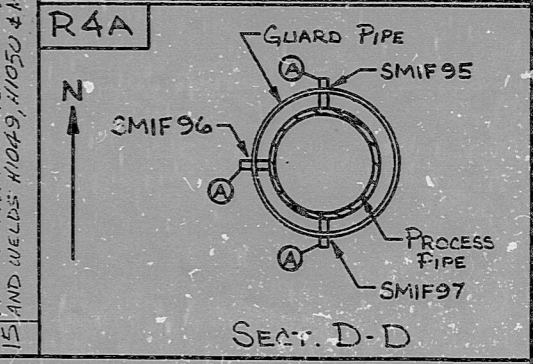
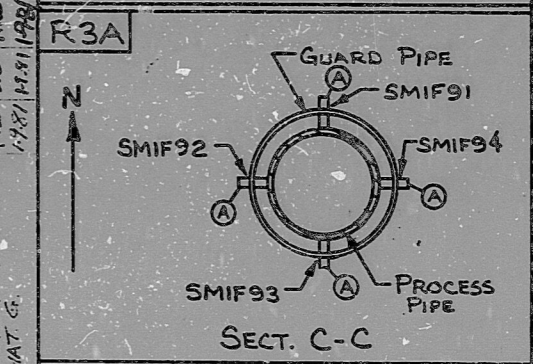
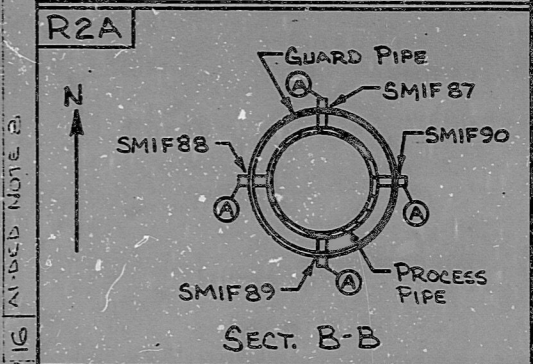
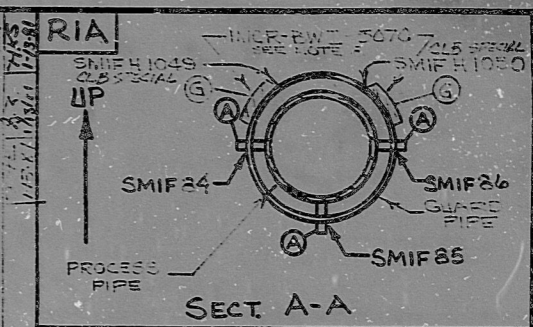
