



IDENTIFICATION WPAT

REV. NO. 6

CONTRACT 83670

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

PAGE NO. 1 OF 6

REVIEWED	OB ENGR	DIST E'GR	CORP WELD	INSP & TEST	CORP QA	REG CONST QA	REG MFG QA				BY	DATE
	JSV		DJS			WRW						
											PREPARED	HMR 6/5/78
											CHECKED	TJL 6/7/78
											REVISED	TJL 4/3/80
											AUTHORIZED	RES 4/9/80
											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

CBI
CONTRACT <u>83670</u>
DATE <u>4-15-80</u>
INITIALS <u>dlv</u>
RELEASED BY
CNQA SERVICES

UPPER DOWNCOMER MODIFICATION	WPS APPLICATION					WPS#				
						E7018	E308	E309		
	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				



IDENTIFICATION WPAT

REV. NO. 6

CONTRACT 83670

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

PAGE NO. 2 OF 6

2.0 USE FIELD WELDING PROCEDURE SPECIFICATIONS (CONT.)

		WPS #				
		E7018	E308	E309		
FLOOR MODIFICATION	WPS APPLICATION					
	BACK UP BARS 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		
LOWER DOWNCOMER MODIFICATION	EAST CURB MODIFICATION		X			
	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		



IDENTIFICATION WPAT
REV. NO. 6
CONTRACT 83670

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

PAGE NO. 3 OF 6

2.0 USE FIELD WELDING PROCEDURE SPECIFICATIONS (CONT.)

		WPS #				
LOWER DOWNCOMER MODIFICATION	WPS APPLICATION	E7018	E308	E309		
	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				
	BRACING PIPE TO BRACING PIPE FISHMOUTH	X				
UPPER QUENCHER & LINER 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		

