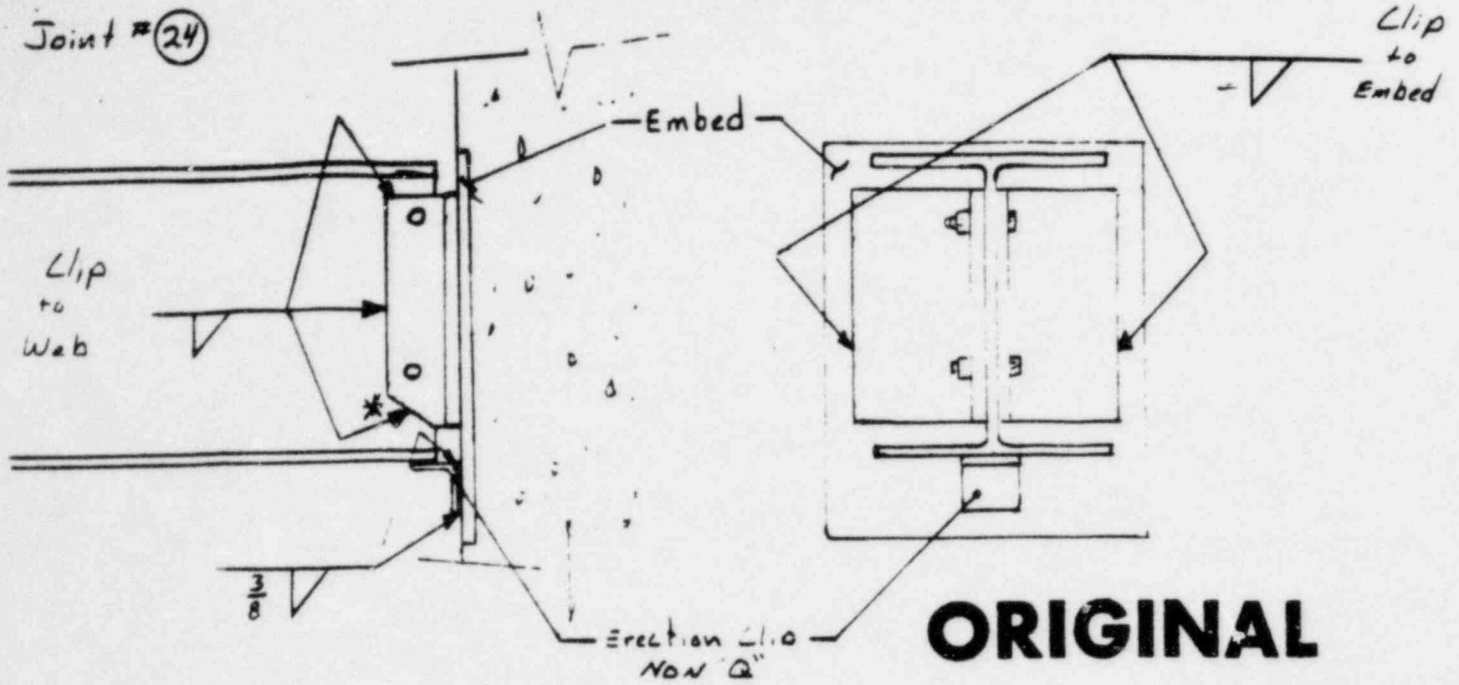
North Side

Clip to Web D. #3. Weld. #2 #7  
 1/16" Undersize 40% of weld length  
 Slag along toe of weld

Clip to Embed Inspected 6" : Remainder D11A

#2 Slag along Toe of Weld (End Return)

Joint #24



**ORIGINAL**

Ref FSK-C-113 sht. 18 NO SCALE

Top weld of erection clip, check for Base Metal Defects D11A  
Bottom weld of erection clip, Base Metal No Comments

West Side Welder ID I-17

#2 Clip to web slag along toe of Diag. Weld

Clip to Web & Clip to Embed weld sizes D11A  
Insufficient access to perform measurements

East Side Welder ID I-17

Clip to Web Diag. Weld \*

#7 Insufficient Throat & Both legs Undersize 1/8" 100%  
#2 Slag along toe of weld

Clip to Embed Bottom End return Undersize leg

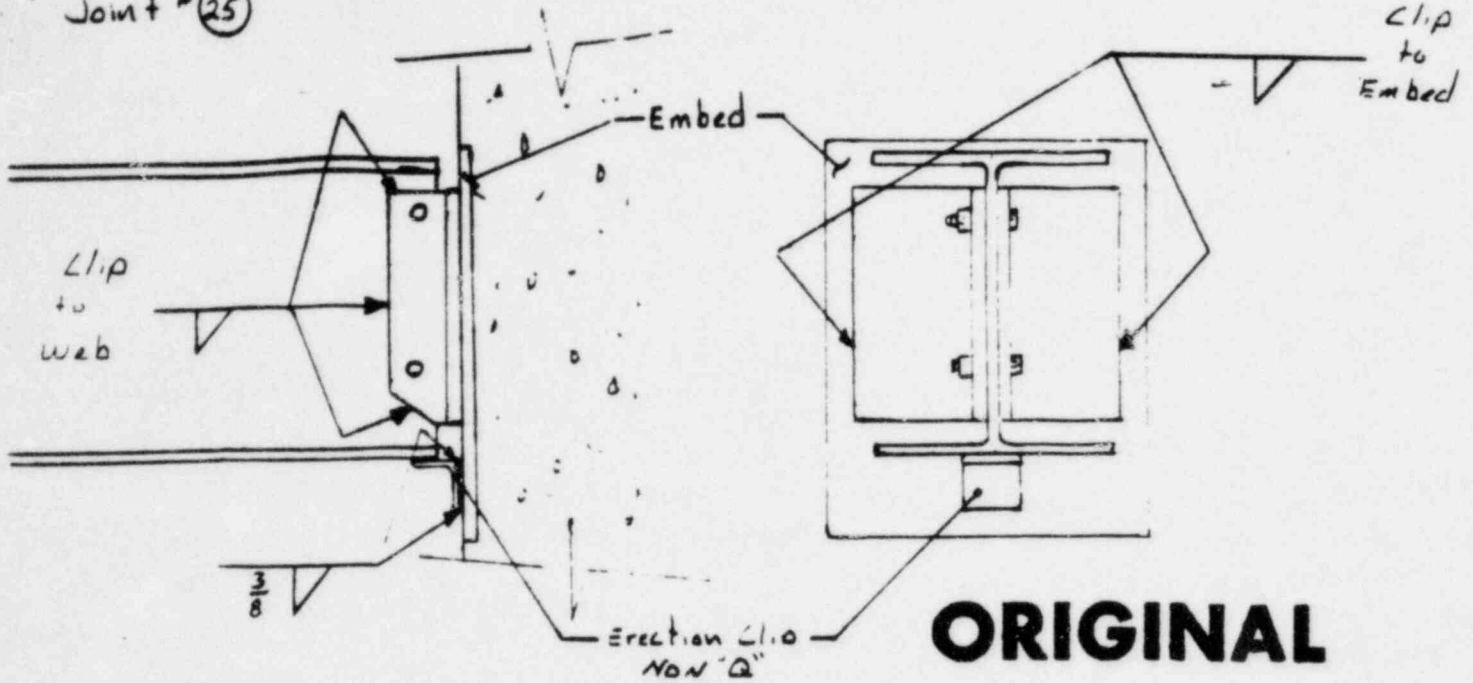
#2 Slag along toe of weld  
#7



Joint # 25

NCR # C-03719-V

Rev. 0



Ref. FSK-C-113 sht. 1B NO SCALE

Top weld of erection clip, check for Base Metal Defects D11.A

Bottom weld of erection clip, Base Metal No comments

~~West~~ <sup>new</sup> ~~East~~ Side D11A Embedded in concrete

#4 East Side No welder ID

Clip to Beam web

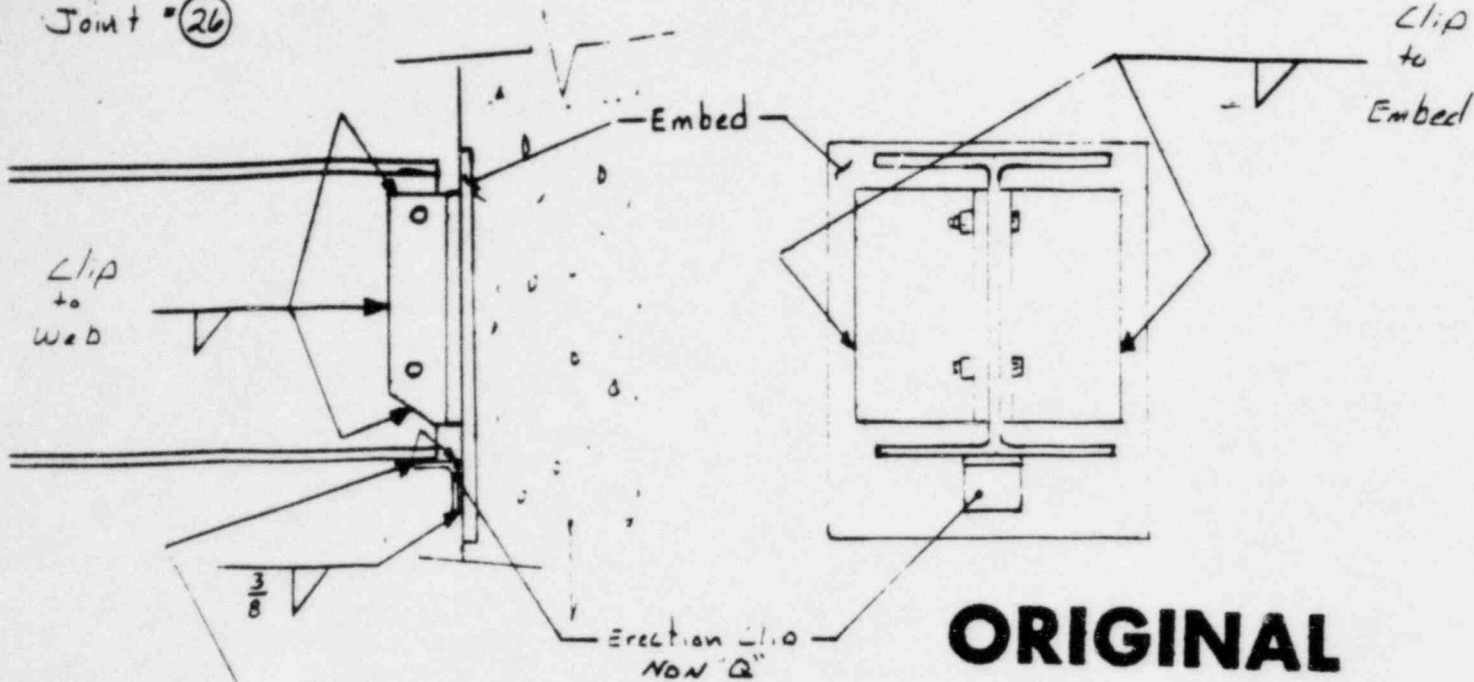
#11 <sup>new</sup> Diag weld under cut > ~~1/32~~ 1/32", 40% weld length