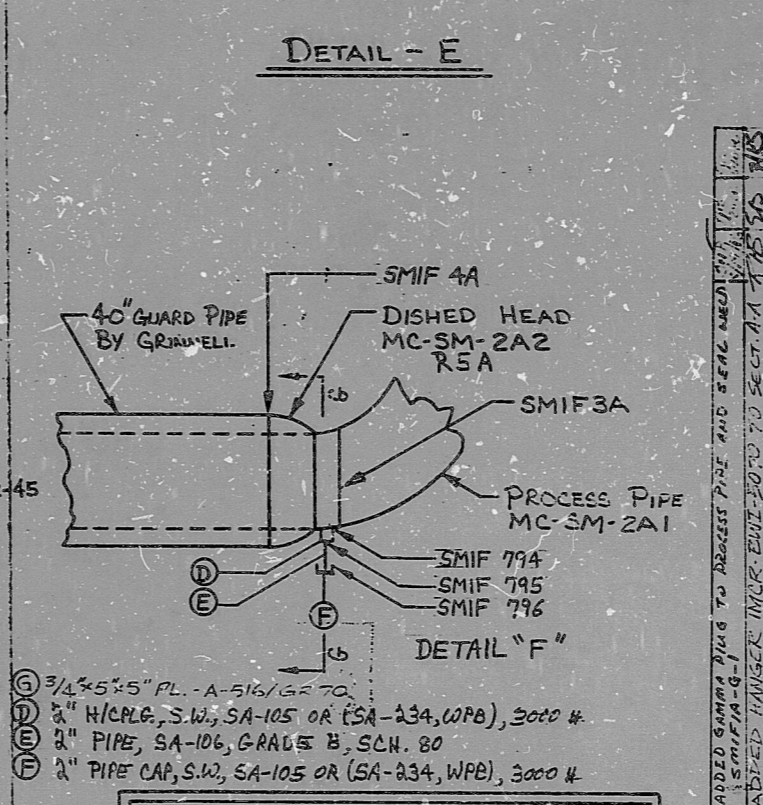
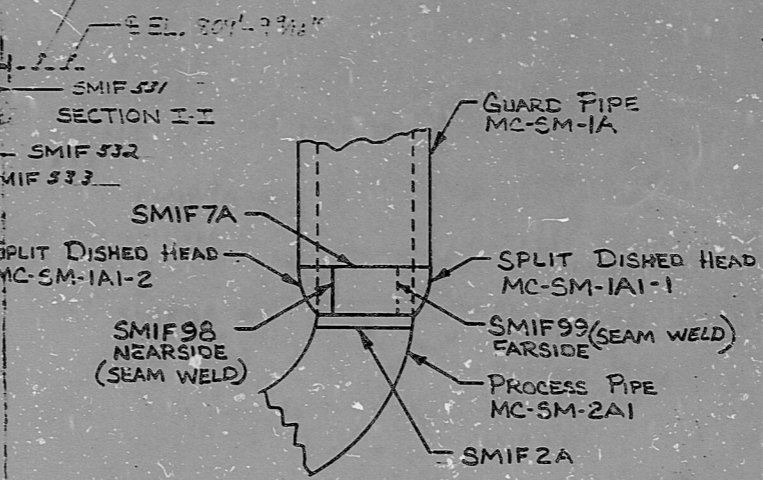
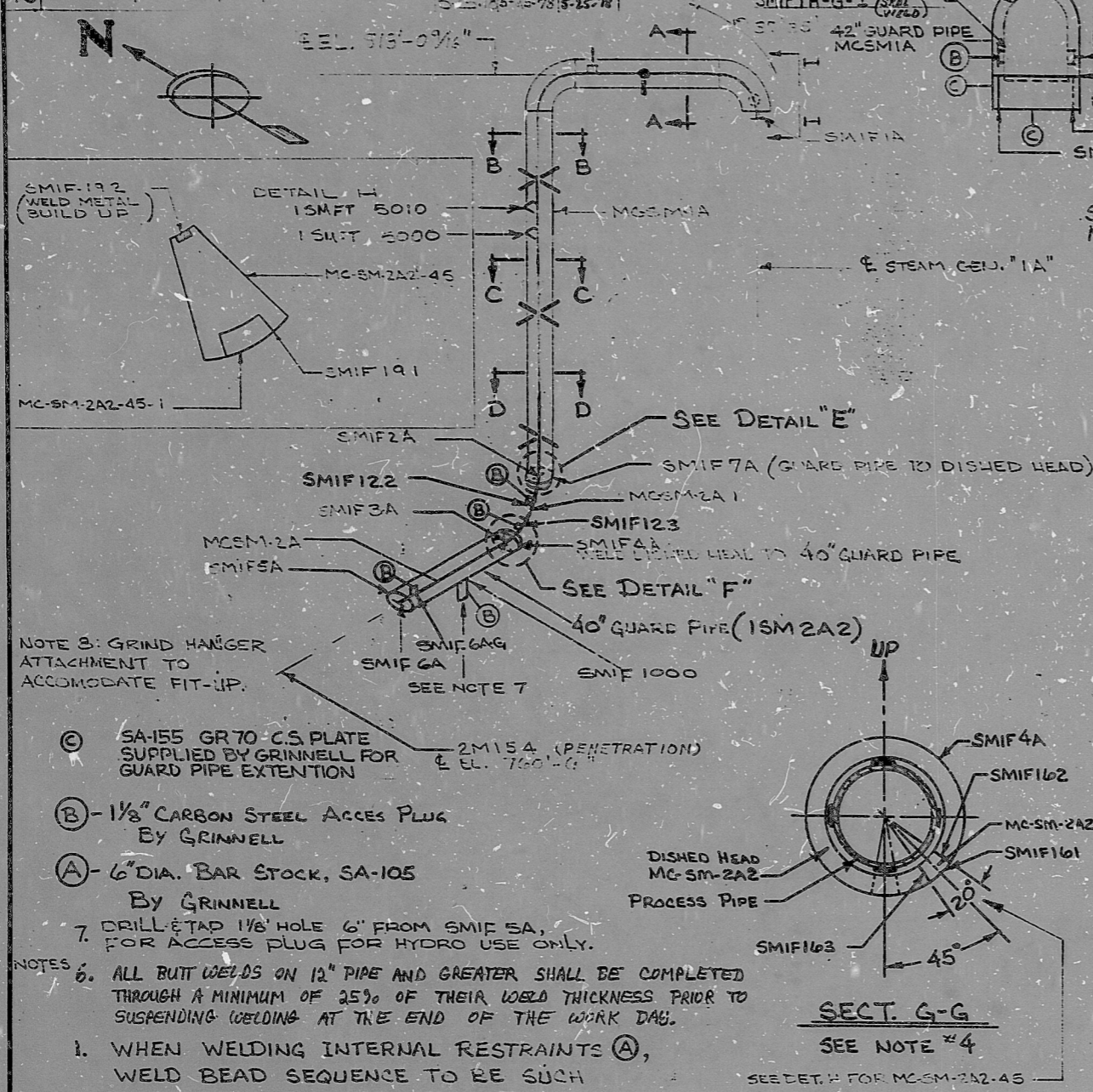