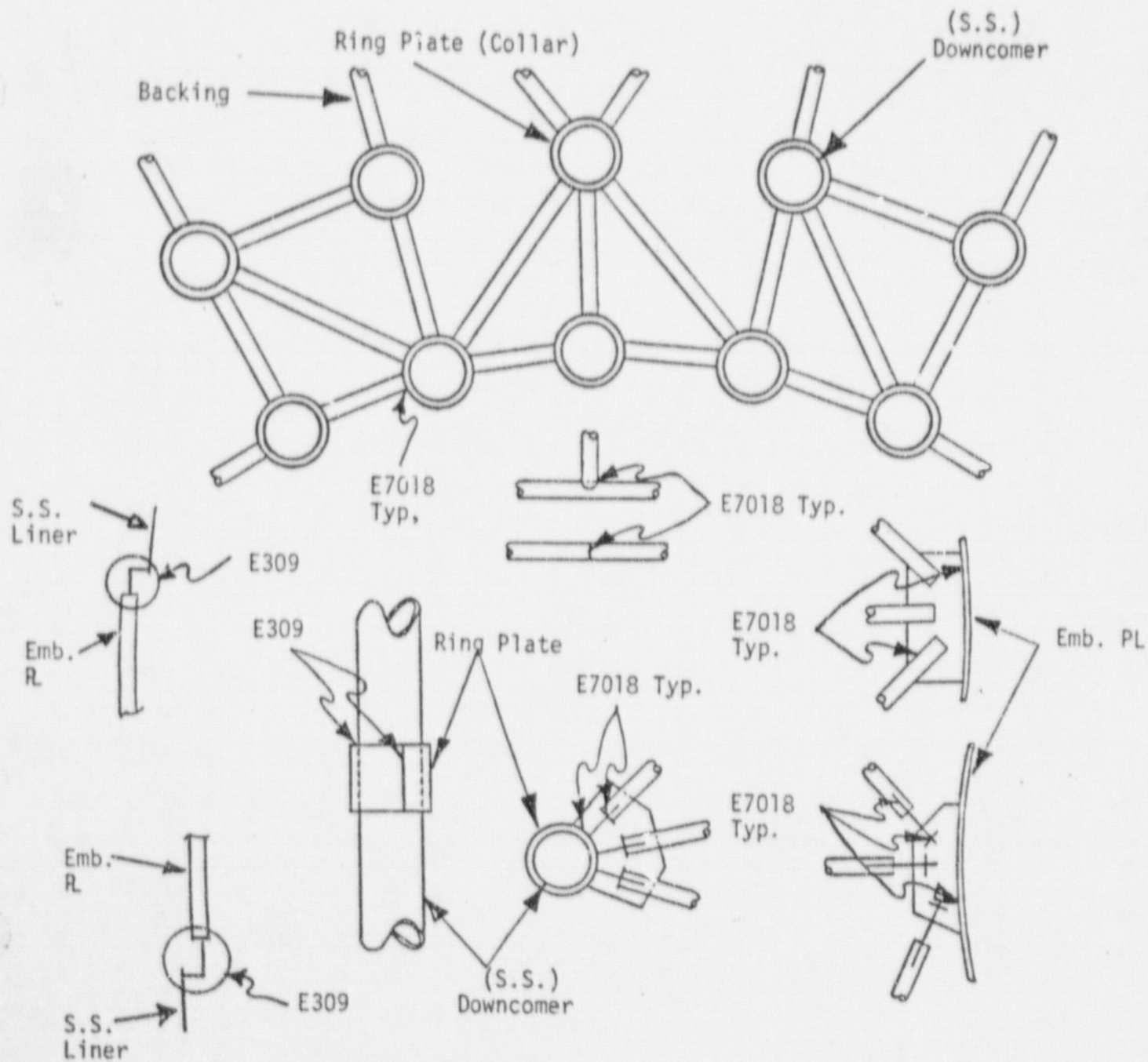


IDENTIFICATION WPAT
REV. NO. 6

CONTRACT 83670

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

PAGE NO. 4 OF 6



TYPICAL ELEVATIONS AND PLAN WELDS

NOTE: These sketches show only general details.