Clip to Embed welder ID I-40

#5 No Bottom End return

#12 Top End return 3" long

Joint #26



**ORIGINAL**

Ref FSK-C-113 Sht 1B NO SCALE

Top weld of erection clip, check for Base Metal Defects, D11A

Bottom weld of erection clip, Base Metal No comments

Tack weld erection clip to Flange of Beam cracked

IIIe

West Side welder ID I-41

Clip to Embed

#5 No Bottom End return

Top End return D11A

Clip to web

Top Horz Weld Leg Sizes D11A

Diag. weld  $\frac{5}{8}$  consumed Edge of Base metal

East Side welder ID I-41

Clip to Embed

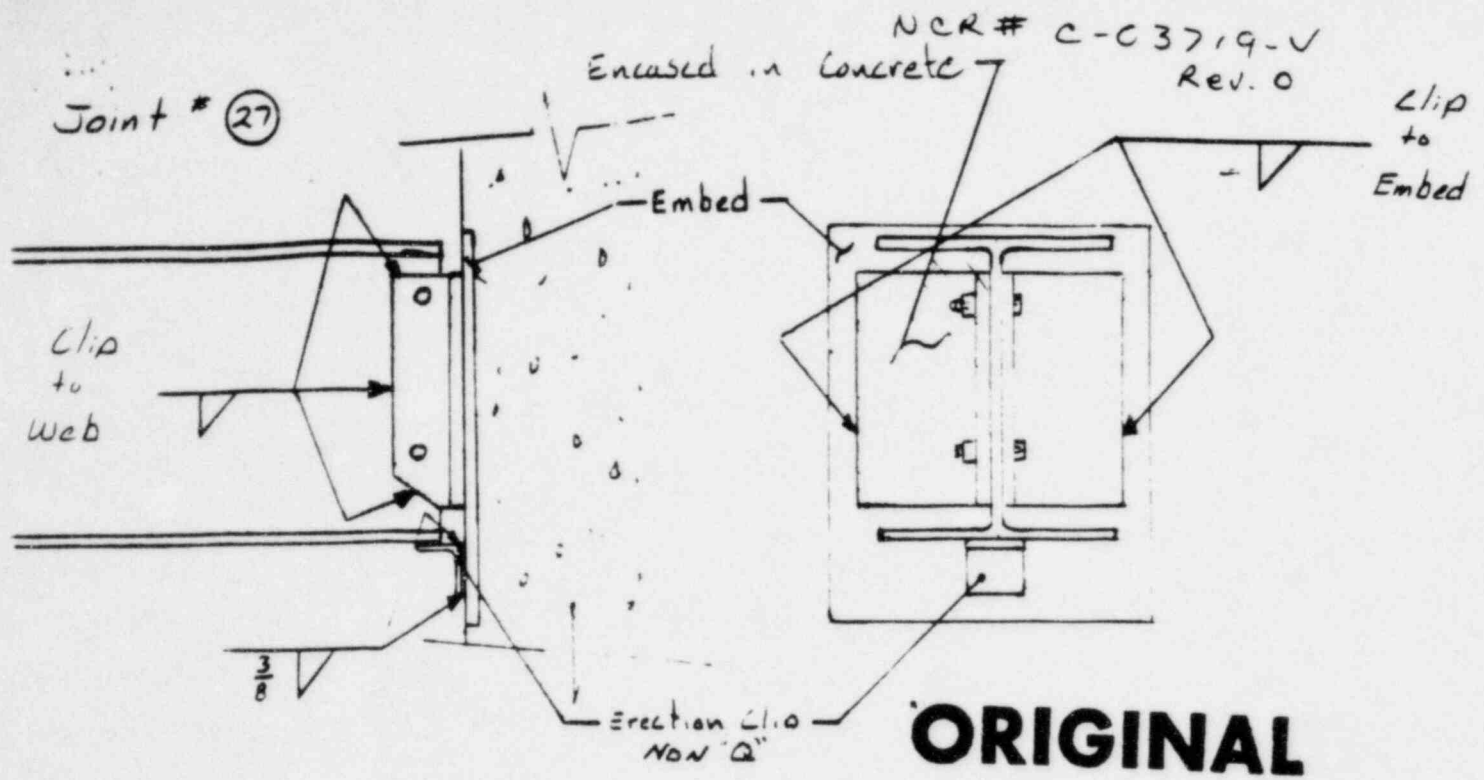
#5 No Bottom End Return

#9 Top End Return  $\frac{1}{2}$ " in length

Clip to web

Top Horz. Weld, leg Sizes D11A

Joint # (27)



Ref FSK-C-113 sht 1B NO SCALE

Top weld of erection clip, check for Base Metal Defects D11A  
Bottom weld of erection clip, Base Metal No Comments

East Side D11A Encased in concrete

West Side

Clip to web welder ID I-29

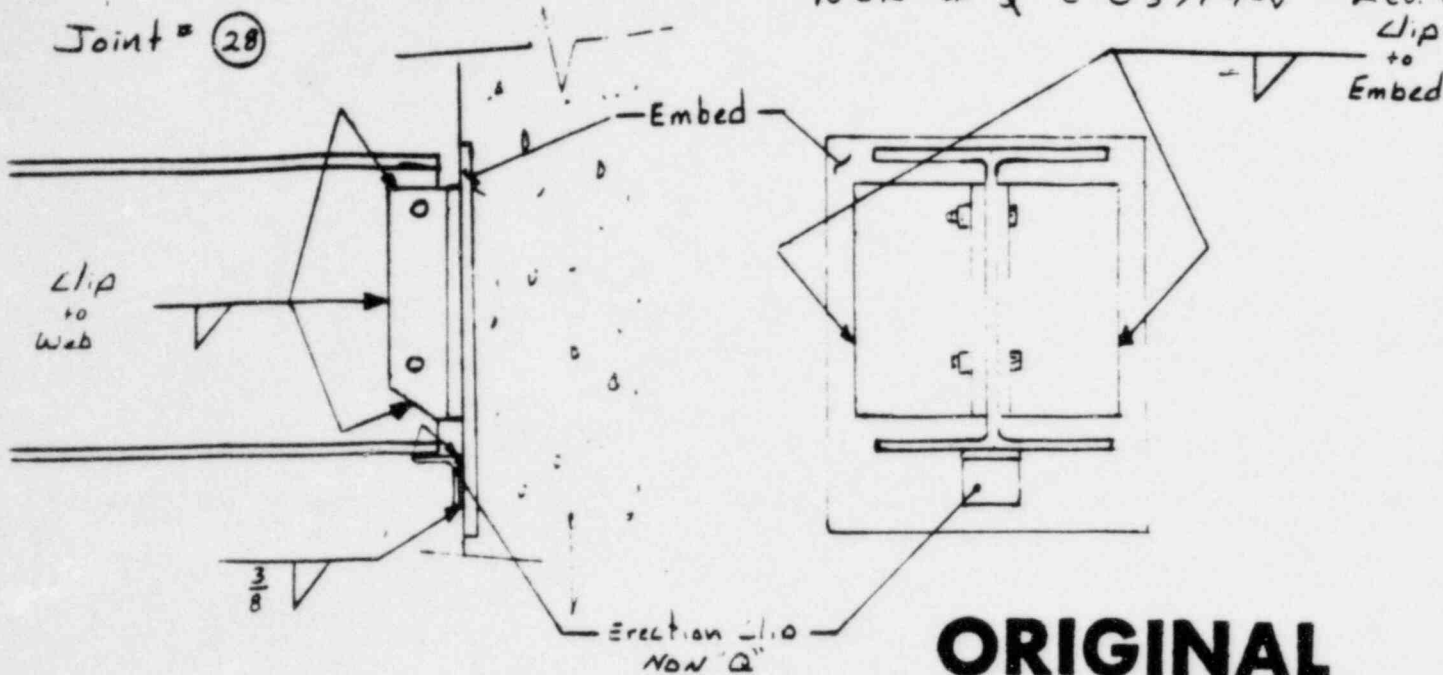
#7 Diag. weld undersize 100% 5/16" actual

Clip to Embed welder ID I-29

#5 No Bottom End return  
Top End return D11A

Joint = (28)

NCR # 5-11-84 C-03719-V Rev. 0  
Clip to Embed



Ref FSK-C-113 sht. 18 NO SCALE

Top weld of erection clip, check for Base Metal Defects D11A  
Bottom weld of erection clip, Base Metal No comments

East Side No ID #4

Clip to Embed  
No Bottom End Return #5

Clip to Web

Top Horiz. D11A

Bottom Diag. No Weld #5

Vert. Weld undersize leg #7 #11 #9  
undercut > 1/16 = 3/32  
weld does not extend full length of plate

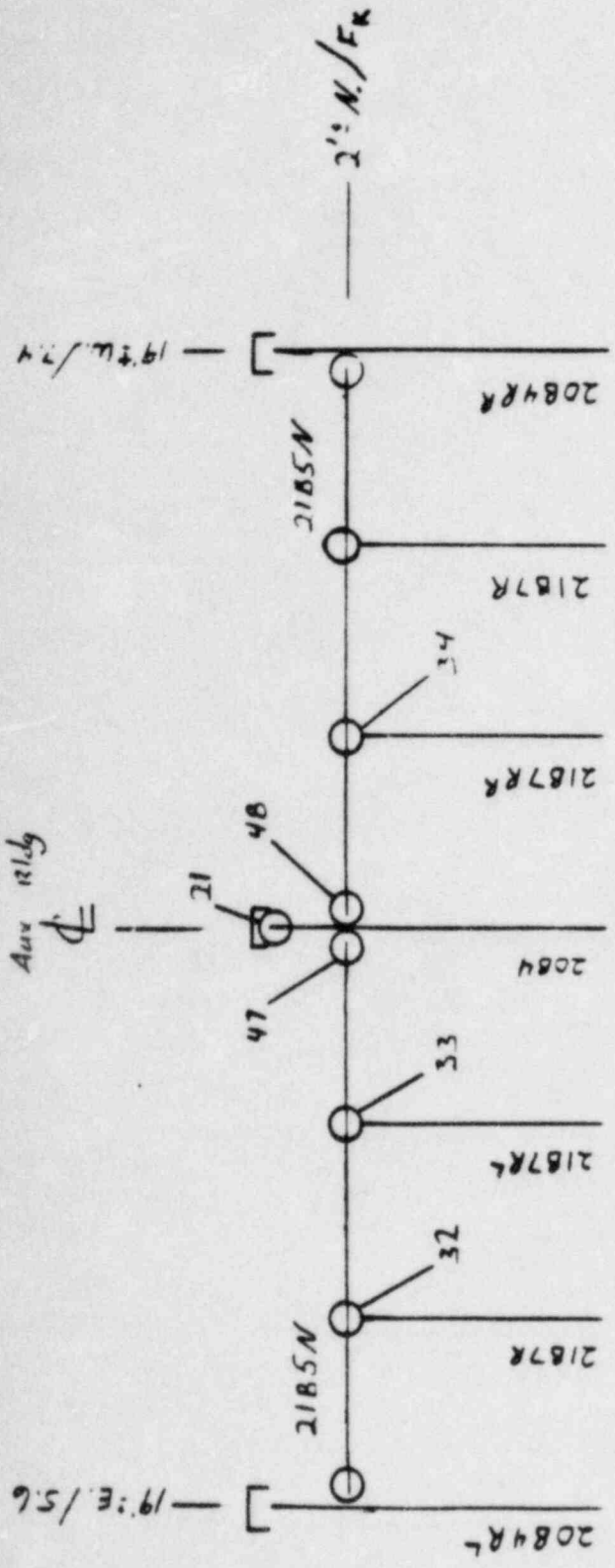
West Side No ID #4

Clip to Embed  
#5 No Bottom End return  
#7 Top End return undersize 1/4" actual size 100%  
#8 Insufficient Throat 100%  
#8 Vert. Weld oversize leg 5/8" actual 1" long

Clip to Web

Vert. Weld Slag along toe of weld #2  
undersize for 1/2" tongue #7  
undersize #11  
undercut > 1/16"

Diag. Insufficient Throat for 1/4"  
Undercut 3/32"



