



**CBI**

CONTRACT 83670  
 DATE 5-28-80  
 INITIALS dlw  
 RELEASED BY  
 CNQA SERVICES

IDENTIFICATION WPAT  
 REV. NO. 7  
 CONTRACT 83670

TITLE WELDING PROCEDURE APPLICATION TABLE  
 DOWNCOMER BRACING & QUENCHER SUPPORT  
 PRODUCT & LINER WORK  
 LASALLE COUNTY STATION

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REVIEWED	OB ENGR	DIST ENGR	CORP WELD	INSP & TEST	CORP QA	REG CONST QA	REG MFG QA
	JSV		DJS			WRW	

	BY	DATE
PREPARED	HMR	6/5/78
CHECKED	TJL	6/7/78
REVISED	DJS	5/8/80
AUTHORIZED	RES	5/27/80
REFERENCE STANDARD	----- REV. NO. -----	

1.0 Welding Procedures approved for this contract are listed in the contract Q. A. Handbook Index.

The following list shows the Welding Procedures that will be required by field welders for this vessel. The application of approved Welding Procedures to the Shop welded joints will be in accordance with the Quality Assurance Program for the fabricating plant involved.

2.0 USE FIELD WELDING PROCEDURE SPECIFICATION

	WPS#		
	E7018	E308	E309
WPS APPLICATION			
UPPER DOWNCOMER MODIFICATION	DOWNCOMER BRACES TOGETHER	X	
	RING PLATES TO DOWNCOMER		X
	DOWNCOMER BRACING TO RING PLATES (COLLARS)	X	
	BRACING GUSSETS TO BRACING	X	
	PATCH PLATE TO DOWNCOMER		X
	DOWNCOMER STIFFENER TO DOWNCOMER		X
	DOWNCOMER STIFFENERS TOGETHER	X	
	BEAMS TO DOWNCOMER BRACES	X	
	SPLICE PLATES TO BEAMS	X	
	BACKUP BAR SPLICES (C.S.) AND SEAL WELDS	X	



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2.0 USE FIELD WELDING PROCEDURE SPECIFICATIONS (CONT.)

		WPS #				
		E7018	E308	E309		
		WPS APPLICATION				
FLOOR MODIFICATION		BACK UP BAPS TO STIFFENERS & TOGETHER	X			
		FLOOR STIFFENERS TOGETHER		X	X	
		ANCHOR BOLT CAPS TO CARBON STEEL			X	
		TEST CHANNELS TO CARBON STEEL			X	
		KWU QUENCHER SUPPORTS TOGETHER	X			
		KWU SUPPORTS TO BOTTOM			X	
		BOTTOM TOGETHER AND TO TEST CHANNELS AND TEST CHANNELS TO SUPPORTS		X	X	
	EAST CURB MODIFICATION		X			
LOWER DOWNCOMER MODIFICATION	▽	PERIPHERY PLATE TO LINER		X		
		PERIPHERY PLATE TO CLOSURES PLATE			X	
		CLOSURE PLATE TO EMBED			X	
		BACK-UP SPLICES (TOG.)			X	
		BACK-UP BAR TO PERIPHERY PLATE			X	
		BACK-UP BAR TO LINER			X	
	▽	PERIPHERY PLATE TOGETHER		X		
		CLOSURE PLATE TOGETHER			X	
		BENT PLATE LEAK CHASE TO LINER			X	
		BENT PLATE LEAK CHASE TO EMBED			X	
	▽	BENT PLATE LEAK CHASE TOGETHER		X		
		ANCHOR BOLT CAP TO EMBED			X	
		ANCHOR BOLT LEAK CHASE TO EMBED			X	
▽	COUPLING TO BENT PLATE LEAK CHASE		X			
▽	LEAK CHASE TO EXISTING LEAK CHASE		X			



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2.0 USE FIELD WELDING PROCEDURE SPECIFICATIONS (CONT.)

		WPS #			
		E7018	E308	E309	
WPS APPLICATION					
LOWER DOWNCOMER MODIFICATION	D.C. COLLAR TOGETHER		X		
	D.C. COLLAR TO D.C.		X		
	HORIZONTAL GUSSET TO EMBED	X			
	BRACING (PIPE) TO HORIZONTAL GUSSET	X			
	PIPE CAP TO HORIZONTAL GUSSET	X			
	PIPE CAP TO BRACING PIPE	X			
	CLIPS (17-9) TO BRACING PIPE	X			
	BRACING PIPE TOGETHER (SPlice)	X			
	FISHMOUTH PIPE TO D.C. COLLAR	X	X		
	BRACING PIPE TO VERTICAL GUSSET	X			
	VERTICAL GUSSET TO HORIZONTAL GUSSET	X			
	VERTICAL GUSSET TO D. C. COLLAR	X			
	HORIZONTAL GUSSET TO D.C. COLLAR	X	X		
	BRACING PIPE TO BRACING PIPE FISHMOUTH	X			
UPPER LOWER, & FLOOR MODIFICATION	TEMPORARY ATTACHMENTS (C.S. TO S.S.)			X	
	DOWNCOMER BRACING TO GUSSETS & GUSSETS TO GUSSETS	X			
	TEMPORARY ATTACHMENTS (S.S. TOGETHER)		X	X	
	REPAIRS TO S.S.		X		
	REPAIRS TO C.S.	X			
	TEST CHANNELS TOGETHER & TO STAINLESS STEEL		X	X	





