

THE M. W. KIMMORGE COMPANY

FOURTH FLOOR

A Division of FULMANN INCORPORATED

Diablo Canyon

SPECIFICATION CHANGE NOTICE

No. 1

Date 6-7-74

E.S.D. Number 227
Page 2 Paragraph(s) Chart

Title: Welding Procedures

TO: PACIFIC GAS & ELECTRIC

The above specification has been changed as follows:

The Weld Procedure Codes 88/89, 202, and 203 were added to the chart section on "Special Welding Procedures", to complete the section and concur with the Welding Procedures.

APPROVED:

M. W. K. Q.A./Q.C. Manager

P.G. & E. Engineer

Reason or Justification for Change: (Fill in when not obvious from above)

FOR INFORMATION ONLY

*Change Number to be assigned consecutively under each specification.

8708200236 870814
PDR FOIA
DEVINE84-743 PDR

Carbon Steel (Pl) to Carbon Steel (Pl)

PROPOSED GRADE	POSITION AND WALL THICKNESS LIMITS	BACKING PURGE	BACKING	BUTT FIT-UP	ROOT	WELDOUT	POST-WELD HEAT TREATMENT	USAGE AND TYPES OF WELD
201-1	1/16" - Max W.T. Up to 2'0.0" ONLY	None	Solar "R" Flux	Open Butt	GTAW E70S-2 or -6	SMAW E7015 16 or 18	As-welded or Heat Treated	Butt welds only
0	3/16" to 1.124" 2G Only	None	None	Open Butt	SMAW E6010	SMAW E7015 16 or 18	None	Class "E" Floor Drains
00	3/16" to 1.124" 5G Only	None	None	Open Butt	SMAW E6010	SMAW E7015 16 or 18	None	Class "E" Floor Drains
4/5	3/16" to 3.624"	Argon or None	None	Insert E70S-2 or -6	GTAW E70S-2 or -6	SMAW E7015 16 or 18	As-welded or Heat Treated	Butt Welds Only
7/6	3/16" to 3.624"	None	Backing Ring or Strip	3/16" min. Root Opening	SMAW E7015 16 or 18	SMAW E7015 16 or 18	As-welded or Heat Treated	Class "C" or "E" Butt Welds and Structural Steel
12/33	1/16"-0.56" (2G) 3/16"-0.812" (5G) 3/16"-3.25" (6)	None	None	Open Butt	SMAW E7015 16 or 18	SMAW E7015 16 or 18	As-welded or Heat Treated	Filletts, sockets, & couplings only
38/39 ①	3/16" to 3.624"	Argon or None	None	Open Butt	GTAW E70S-2 or -6	SMAW E7015 16 or 18	As-welded or Heat Treated	Butt welds only
200 ②	3/16" to 1.5"	Argon	None	Insert E70S-2 or -6	GTAW E70S-2 or -6	SMAW E 8018	Heat Treated Only	Mainsteam, Feedwater and Steam Generator Welds Only
201	1/16" to 0.56"	Argon	None	Insert E70S-2 or -6	GTAW E70S-2 or -6	GTAW E70S-2 or -6	As-welded or Heat Treated	Butt, filletts, socket and couplings
202 ①	1/16" to 0.436"	Argon	None	Open Butt	GTAW E70S-2 or -6	GTAW E70S-2 or -6	As-welded or Heat Treated	Butt, filletts, socket and couplings
203 ①	1/16" to 0.474"	None	None	Open Butt	GTAW E70S-2 or -6	GTAW E70S-2 or -6	As-welded or Heat Treated	Butt, filletts, socket and couplings
204 ②	3/16" to 1.5"	None	None	Open Butt	GTAW E70S-2 or -6	SMAW E 8018	Heat Treated Only	Mainsteam, Feedwater and Steam Generator Welds only

Notes: 1) Requires Q.A. Manager's approval before using on Mainsteam and Feedwater Systems.

2) Requires Q.A. Manager's approval before using anywhere on the site.

4) For filletts, sockets, and couplings; delete insert and root pass and follow with balance of passes

5) Argon backing purge required on the GTAW part of the process only

6) All thickness limits applies to material requiring heat treatment

FOR INFORMATION ONLY

Carbon Steel (P1) to Carbon Steel (P1)

PROCEDURE CODE NO.	POSITION AND WALL THICKNESS LIMITS	BACKING PURGE ⑤	BACKING	BUTT FIT-UP	ROOT	WELDOUT	POST-WELD HEAT TREATMENT	USAGE AND TYPES OF WELD
205	1G, 2G, & 3G unlimited wall thickness	None	Backing Strip 3/8" min. thickness	Groove 3/16" min. gap	Opt. E7018 Root GMAW E70T-1	GMAW E70T-1	None	Rupture Restraints Only
206	1G, 2G, & 3G unlimited wall thickness	None	Backing Strip 3/8" min. thickness	Groove 3/16" min. gap	Opt. E7018 Root GMAW E70S-3	GMAW E70S-3	None	Rupture Restraints Only
25/26	3/16" to 1.0"	None	None	Open Butt	GMAW E70S-3 GTAW E70S-2 SMAW E7018	GMAW E70S-2 -3, or -6	None	Butt, sockets, and couplings

Stainless Steel (P8) to Stainless Steel (P8)

PROCEDURE CODE NO.	POSITION AND WALL THICKNESS LIMITS	BACKING PURGE ⑤	BACKING	BUTT FIT-UP	ROOT	WELDOUT	POST-WELD HEAT TREATMENT	USAGE AND TYPES OF WELD
15/16	3/16" to 1.4"	Argon	None	Insert ④ ER 308	GTAW ER 308	SMAW E 308 ③	None	Butt, fillet, and socket
19/80	1/16" to 1.0"	Argon	None	Insert ER 308	GTAW ER 308	GTAW ER 308	None	Butt welds only
29	1/16" to 0.56"	Argon	None	Open ④ Butt	GTAW ER 308	GTAW ER 308	None	Butt, fillet, and socket

Carbon Steel (P1) to Stainless Steel (P8)

PROCEDURE CODE NO.	POSITION AND WALL THICKNESS LIMITS	BACKING PURGE ⑤	BACKING	BUTT FIT-UP	ROOT	WELDOUT	POST-WELD HEAT TREATMENT	USAGE AND TYPES OF WELD
49	3/16" to 1.436" over 2" O.D. ONLY	Argon	None	Insert ④ ER 309	GTAW ER 309	SMAW E 309	None	Butt, fillet, and socket
150	1/16" to 0.56"	Argon	None	Insert ④ ER 309	GTAW ER 309	GTAW ER 309	None	Butt, fillet, and socket

Notes: 3) Optional GTAW cover pass allowed, using ER 308.

4) For fillets, sockets, and couplings, delete insert and root pass and follow with balance of passes.

5) Argon backing required on the GTAW part of the process.