**ORIGINAL**

Rev. 0

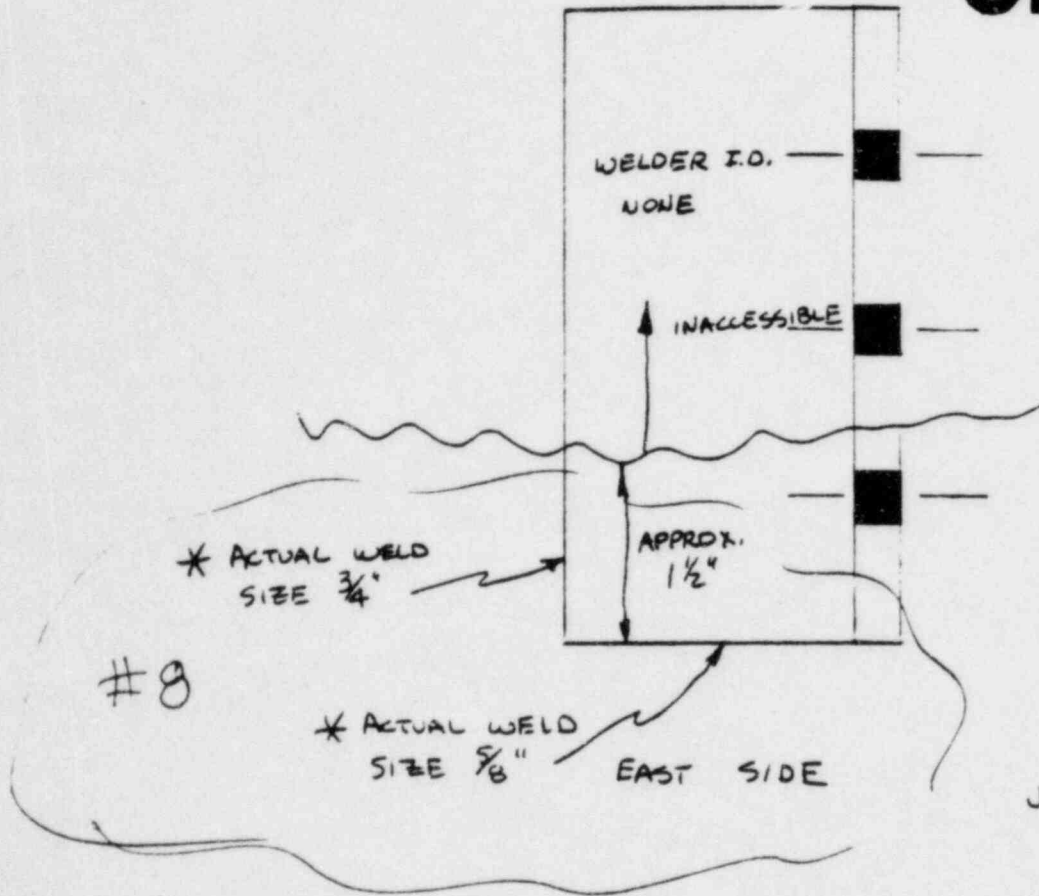
NCR# C-03719-V

Joints 32, 33, 34, 47, 48, & 21 are inaccessible due to congestion of conduits and cable trays

Note: See FSK-C-113 sht 1B for cross reference to individual beam drawings.

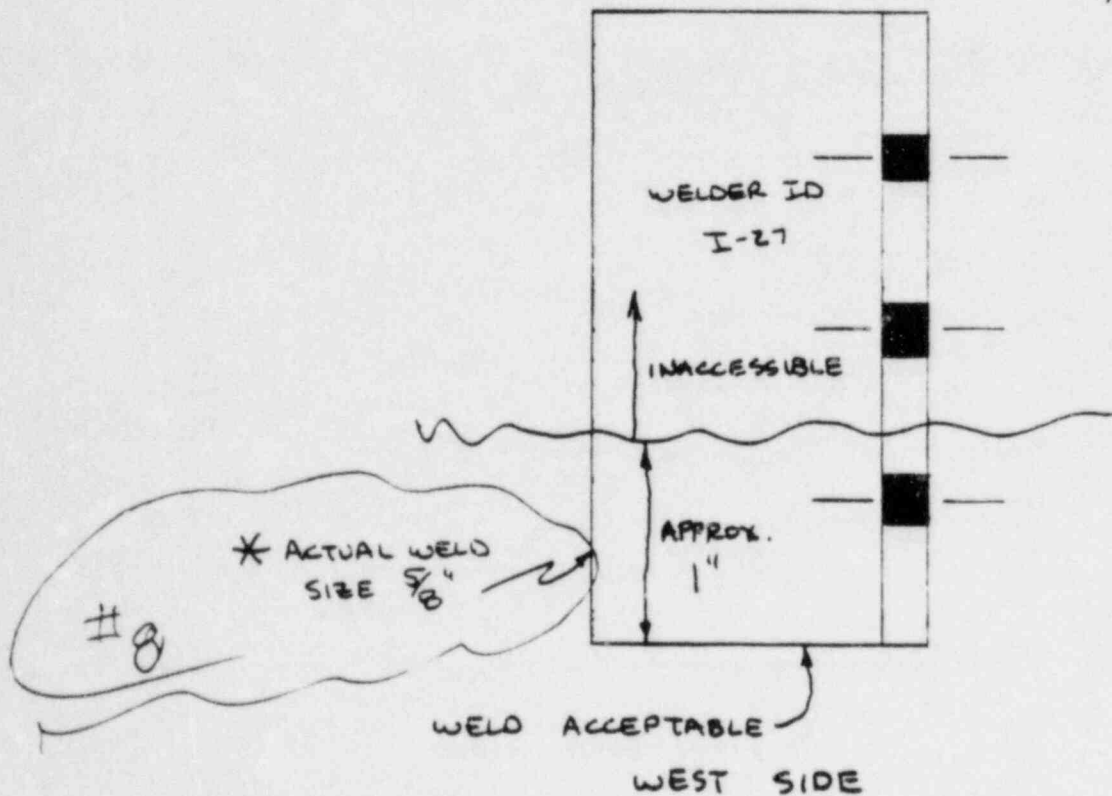


**ORIGINAL**

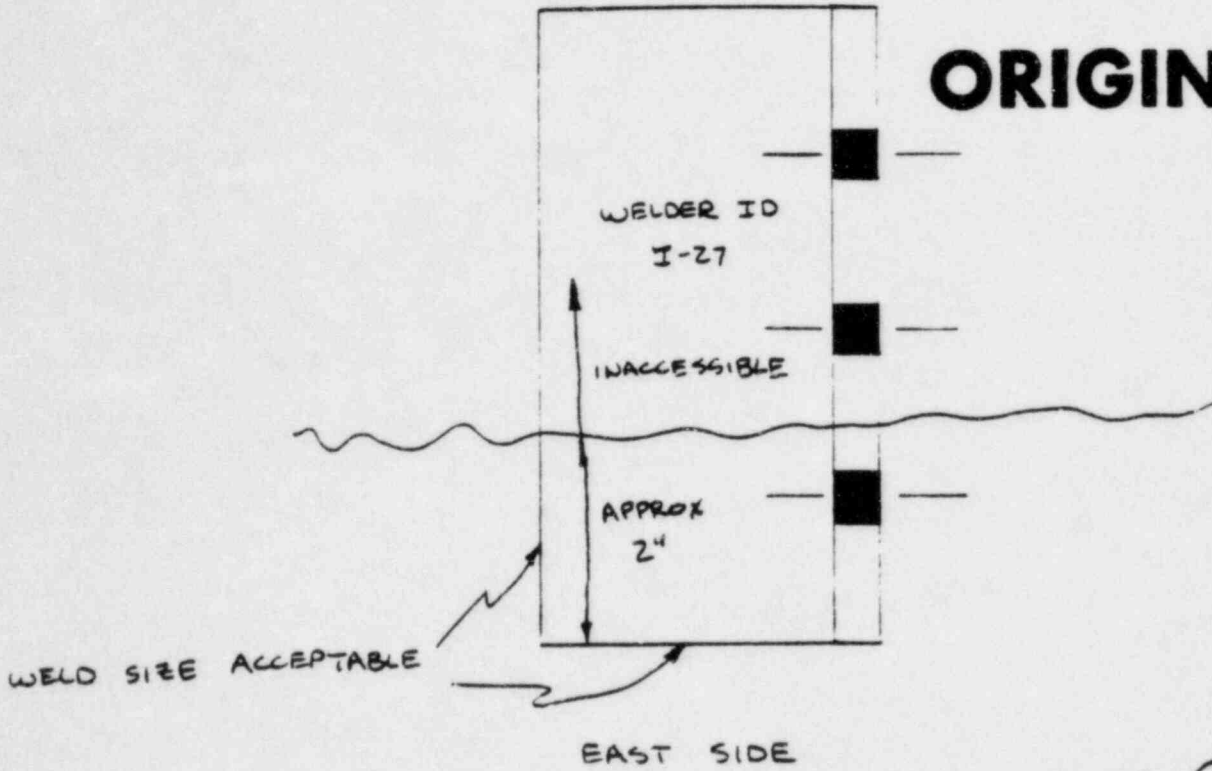


JOINT # ~~24~~ 29 <sup>MSW 5/4/84</sup>

\* OVERRUN WELDS

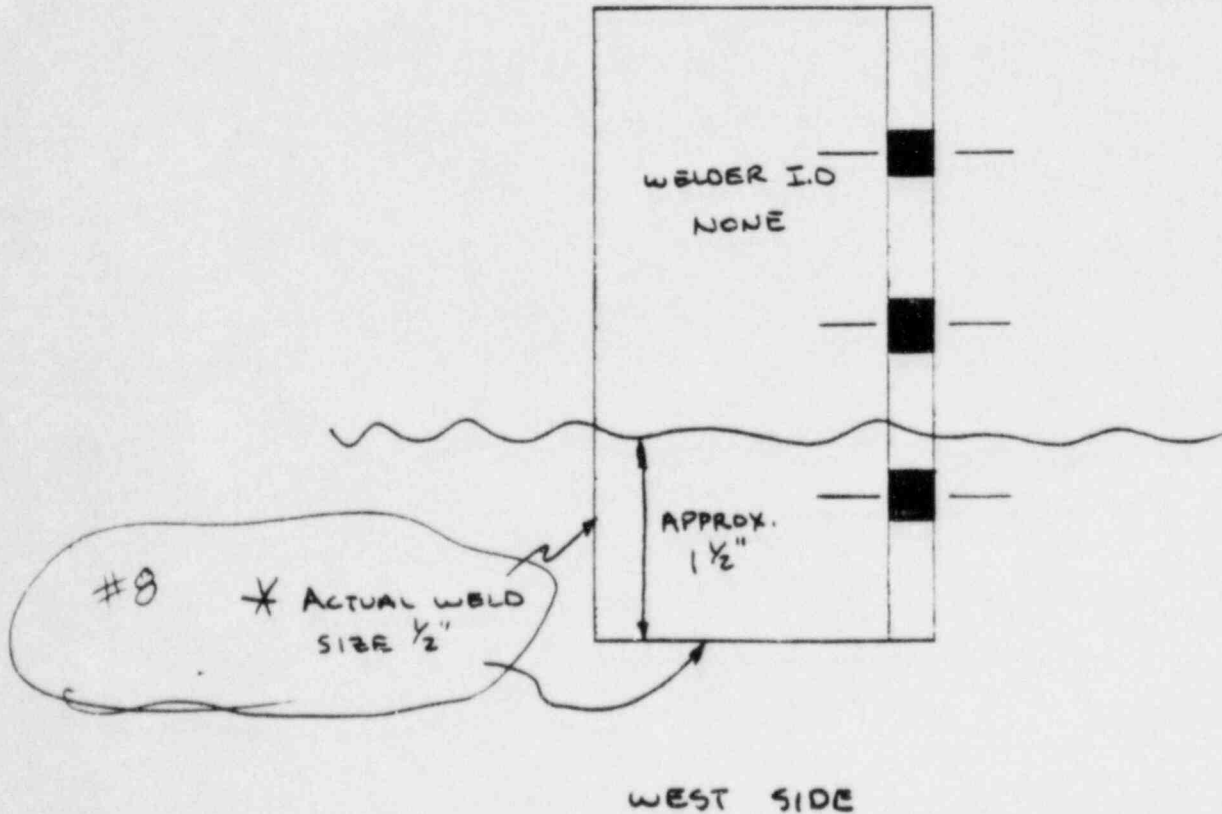


**ORIGINAL**



JOINT # (30)