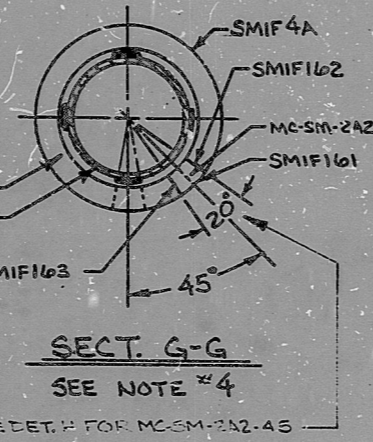
12 ADDED MAT'S D,E,F AND WELDS SMIF 794 THRU 796
 13 ADD SMIF 1000 & NOTE 7

INSERVICE INSPECTION

14 REV TO ADD INSTL TAPS SMIT 5000 & 5010 ON E LAYOUT
 CONT. ON ISO. 15M-18



- NOTE 3: GRIND HANGER ATTACHMENT TO ACCOMMODATE FIT-UP.
- ⓐ SA-105 GR 70 CS PLATE SUPPLIED BY GRINNELL FOR GUARD PIPE EXTENSION
 - ⓑ 1/2" CARBON STEEL ACCESS PLUG BY GRINNELL
 - ⓐ 6" DIA. BAR STOCK, SA-105 BY GRINNELL
7. DRILL & TAP 1/8" HOLE 6" FROM SMIF SA, FOR ACCESS PLUG FOR HYDRO USE ONLY.
- NOTES
6. ALL BUTT WELDS ON 12" PIPE AND GREATER SHALL BE COMPLETED THROUGH A MINIMUM OF 25% OF THEIR WELD THICKNESS PRIOR TO SUSPENDING WELDING AT THE END OF THE WORK DAY.
 1. WHEN WELDING INTERNAL RESTRAINTS (A), WELD BEAD SEQUENCE TO BE SUCH THAT THE WELD PROGRESS FROM THE RESTRAINT TO THE PIPE WALL.
 2. RESTRAINTS: R1A, R2A, R3A, R4A, R5A ARE DESCRIBED IN MAINSTEAM COLD PULL PROCEDURE WRS-02-20-76-1.
 3. DOCUMENTATION FOR ACCESS PLUG WELDS SHALL BE FILED WITH THE ADJACENT PROCESS PIPE WELD.
 4. A 20° PORTION OF THE DISHED HEAD (MC-SM-2A2) WILL BE REMOVED FOR FIT-UP PURPOSES (PIE SHAPED SECTION TO BE REMOVED & LABELED MC-SM-2A2-45). UPON FIT-UP, THE REMOVED SECTION WILL BE ROTATED APPROXIMATELY 45° TO POSITION THIS AREA BETWEEN THE TWO SUPPORT PADS ON THE LOWER & RIGHT SIDES. REMOVED SECTION WILL BE RE-FIT & WELDED I.A.W. PROCEDURE M-4.



