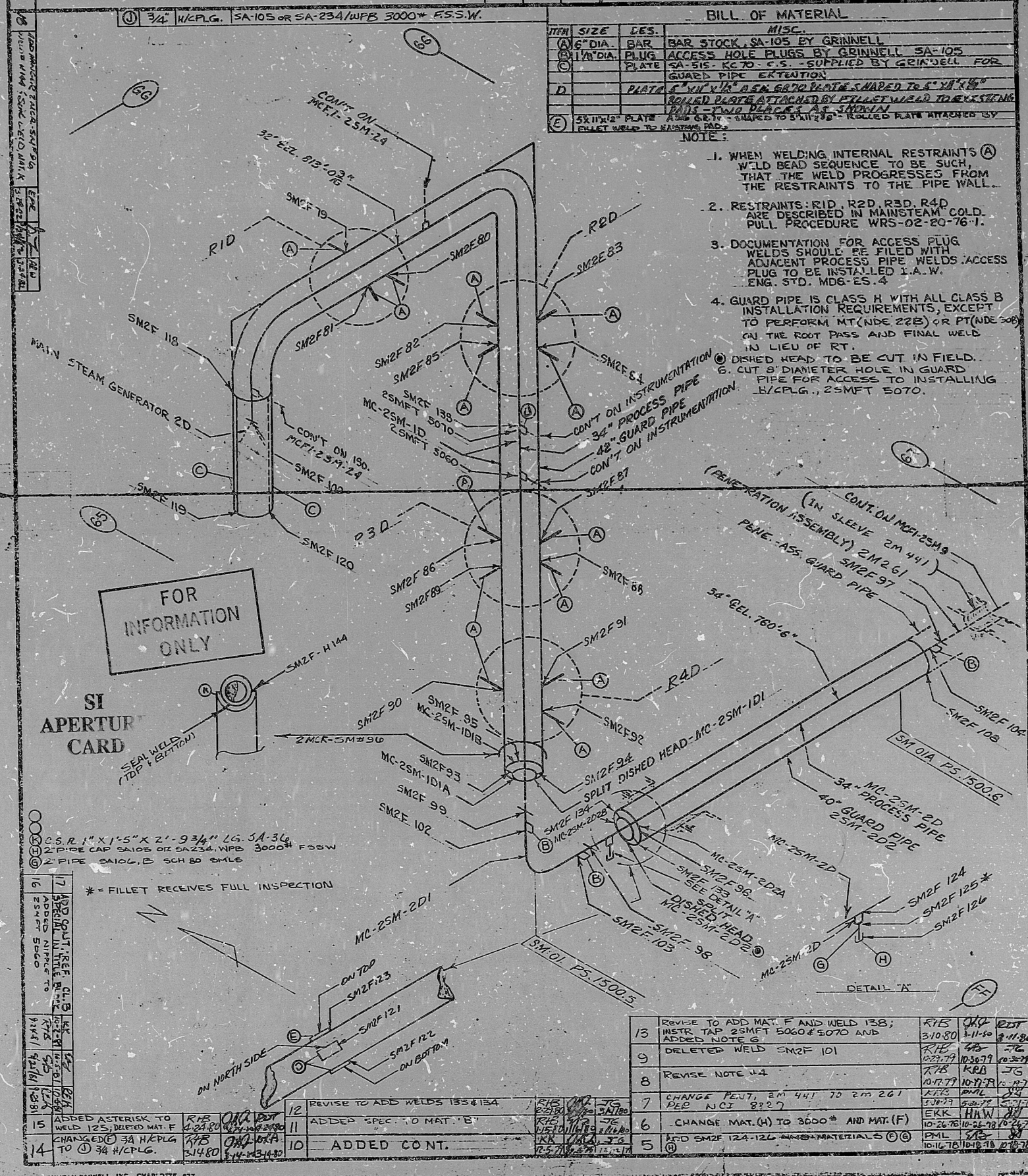


NO.	REVISION	QA CONDITION	ORIG. DATE	CHKD. DATE	APPR. DATE
4	ADD MAT (E) AND SMZF 123				
3	ADDED 'D' WELDS SMZF-121 + 122				
2	ADDED WELDS SMZF 108, SMZF 118, SMZF 120 ALSO MAT 'C' & GUARD PIPE FOR PEN. ASS.				
1	DELETED NOTE #5				
0	RELEASE FOR CONSTRUCTION				