\* OVERRUN WELDS

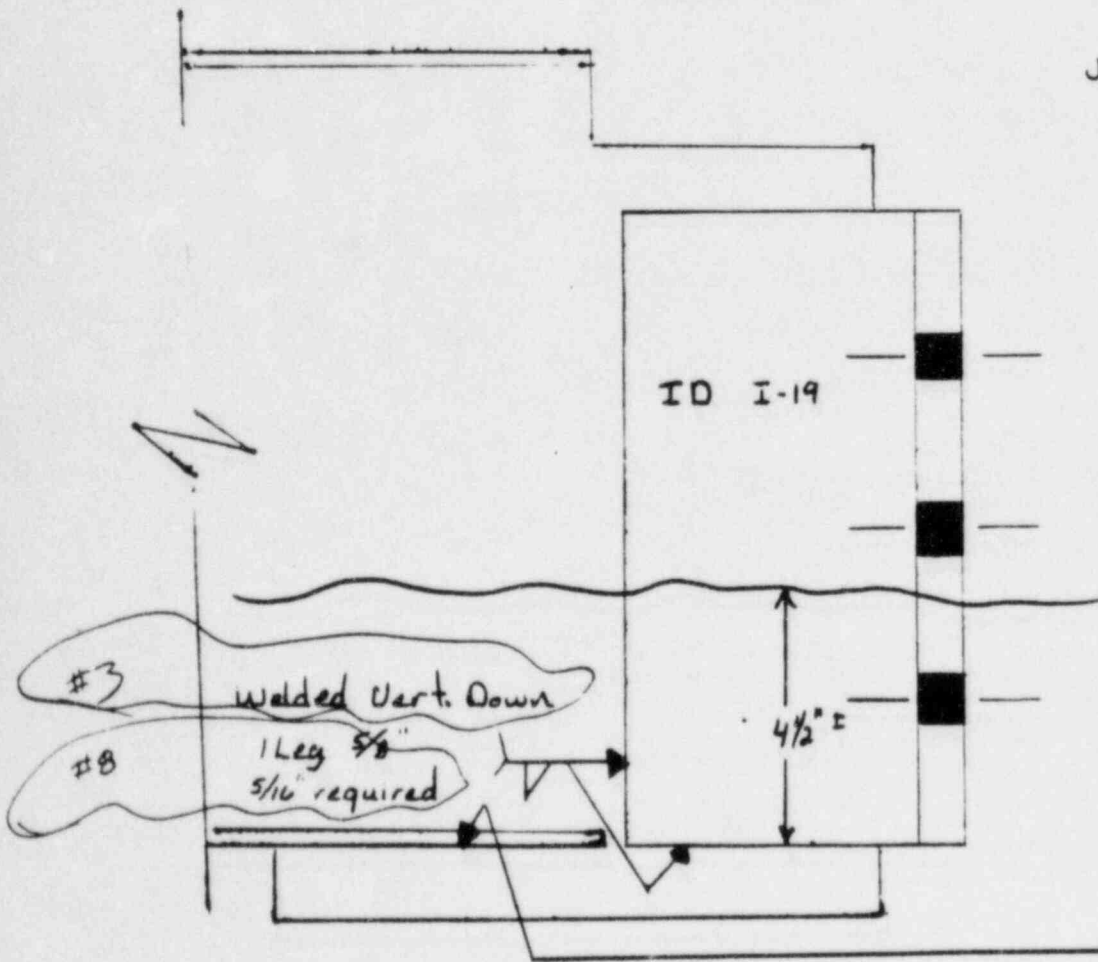


**ORIGINAL**



North Side Elevation

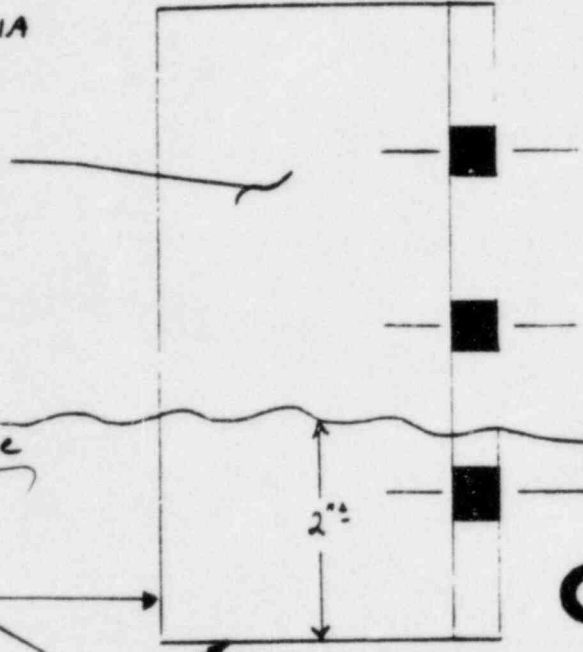
JOINT # 31



South Side

WELDER IQ 011A

Embedded in  
concrete

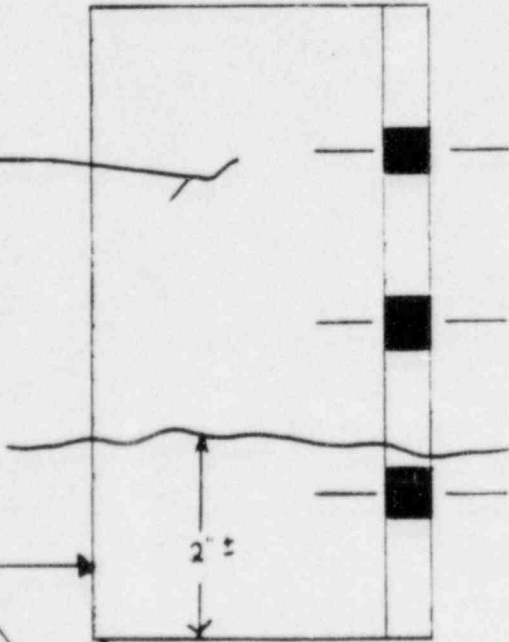


**ORIGINAL**

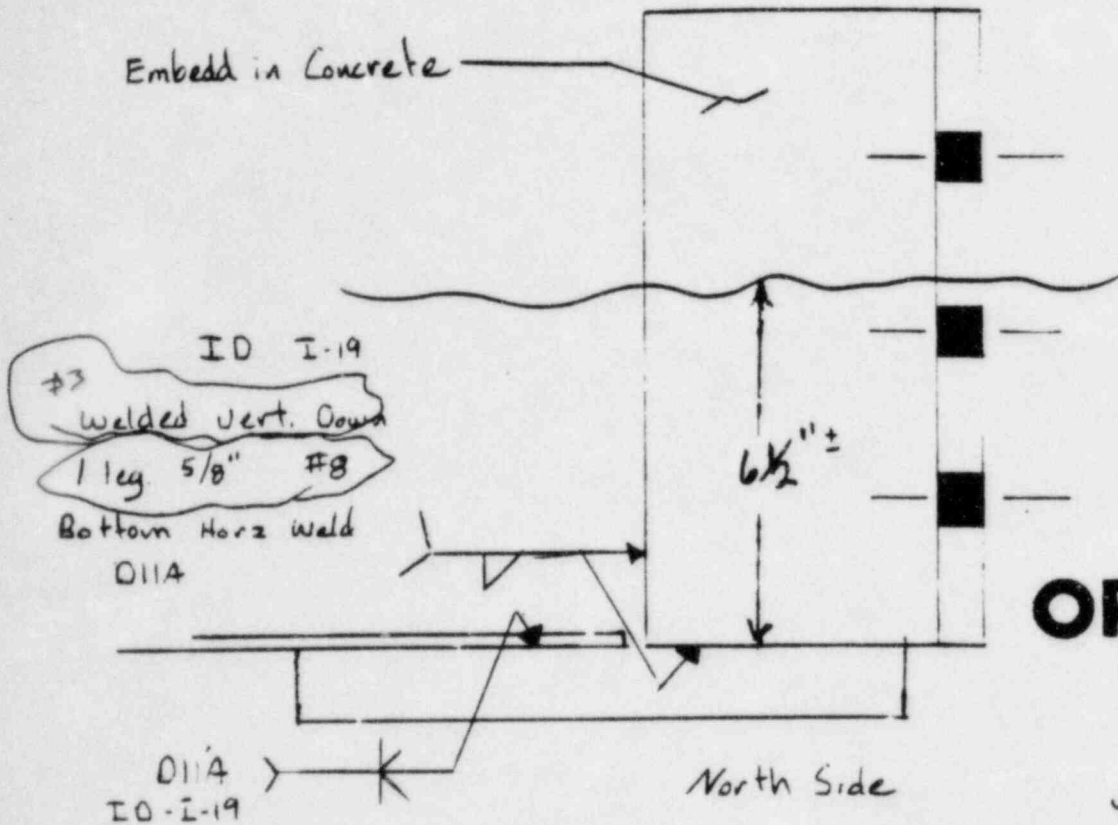
JOINT # (35)

WELDER IQ 011A

Embedded in Concrete

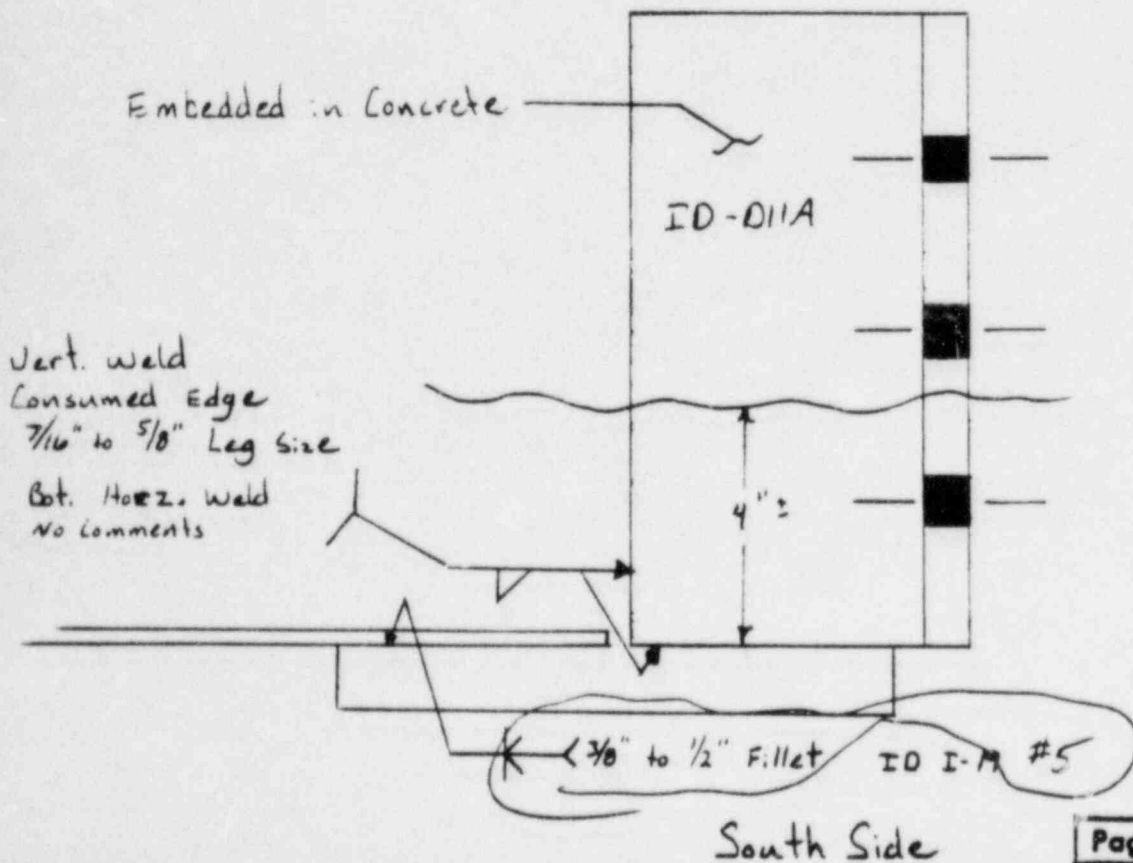


West Side



**ORIGINAL**

JOINT # (36)