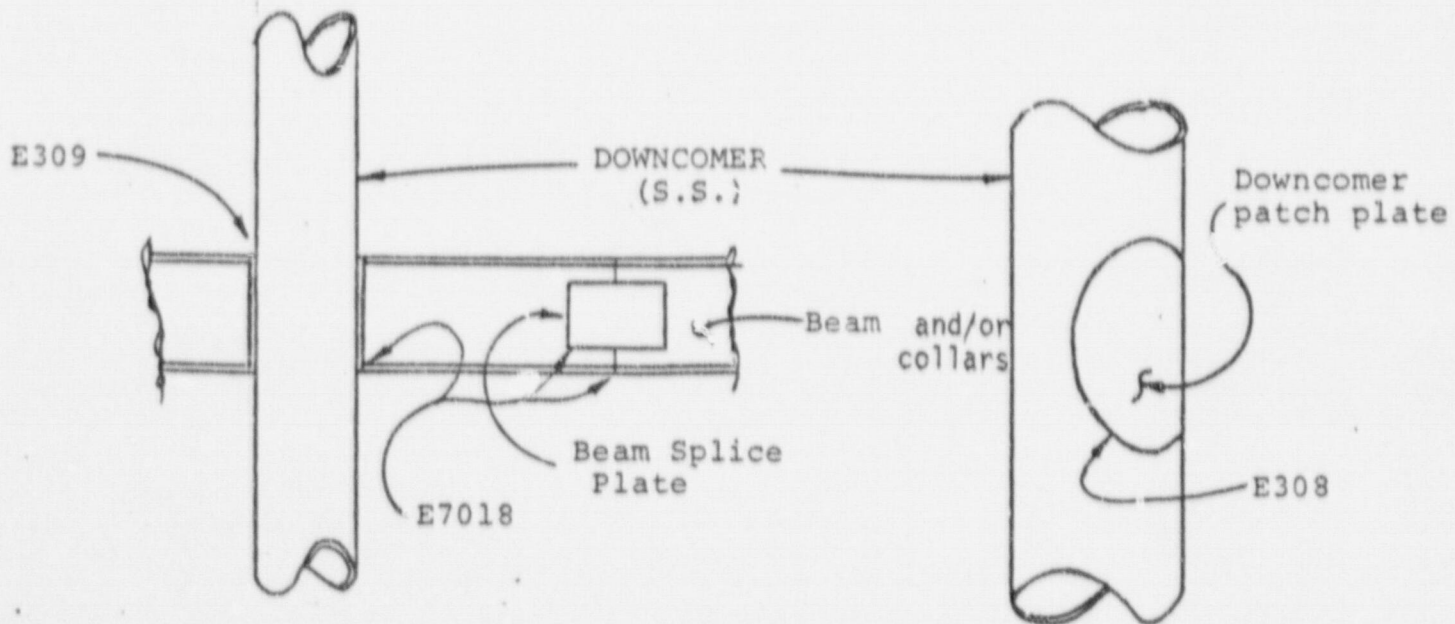
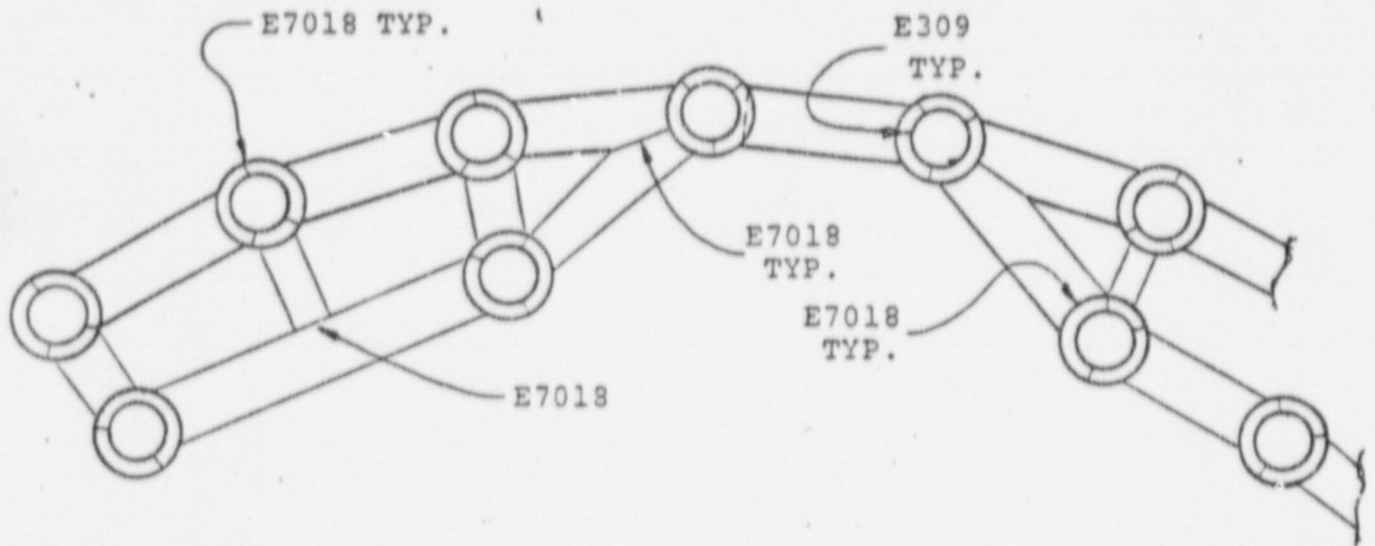