REV. 18	REV. 18	REV. 18
TSO NO: MCFI 2SM 4	DUKE PIPING CLASS: (CLASSIFIED) SPECIAL ASME SECTION III CL. B	BUILDING: REACTOR ZONE R28
SYSTEM SYMBOL: SM - MAIN STEAM	PIPING SPEC.: SM 01.01A PS. 1500.5 & 6	DRAWING NO.: MC 1625-1
		FL. EL. 750'-0"
		PROJECT: MC GUIRE



ITEM	SIZE	QTY.	DESC.	MISC.
1	1/2" DIA.	BAR	BAR STOCK, SA-105 BY GRINNELL	
2	1/4" DIA.	PLUG	ACCESS HOLE PLUGS BY GRINNELL SA-105	
3	1/4" DIA.	PLATE	SA-515-KC70-C.S. SUPPLIED BY GRINNELL FOR GUARD PIPE EXTENSION	
4		PLATE	1/4" X 1/4" A.S.M. 6870 PLATE SHAPED TO 4" X 1/4" ROLLED PLATE ATTACHED BY FILLET WELD TO EXISTING	
5	5/8" DIA.	PLATE	1/4" X 1/4" A.S.M. 6870 PLATE SHAPED TO 5/8" X 1/4" ROLLED PLATE ATTACHED BY FILLET WELD TO EXISTING	

- NOTE:
- WHEN WELDING INTERNAL RESTRAINTS (A) WELD BEAD SEQUENCE TO BE SUCH THAT THE WELD PROGRESSES FROM THE RESTRAINTS TO THE PIPE WALL.
 - RESTRAINTS: R1D, R2D, R3D, R4D ARE DESCRIBED IN MAINSTEAM COLD PULL PROCEDURE WRS-02-80-76-1.
 - DOCUMENTATION FOR ACCESS PLUG WELDS SHOULD BE FILED WITH ADJACENT PROCESS PIPE WELDS. ACCESS PLUG TO BE INSTALLED I.A.W. ENG. STD. MDG-ES.4
 - GUARD PIPE IS CLASS H WITH ALL CLASS B INSTALLATION REQUIREMENTS, EXCEPT TO PERFORM MT (NDE 22B) OR PT (NDE 20B) ON THE ROOT PASS AND FINAL WELD IN LIEU OF RT.
 - DISHED HEAD TO BE CUT IN FIELD.
 - CUT 8" DIAMETER HOLE IN GUARD PIPE FOR ACCESS TO INSTALLING BY/PLG., 2SMFT 5070.

FOR INFORMATION ONLY

SI APERTURE CARD

SEAL WELD (TOP POSITION)

2" PIPING CAP SA105 OR SA234/WPB 3000 FSSW

2" PIPE SA106.B SCH 80 SMLE

* - FILLET RECEIVES FULL INSPECTION

NO.	REVISION	QA CONDITION	ORIG. DATE	CHKD. DATE	APPR. DATE
15	ADDED ASTERISK TO WELD 125 BEYOND MAT F				
14	CHANGED SA HPLG TO 34" H/PLG				
13	REVISE TO ADD MAT F AND WELD 158; INSTR TAP 2SMFT 5060 & 5070 AND ADDED NOTE 6				
9	DELETED WELD SMZF 101				
8	REVISE NOTE #4				
7	CHANGE FEWT, 2M 441 TO 2M 201 PER NCT 8227				
6	CHANGE MAT. (H) TO 3000* AND MAT. (F)				
5	ADD SMZF 124-126 MATERIALS (C)				
12	REVISE TO ADD WELDS 135 & 134				
11	ADDED SPEC. TO MAT. 'E'				
10	ADDED CONT.				

NO.	REVISION	QA CONDITION	ORIG. DATE	CHKD. DATE	APPR. DATE
13	REVISE TO ADD MAT F AND WELD 158; INSTR TAP 2SMFT 5060 & 5070 AND ADDED NOTE 6				
9	DELETED WELD SMZF 101				
8	REVISE NOTE #4				
7	CHANGE FEWT, 2M 441 TO 2M 201 PER NCT 8227				
6	CHANGE MAT. (H) TO 3000* AND MAT. (F)				
5	ADD SMZF 124-126 MATERIALS (C)				

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PDR RIDS