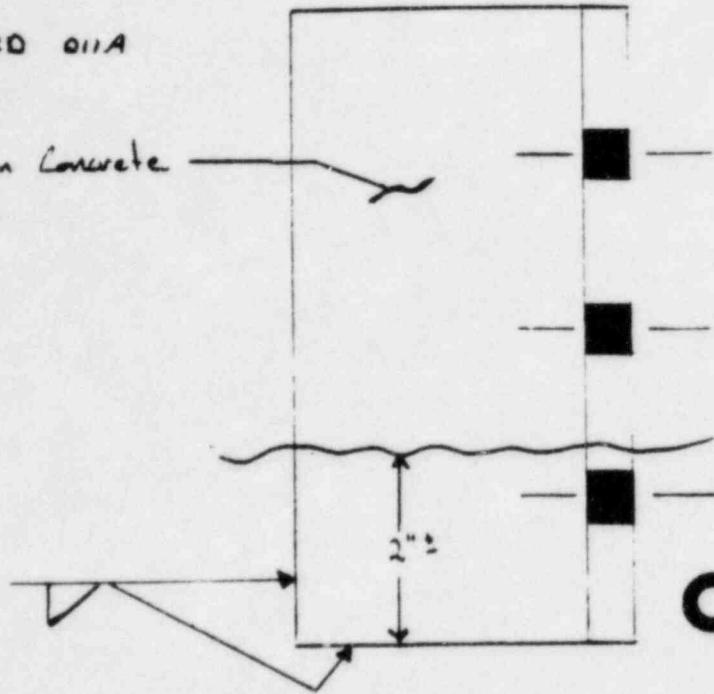




WELDER ID 011A

Embedded in Concrete

Consumed Edge  
of Plate



East Side

**ORIGINAL**

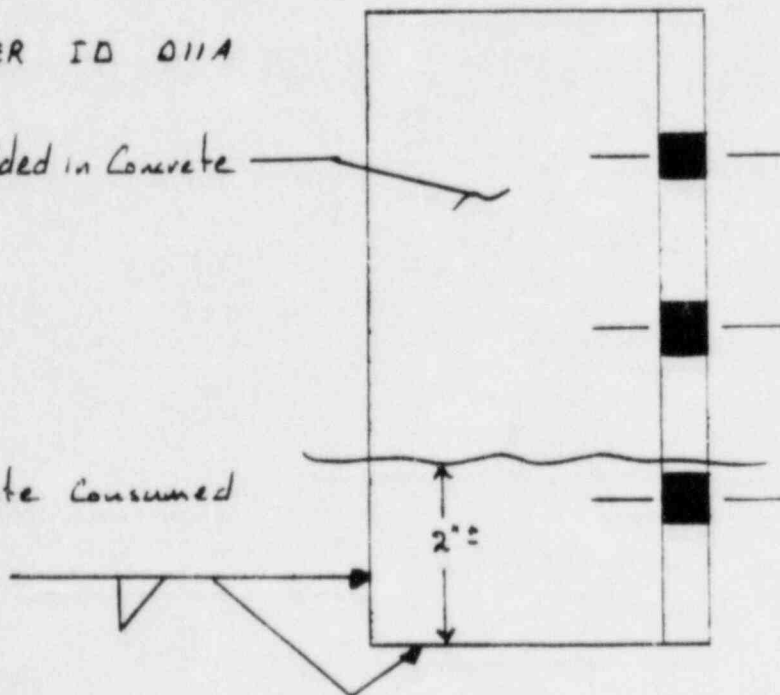
JOINT # (37)

WELDER ID 011A

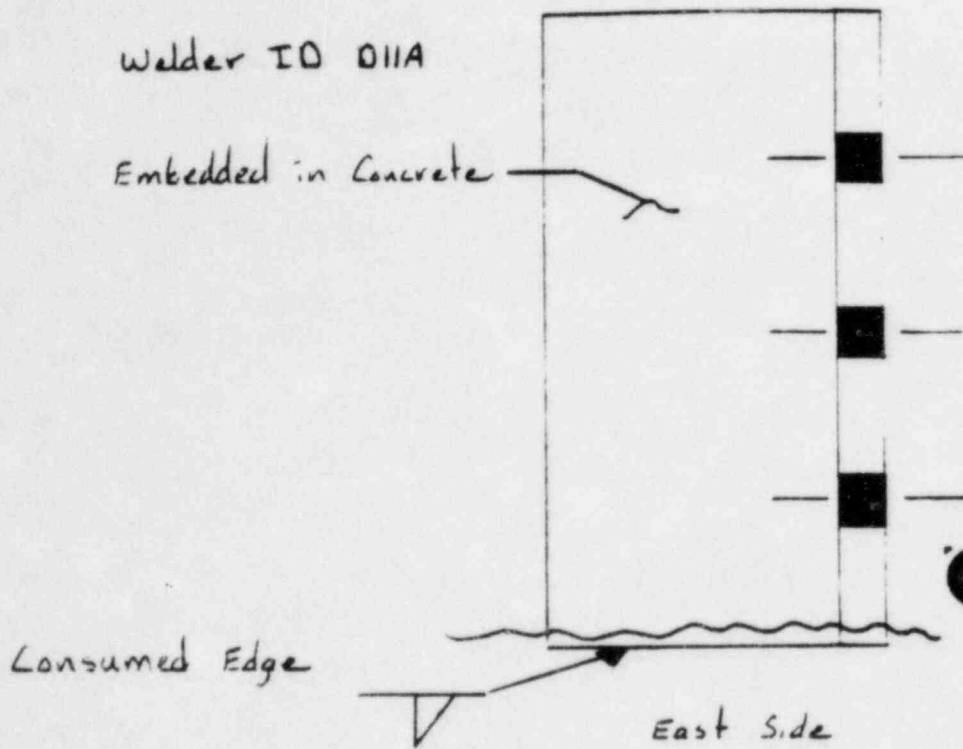
Embedded in Concrete

Edge of Plate Consumed

#8  $\frac{7}{16} \rightarrow \frac{5}{8}$

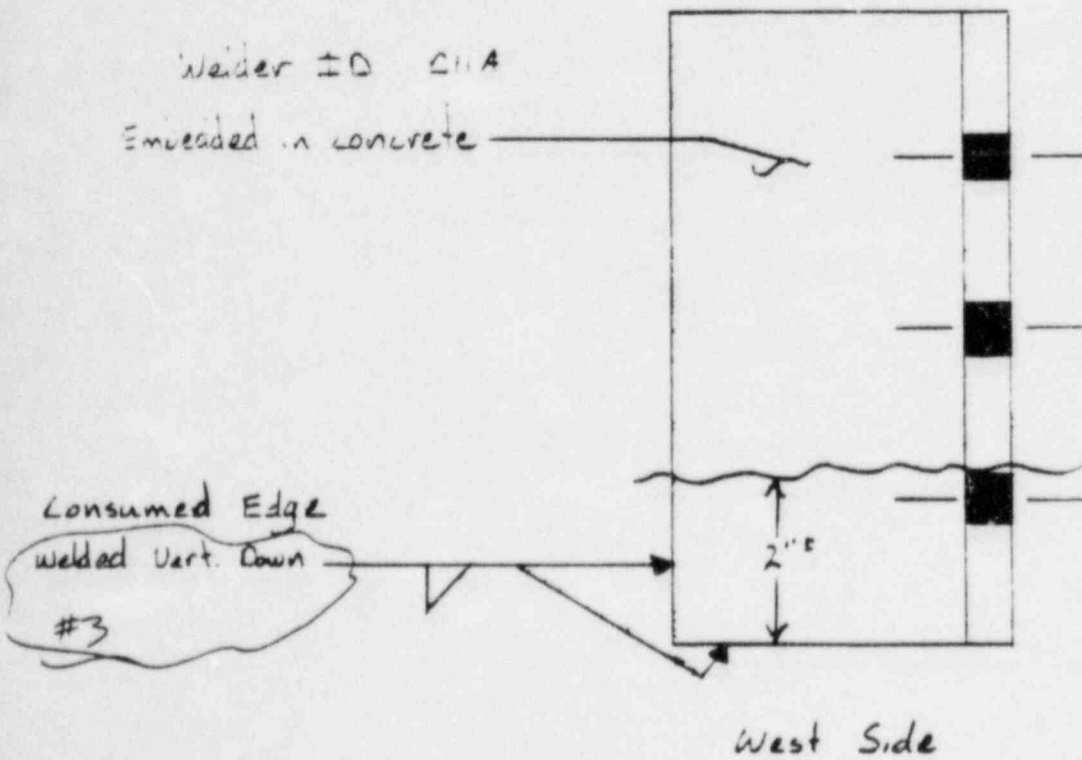


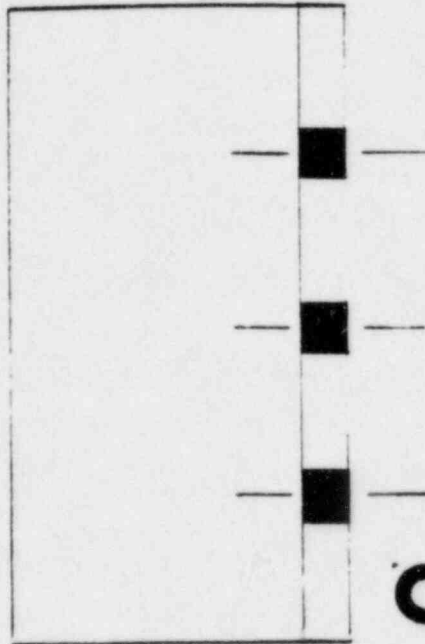
West Side



**ORIGINAL**

JOINT # (38)



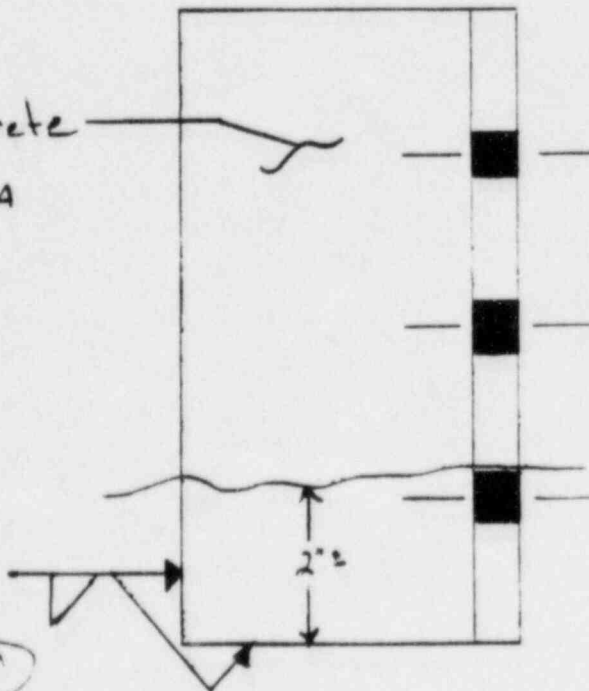


**ORIGINAL**

East Side D11A

JOINT # (39)