- ⓐ 3/4" x 5/8" PL. A-516/670
- ⓑ 2" H/CPLG, S.W., SA-105 OR (SA-234, WPB), 3000 #
- ⓐ 8" PIPE, SA-106, GRADE B, SCH. 80
- ⓐ 1" PIPE CAP, S.W., SA-105 OR (SA-234, WPB), 3000 #

NOTE (5): GUARD PIPE HAS BEEN DOWNGRADED TO CLASS "H" WITH CLASS "B" INSTALLATION REQUIREMENTS. PIPE HAS BEEN INSTALLED AS CLASS "B" AND WILL REMAIN INSTALLED AS I.A.W. RS-1500.6

NO.	ADDED MAT. AND WELDS	RDH	CHKD	DATE	BY
10	ADDED MAT. AND WELDS SMIF 531 THRU 533	RDH	HEB	9-1-77	9-2-77
9	ADDED NOTE # 5, ZONE	RDH	HEB	8-27-77	9-2-77
8	ADDED SECTION I-I	RDH	HEB	8-27-77	9-2-77
7	ADD DET. H SMIF 191 SMIF 192, Q IN 2713	RDH	HEB	8-27-77	9-2-77

NDE REQUIREMENTS

REFER TO PROCESS CONTROL INFORMATION OF FIELD WELLS AND/OR CRACKS FOR NDE REQUIREMENTS.

NUCLEAR SAFETY RELATED PROJECT

DUKE PIPING CLASS: E PS 1500.5 & .6

SYSTEM TITLE & SYMBOL: SM-MAINSTEAM

BUILDING: REACTOR ZONE R-6

FOR INFORMATION ONLY

1.1

SI APERTURE CARD

DRAWING NO. MC-1625-1 MC-1625-1B 20-00

NO.	ADDED NOTE	RDH	CHKD	DATE	BY
11	ADDED NOTE 6	RDH	HEB	9-15-77	9-27-77
10	ADDED SECT. G-G & NOTE #4	RDH	HEB	10-26-77	10-26-77
5	ADDED SPEC. NO. 15M2A2	RDH	HEB	10-13-76	10-22-76

NO.	REVISION	ORIG.	CHD.	MECH.	Q.A.	DATE	DATE	DATE	DATE
4	REVISED TO ADD DETAILS & SECTS	HKS	HEB	HEB	HEB	9-10-76	9-21-76	9-27-76	9-27-76
3	ADD WELL 7A	RDH	HEB	HEB	HEB	8-11-76	8-15-76	8-20-76	8-20-76
2	CHANGE PEN NO# (2M154)	RFR	HEB	HEB	HEB	1-8-76	1-8-76	1-8-76	1-8-76
1	WELL ANNOTATION CORRECTION	RDH	HEB	HEB	HEB	10-7-75	10-7-75	10-7-75	10-7-75
0	WELL FOR 7A	RDH	HEB	HEB	HEB	10-1-75	10-1-75	10-1-75	10-1-75

NO.	REVISION	ORIG.	CHD.	MECH.	Q.A.	DATE	DATE	DATE	DATE
4	REVISED TO ADD DETAILS & SECTS	HKS	HEB	HEB	HEB	9-10-76	9-21-76	9-27-76	9-27-76

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PDR RIDS

