



**NOZZLE INSULATION REMOVAL CHART**

NOZZLE NO.	QTY	SIZE	FUNCTION	INSUL. OPENING
N-1	2	20"	RECIRCULATION OUTLET	15" x 15"
N-2	10	12"	RECIRCULATION OUTLET	15" x 15"
N-3	4	24"	STEAM OUTLET	24" x 24"
N-4	2	6"	FEEDWATER	6" x 6"
N-5	2	10"	COOL SPRAY	6" x 6"
N-6	2	4"	NET PURG. SUPPLY	6" x 6"
N-7	1	5"	CEED RETURN	6" x 6"
N-8	1	2"	SOOT BLOWER FEED	6" x 6"
N-9	2	2"	INSYUMENTATION	6" x 6"
N-10	2	2"	INSYUMENTATION	6" x 6"
N-11	2	2"	INSYUMENTATION	6" x 6"
N-12	2	2"	INSYUMENTATION	6" x 6"
N-13	2	2"	INSYUMENTATION	6" x 6"

**WELD INSULATION REMOVAL CHART**

WELD NO.	QTY	FUNCTION	INSUL. OPENING
W-1	1	CIRC & LGN WELD	2' x 2' 6"
W-2	1	CIRC & LGN WELD	2' x 2' 6"
W-3	1	CIRC & LGN WELD	2' x 2' 6"
W-4	1	CIRC & LGN WELD	2' x 2' 6"
W-5	1	CIRC & LGN WELD	2' x 2' 6"
W-6	1	CIRC & LGN WELD	2' x 2' 6"
W-7	1	CIRC & LGN WELD	2' x 2' 6"
W-8	1	CIRC & LGN WELD	2' x 2' 6"
W-9	1	CIRC & LGN WELD	2' x 2' 6"
W-10	1	CIRC & LGN WELD	2' x 2' 6"
W-11	1	CIRC & LGN WELD	2' x 2' 6"
W-12	2	CIRC & MERID WELD	2' x 2' 6"
W-13	1	CIRC & LGN WELD	2' x 2' 6"

CIRC - CIRCUMFERENTIAL  
LGN - LONGITUDINAL  
MERID - MERIDIONAL

**VESSEL SEGMENT WELDS**

WELD NO.	LENGTH	WELD NO.	LENGTH
VC-F-1	750"	VV-TH-1E	83"
VC-I-2	750"	VV-TH-1F	83"
VC-2-3	750"	VV-TH-1G	83"
VC-3-4	750"	VV-TH-1H	83"
VV-1A	150"	VC-2-3H1	714"
VV-1B	150"	VC-2-3H2	562"
VV-1C	150"	VC-2-3H3	517"
VV-2A	150"	VV-BH-1A	64"
VV-2B	150"	VV-BH-1B	64"
VV-2C	150"	VV-BH-1C	64"
VV-3A	150"	VV-BH-1D	64"
VV-3B	150"	VV-BH-1E	64"
VV-3C	150"	VV-BH-1F	64"
VV-4A	150"	VV-BH-1G	64"
VV-4B	150"	VV-BH-1H	64"
VV-4C	150"	VV-BH-1I	64"
VC-TH-2F	670"	VV-BH-1J	64"
VC-TH-2G	530"	VV-BH-1K	64"
VV-TH-1B	83"	VV-BH-2D	54"
VV-TH-1C	83"	VV-BH-2E	54"
VV-TH-1D	83"	VC-SK-2	552"

**SKIRT SEGMENT WELDS**

WELD NO.	LENGTH	WELD NO.	LENGTH
VC-SK-1	552"	VH-SK-1	39"
VC-SK-2	532"	VH-SK-2	39"
VV-SK-1	27"	VH-SK-3	39"
VV-SK-2	27"	VH-SK-4	39"

**WELDED AT ATTACHMENTS**

ITEM	THK'S	ITEM	THK'S
LIFTING LUG	5"	STABILIZER	6 1/2"
SUPPORT BRKT	3/4"		

**NOTES**

1. FOR DETAIL OF SUPPORT BRACKET SEE COMBUSTION ENGINEERING DWG NO E235-249

2. ALL REF DWGS ARE IN THE FITZPATRICK REACTOR VESSEL INSTRUCTION MANUAL BY COMBUSTION ENGINEERING FOR G.E.-GE BOOK NO E1506 7/11

DATE	DESCRIPTION	BY	CHKD
	FOR INFORMATION		

JAMES A. FITZPATRICK NUCLEAR POWER PLANT

I.S.I. REACTOR VESSEL STRETCHOUT FOR WELD DESIGNATION & INSULN REMOVAL

POWER AUTHORITY OF THE STATE OF NEW YORK

SCALE: AS NOTED DWG. 850358FM001 REV. 0 DATE 9-18-55

DB

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