Embedded in Concrete  
Welder TO D11A



Consumed Edge

2"

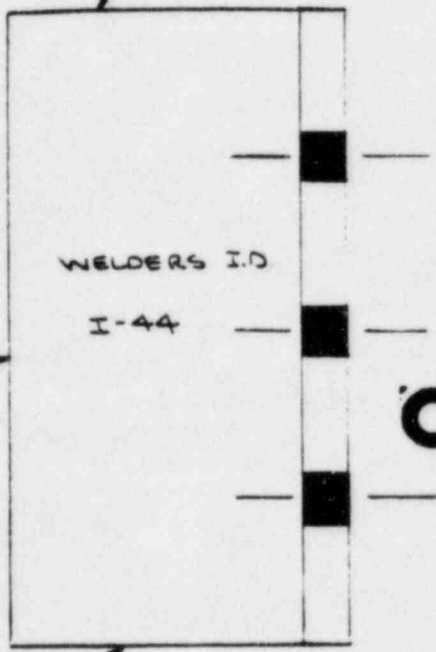
#3 Welded Vert Down

West Side

NCR # C-03719-V  
Rev. 0

$\frac{5}{16}$ " WELD ACCEPTABLE

\* ACTUAL WELD  
SIZE  $\frac{5}{8}$ "



**ORIGINAL**

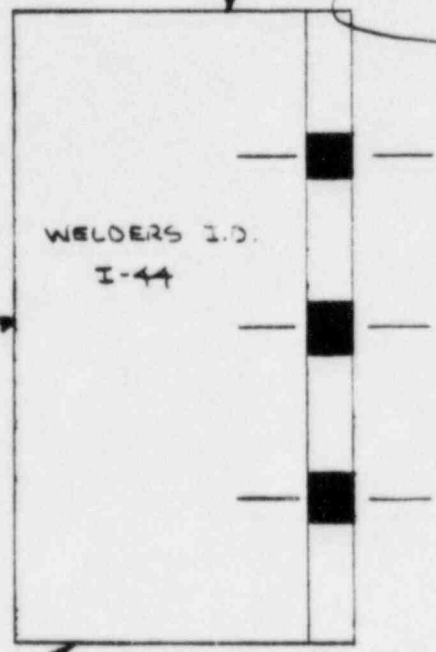
$\frac{5}{16}$ " WELD ACCEPTABLE EAST SIDE

\* ACTUAL WELD SIZE  $\frac{9}{16}$ "

JOINT # (41)

#8  
\* OVERRUN WELDS

\* ACTUAL WELD  
SIZE  $\frac{9}{16}$ "



\* ACTUAL WELD  
SIZE  $\frac{5}{8}$ "

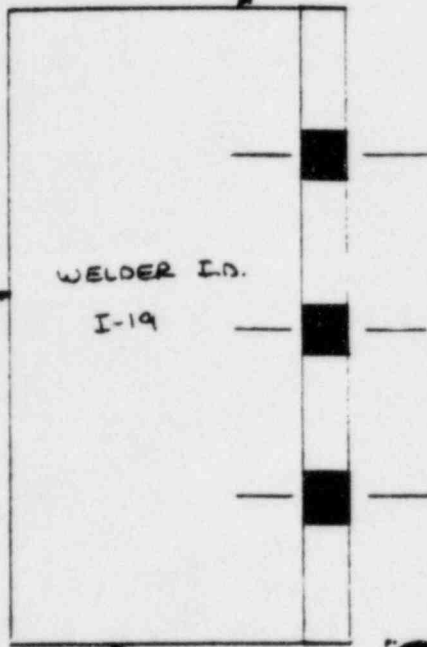
WEST SIDE

NCR# C-03719-V

REV. 0

\* ACTUAL WELD SIZE 1/2"

\* ACTUAL WELD  
SIZE 1/2"



\* ACTUAL WELD  
SIZE 1/2"

EAST SIDE

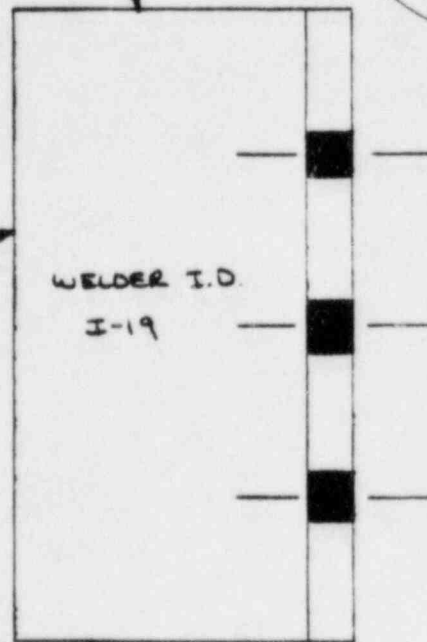
**ORIGINAL**

JOINT # (42)

#8

\* OVERRUN WELDS

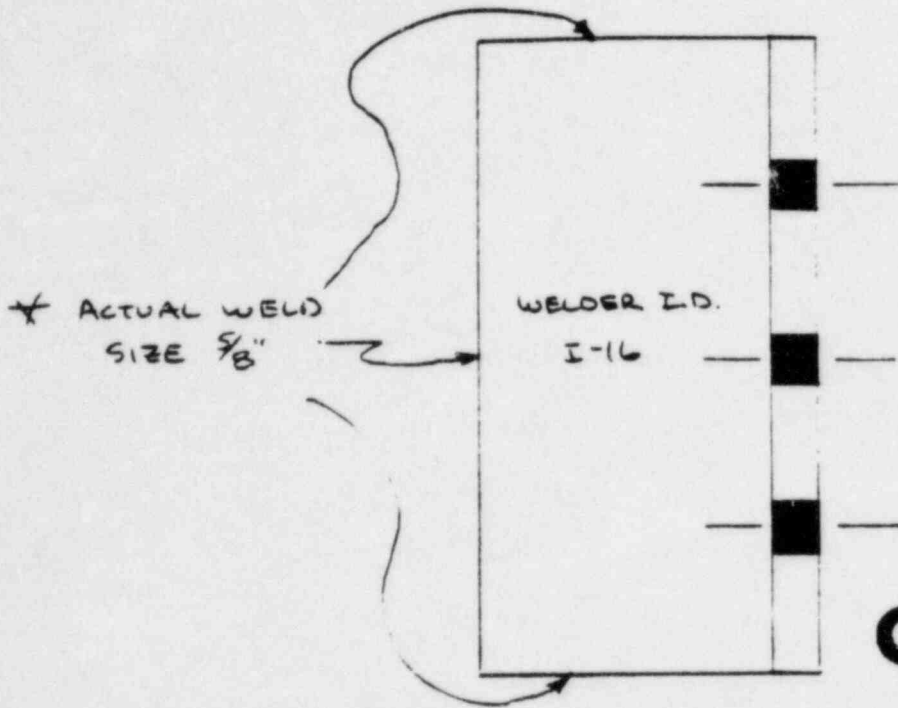
\* ACTUAL WELD  
SIZE 5/8"



WEST SIDE



NCR #C-03719-V  
Rev. 0



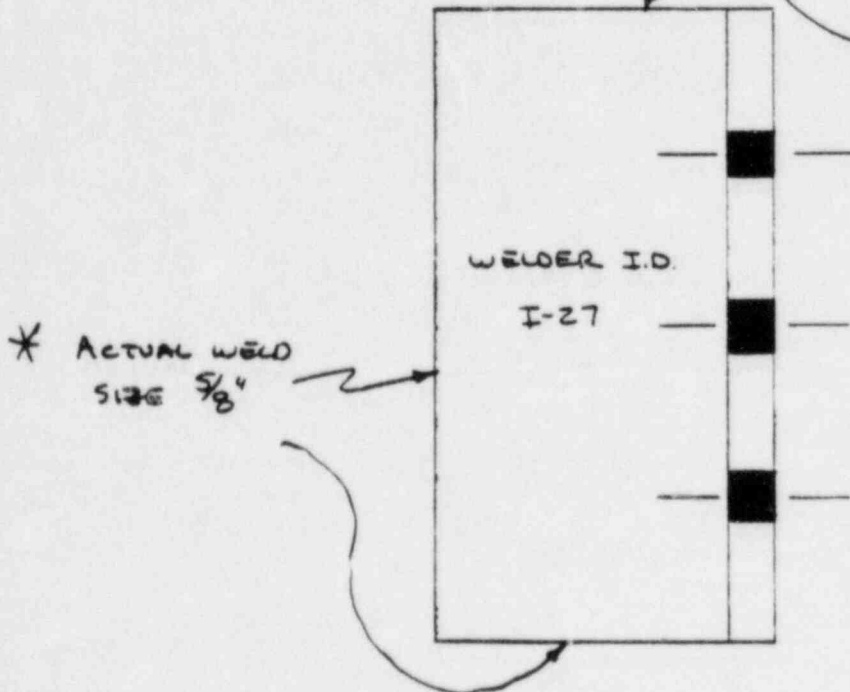
**ORIGINAL**

EAST SIDE

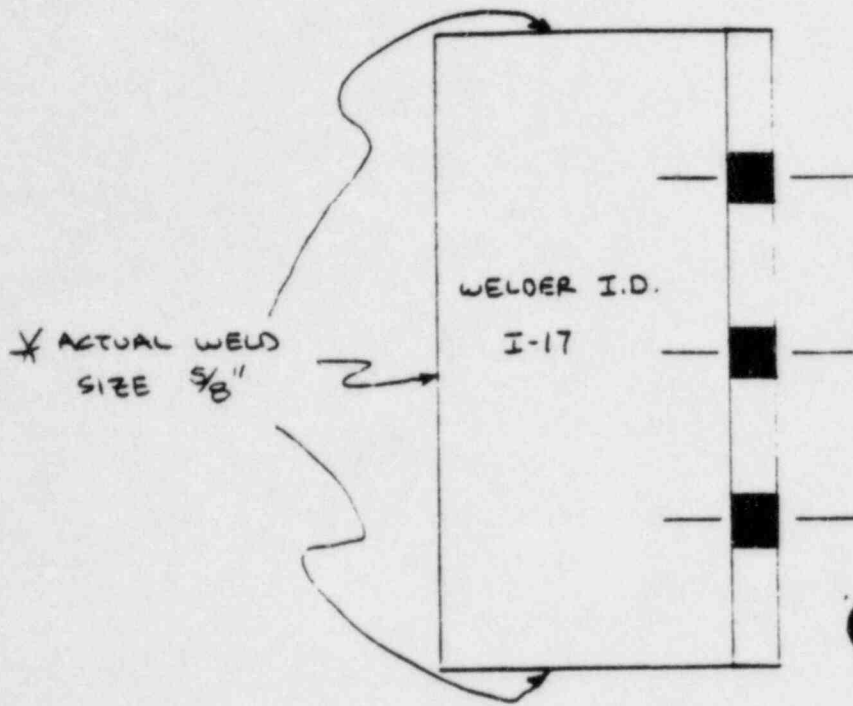
JOINT # (43)