IDENTIFICATION WPAT

REV. NO. 5

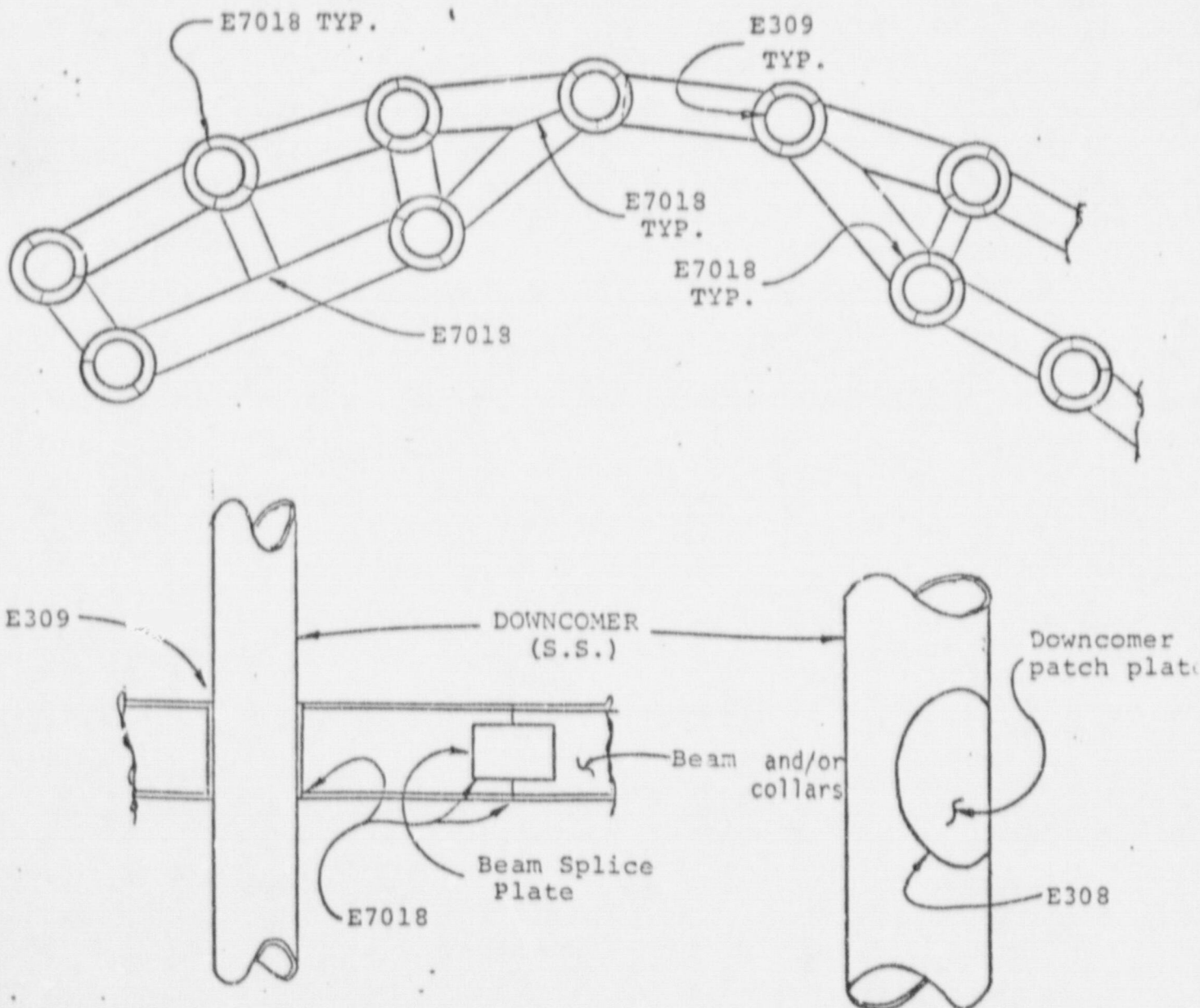
CONTRACT 83670

TITLE

WELDING PROCEDURE APPLICATION TABLE
DOWNCOMER BRACING & QUENCHER SUPPORT
& LINER WORK
LA SALLE COUNTY STATION

PRODUCT

PAGE NO. 5 OF 6



TYPICAL ELEVATIONS AND PLAN VIEWS

NOTE: These sketches show only general details,



IDENTIFICATION WPAT

REV. NO. 6

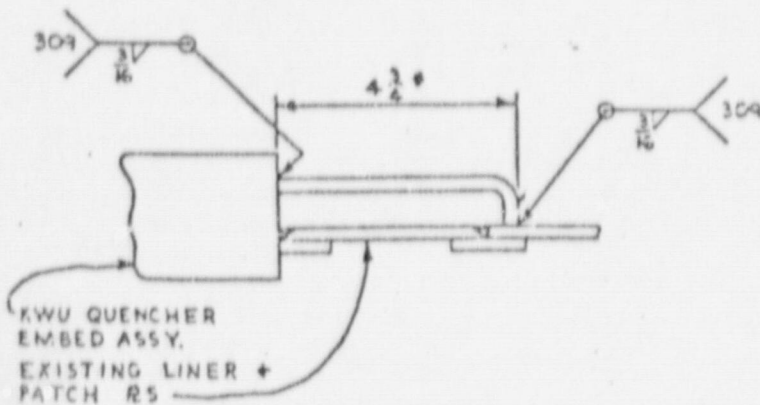
CONTRACT 83670

TITLE

WELDING PROCEDURE APPLICATION TABLE
DOWNCOMER BRACING & QUENCHER SUPPORT
& LINER WORK
LA SALLE COUNTY STATION

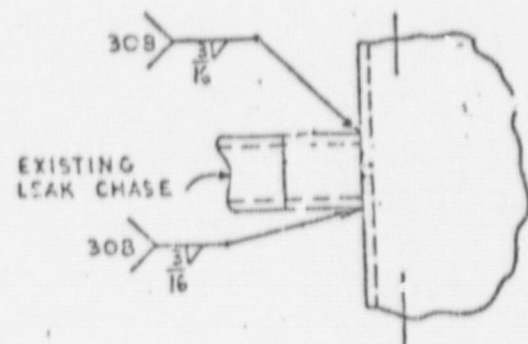
PRODUCT

PAGE NO. 6 OF 6

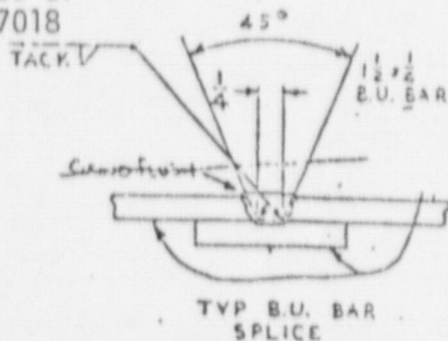
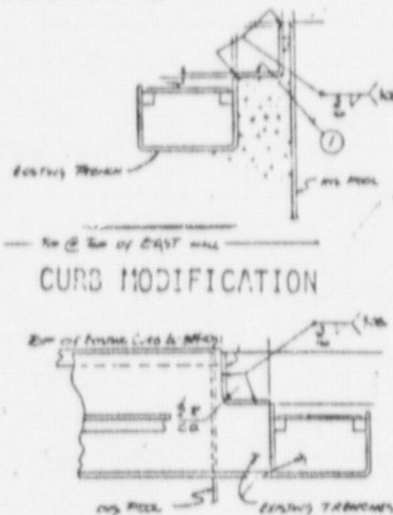


MAY BE UP TO 6 3/4 DUE TO FIELD TRIM

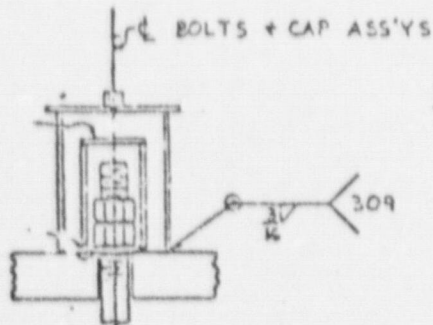
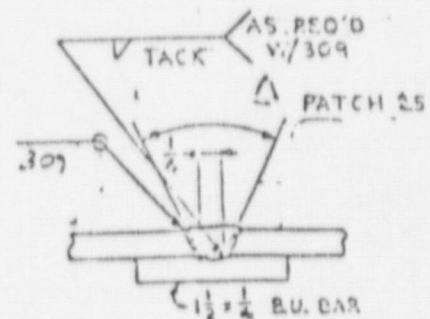
TYPICAL SECTION THRU BENT LEAK CHASE 2



TYPICAL AIR PASSAGE DETAIL

E309 or
E7018TYP B.U. BAR
SPLICE

CURB MODIFICATION

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