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TYPICAL ELEVATIONS AND PLAN VIEWS

NOTE: These sketches show only general details,



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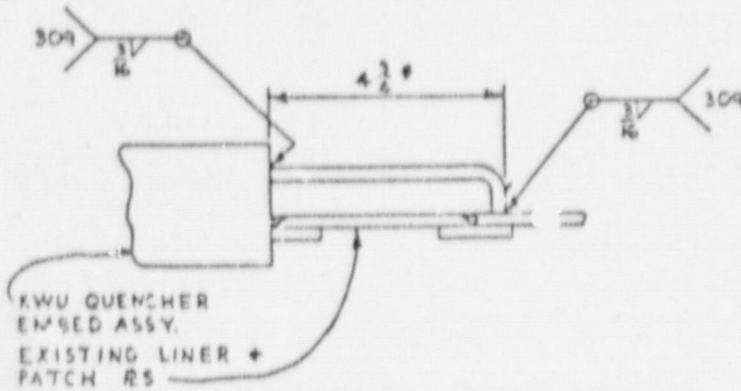
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LA SALLE COUNTY STATION

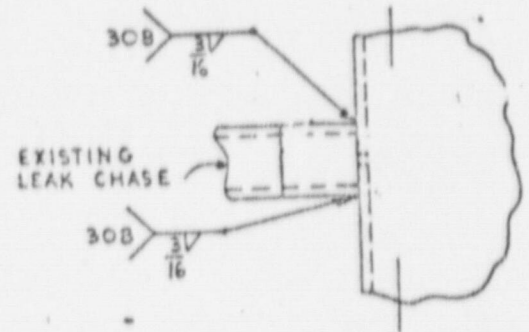
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PRODUCT

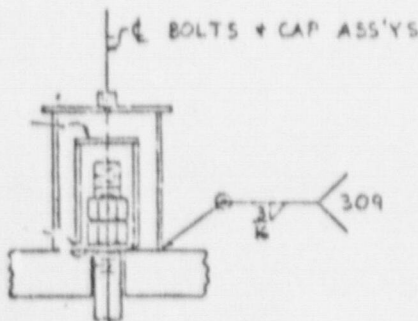
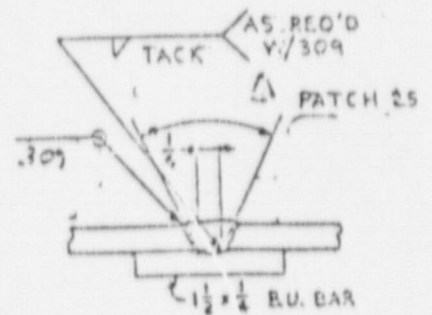
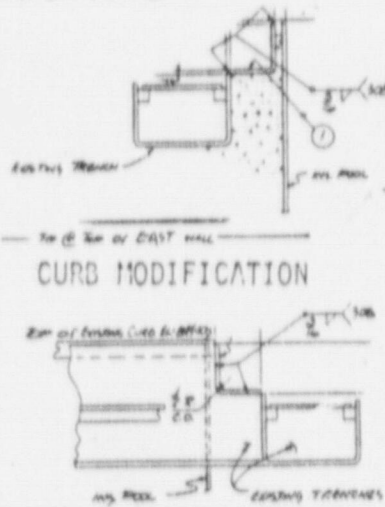
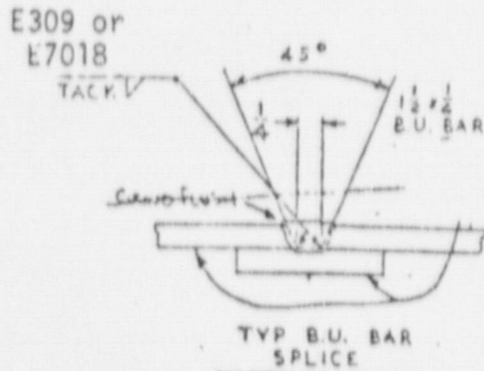


⊗ MAY BE UP TO  $6 \frac{3}{4}$  DUE TO FIELD TRIM

TYPICAL SECTION THRU BENT LEAK CHASE ⊗



TYPICAL AIR PASSAGE DETAIL



SECTION "B-B"  
TYPICAL SECTION THRU LEAK CHASE CAPS  
B REQ'D PER EMBED

CURB MODIFICATION