\* ACTUAL SIZE WELD 1/16

#8  
\* OVERRUN WELDS



WEST SIDE



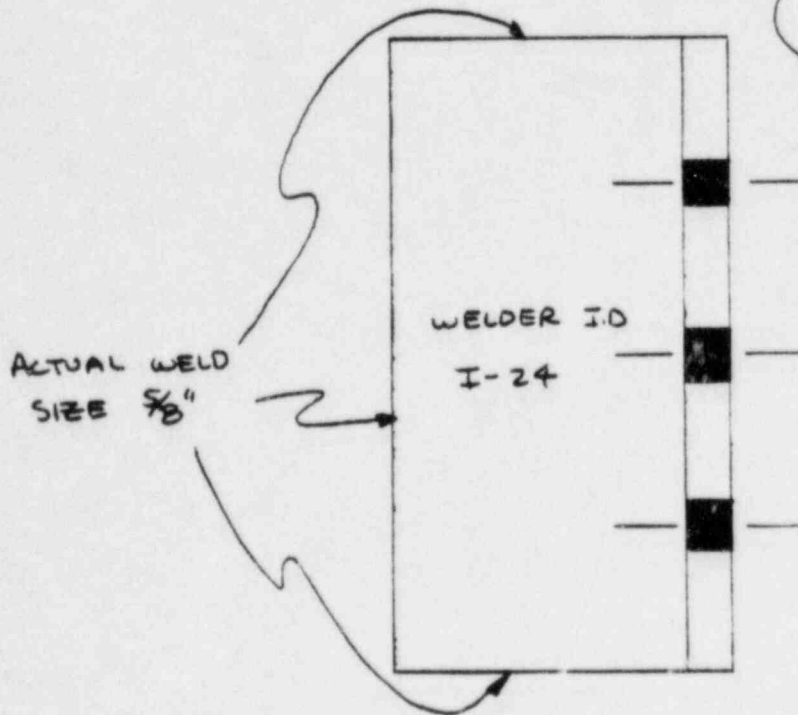
**ORIGINAL**

EAST SIDE

JOINT # 44

#8

X OVERRUN WELDS

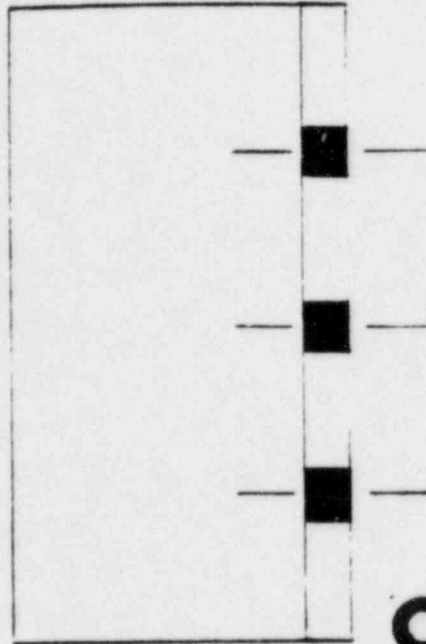


WEST SIDE

NCR# C-03719-V  
Rev. 0

welds acceptable

Welder ID I 23



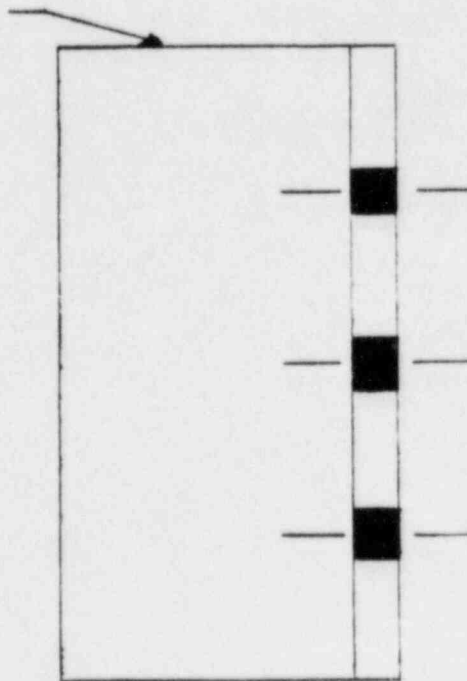
**ORIGINAL**

East Side

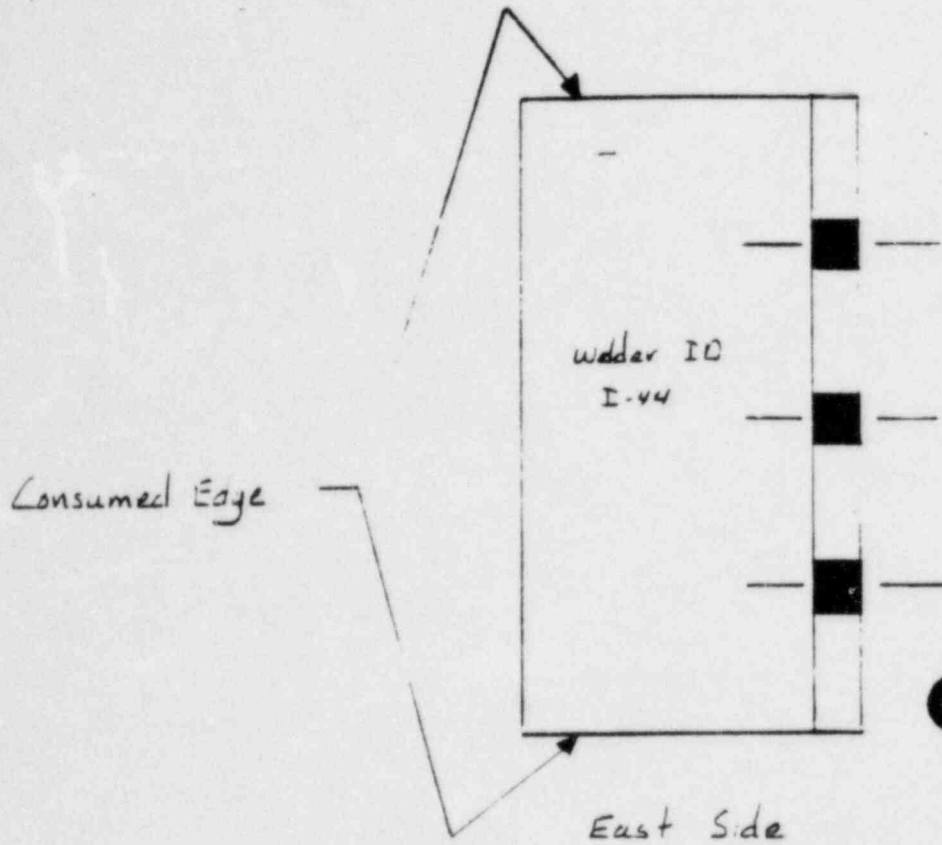
JOINT # (45)

Consumed Edge

No Welder ID  
#4

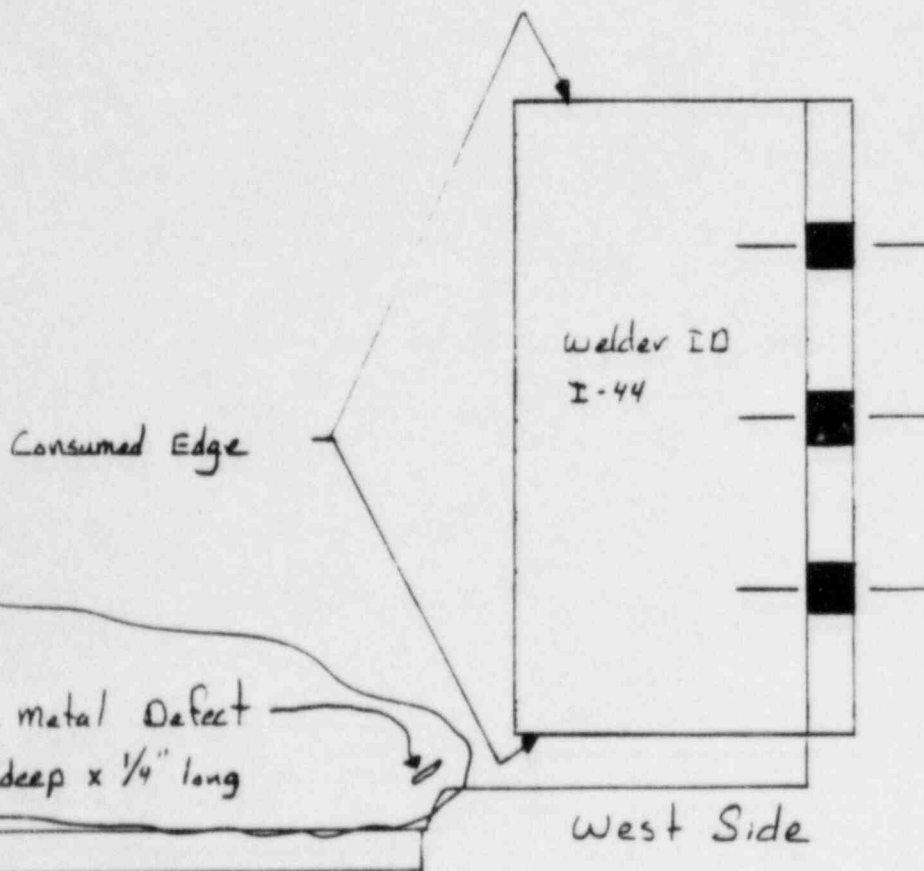


West Side



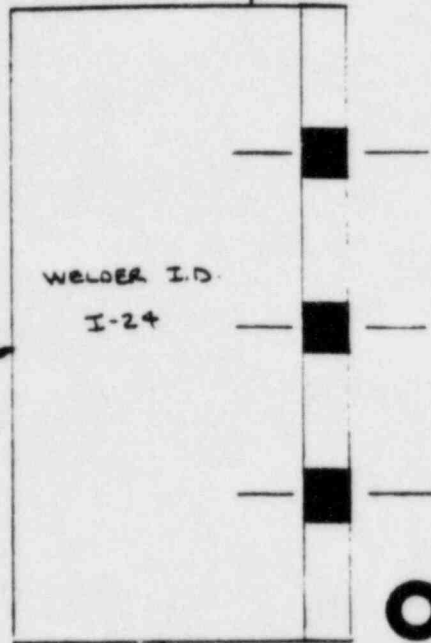
**ORIGINAL**

JOINT # (46)



\* ACTUAL WELD SIZE  $\frac{5}{8}$ "

\* ACTUAL WELD SIZE  $\frac{5}{8}$ "



**ORIGINAL**

\* ACTUAL WELD SIZE  $\frac{5}{8}$ " EAST SIDE

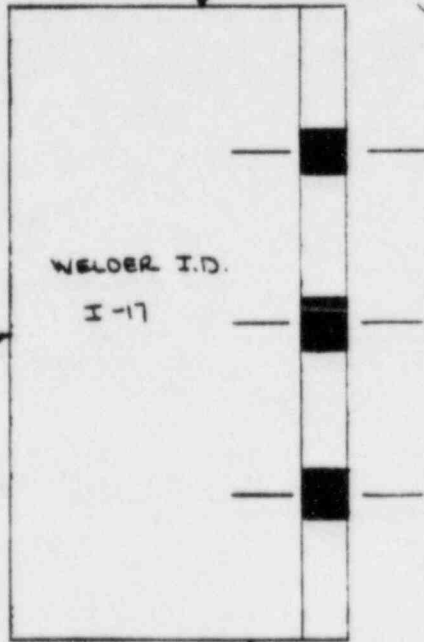
JOINT # 49

#8

\* OVERRUN WELDS

\* ACTUAL WELD SIZE  $\frac{5}{8}$ "

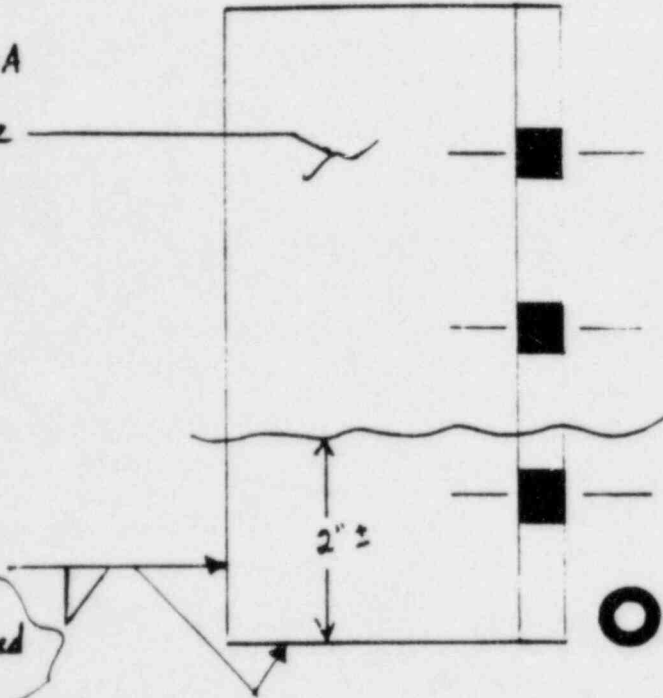
\* ACTUAL WELD SIZE  $\frac{5}{8}$ "



\* ACTUAL WELD SIZE  $\frac{5}{8}$ " WEST SIDE

welder TO D11A  
Embed in Concrete

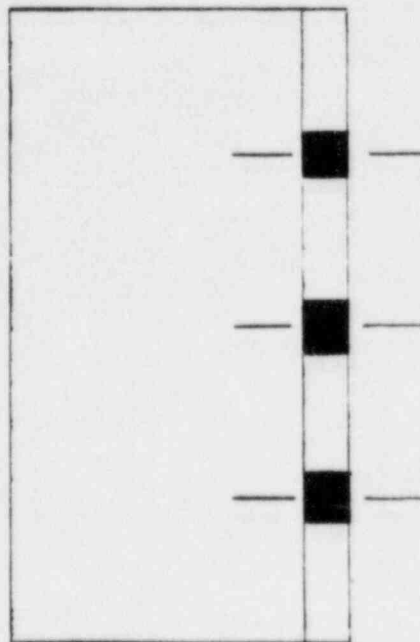
Consumed Edge  
#3 welded Vert. Down  
#6 1 Leg 5/8 3/8 required



East Side

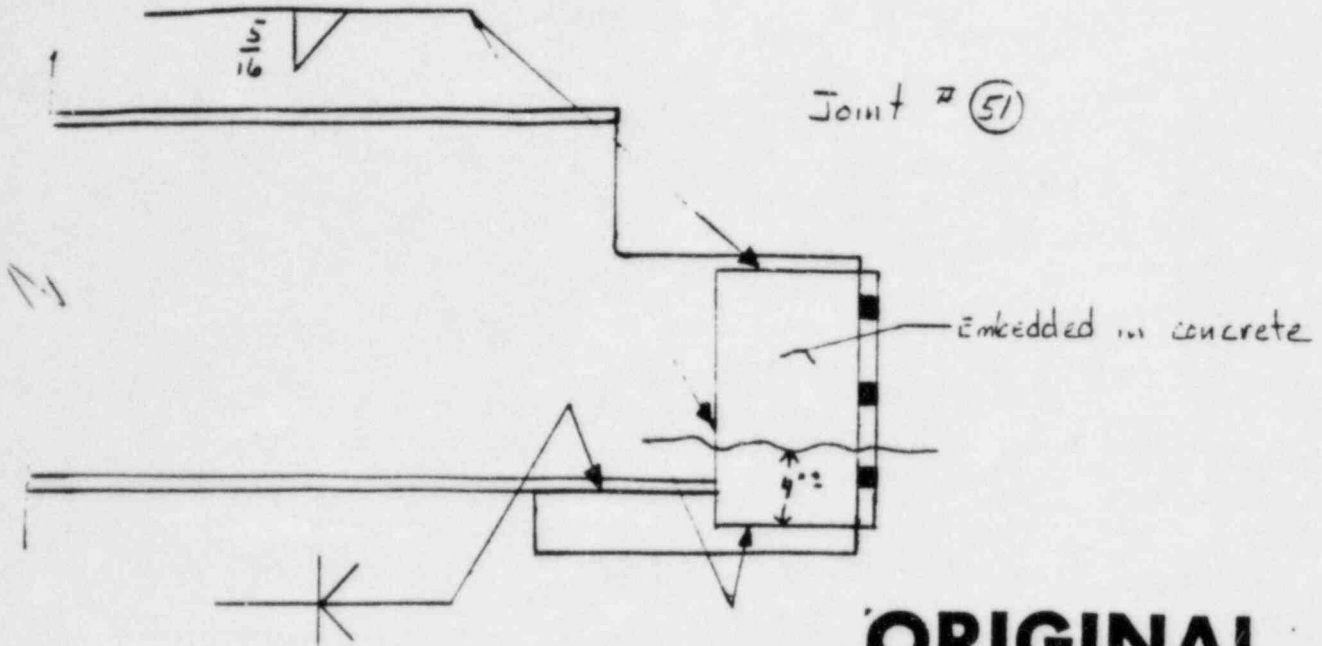
**ORIGINAL**

JOINT # (50)



West Side D11A





**ORIGINAL**

Ref. FSX-C-113 slt. 11/18, Am 2185N

North Side

#5 Full Pen ID I-27  
 5/16 x 7/16 Fillet Not shown on Dwg.

Fillets ID D11A

Consumed Edge of Base Metal

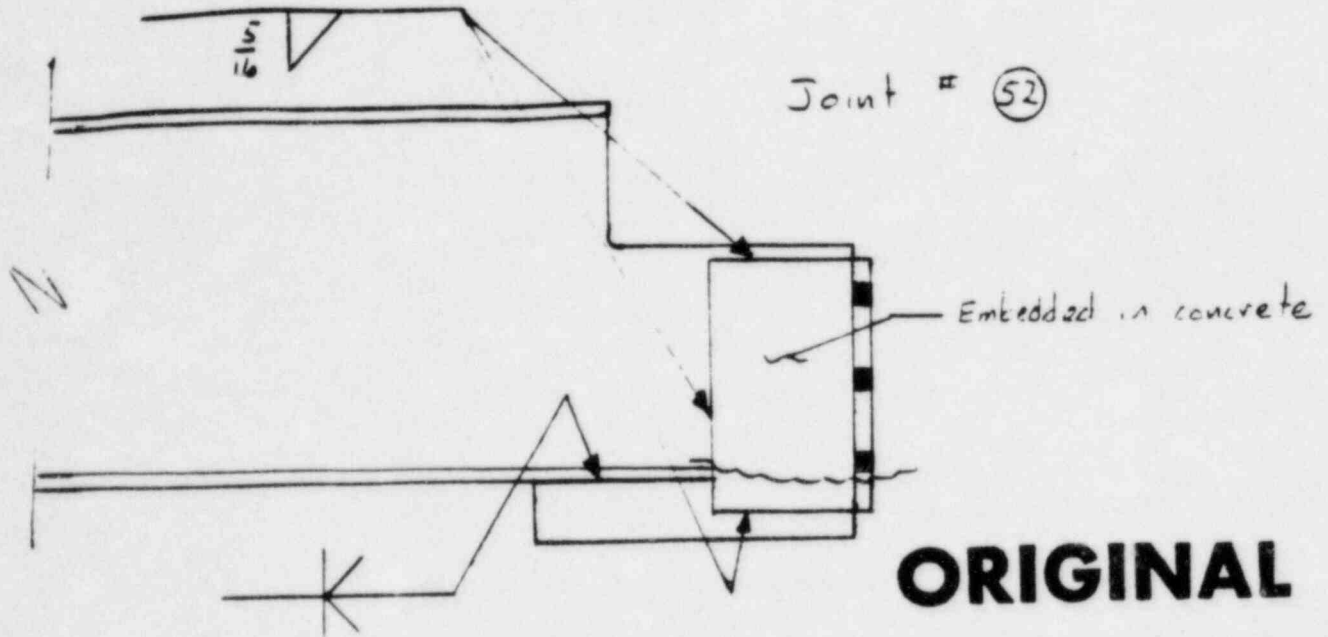
South Side

#5 Full Pen No welder ID  
 5/16 x 7/16 Fillet Not shown on Dwg.

Fillet Welder ID D11A

Consumed Edge of Base metal

#3 Welded Vert. Down.



Ref. FSK-C-113 Sht. 1B of 11 Bm 2185N

North Side IO 0114

Fillet Penn. 3/8" Fillet #5

No welder IO

Fillet welder IO 0114

Bottom Horiz. weld visible only

Consumed Edge of Base Metal

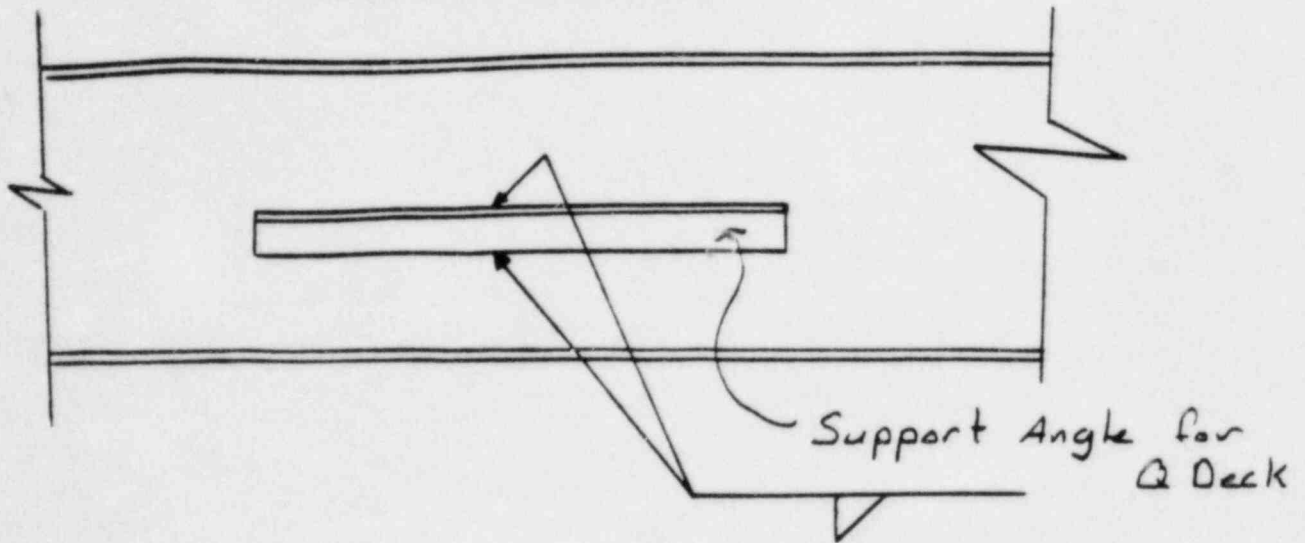
South Side IO 0114

Fillet Consumed Edge

Bottom Horiz Fillet only inspected

~~Rest~~ Remainder of weld IO

# ORIGINAL



Ref. FSK-C-113 sht. 18, 19, & 12

Welds #53 thru 76 Top Fillets D11A Embedded in Concrete

Note: Welds on Q Deck support angles are Non-Q per FCR 7988 attached to Dwg. C-244 rev. 15. Inspected Q Base Metal Only

- #54 D11A Bm 20B3R<sup>R</sup> 5'-6"± East of Bm 20B4R<sup>R</sup> Covered with Concrete
- #66, 67, & 68 D11A 12"± 6'± of Bm 21B7R<sup>R</sup> & 21B7R @ G.9 line from Bm 21B5N Embedded in concrete
- #65 D11A All of Bm 21B7R<sup>R</sup> Embedded in Concrete and due to Conduit & Piping Conjestion
- #63 & 64 D11A 12"± 6'± of Bm 21B7R @ G.2 line from Bm 21B5N Embedded in concrete & Conjestion (8'x10's #64 only Pipe Conjestion)
- #53 D11A Bm 20B3R<sup>R</sup> 2'-3"± East of S.6 line Wall covered with Concrete

# 11 #56 Undercut greater than 1/16" deep @ ≈ £ Reactor Bldg. (near unistrut for OVM 15BQ)

#58 Undercut greater than 1/16" deep @ ≈ 2'± S. / £ Reactor Bldg.