



NO.	REVISIONS	DATE	APPROVED
1	ISSUED FOR FABRICATION	12/15/68	[Signature]
2	ADDED DETAIL B	1/10/69	[Signature]
3	ADDED DETAIL C	1/10/69	[Signature]
4	ADDED DETAIL D	1/10/69	[Signature]
5	ADDED DETAIL E	1/10/69	[Signature]
6	ADDED DETAIL F	1/10/69	[Signature]
7	ADDED DETAIL G	1/10/69	[Signature]
8	ADDED DETAIL H	1/10/69	[Signature]
9	ADDED DETAIL I	1/10/69	[Signature]
10	ADDED DETAIL J	1/10/69	[Signature]

UNCONTROLLED PRINT
DO NOT USE FOR OPERATION OR MAINTENANCE UNLESS VERIFIED TO BE THE LATEST REVISION IN ACCORDANCE WITH THE DRAWING INDEX.
JUN 19 1981

POOR ORIGINAL

TERA APERTURE CARD

VERIFIED BY [Signature]
APPROVED BY [Signature]
DATE 12-1-78
DR. NR02

10. FABRICATION & INSPECTION SHALL BE IN ACCORDANCE WITH U.S. SPEC. LR 2.2-2.5 (1962) EDITION 1 AND U.S. SPEC. LR 2.2-2.5 (1962) EDITION 2.

11. ALL DIMENSIONS ARE TO BE MARKED WITH LOW STRESS STEEL STAMP 1/16" DEPTH. ALL MARKING TO BE REMOVED BEFORE SHIPMENT.

12. FABRICATION & INSPECTION SHALL BE IN ACCORDANCE WITH THE PROVISIONS OF:

- (A) ASME BOILER CODE, SECTION I, 1962 EDITION 1 AND U.S. SPEC. LR 2.2-2.5 (1962) EDITION 1 AND 2.
- (B) GENERAL WELDING PROC. QW-450.1 AND THE APPLICABLE ADDENDA CONTAINED THEREIN.
- (C) MAXIMUM CARBON AT MACHINED OR AS CLAD SURFACES TO BE 0.05 PERCENT FOR STAINLESS STEEL CLADDING.
- (D) MAXIMUM CARBON CONTENT OF ALL MATERIALS TO BE 0.02 PERCENT.

13. DOUBLE ARROW INDICATES DIMENSION TO GIVEN REFERENCE LINE.

14. SIZES IN U/M ARE FINISHED SIZES. NO ALLOWANCE MADE FOR FABRICATION OR WELD SHRINKAGE, UNLESS NOTED.

15. DIMENSIONS ARE IN INCHES, ELEVATIONS ARE IN FEET.

16. PREFERENCES (REF) DIMENSIONS ARE FOR INFORMATION ONLY. DO NOT USE FOR FABRICATION.

17. ALL WELDING FABRICATION AND INSPECTION SHALL BE IN ACCORDANCE WITH THE PROVISIONS OF:

- (A) ASME BOILER CODE, SECTION I, 1962 EDITION 1 AND U.S. SPEC. LR 2.2-2.5 (1962) EDITION 1 AND 2.
- (B) GENERAL WELDING PROC. QW-450.1 AND THE APPLICABLE ADDENDA CONTAINED THEREIN.
- (C) MAXIMUM CARBON AT MACHINED OR AS CLAD SURFACES TO BE 0.05 PERCENT FOR STAINLESS STEEL CLADDING.
- (D) MAXIMUM CARBON CONTENT OF ALL MATERIALS TO BE 0.02 PERCENT.

GENERAL NOTES

- SYMBOLS LISTED BELOW DENOTE WELDS OR SURFACES TO BE TESTED BY:
- RADIOGRAPHIC INSPECTION
- MAGNETIC PARTICLE INSPECTION PER MAP NO. 2.4.2.1 (1962)
- CO DENOTES WELD JOINTS WELD TABLE
- WELD JOINTS WELD TABLE
- NOZZLE DETAILS - VESSEL
- NOZZLE DETAILS - VESSEL

REFERENCE DRAWINGS

NO.	TITLE	DWG. NO.	WELD NO.	PROC. NO.
1	VESSEL FORMING & WELDING - LOWER	E-232-564	1-562	1-562
2	VESSEL MACHINING - SHEET METAL	E-232-570	2-562	2-562
3	VESSEL MACHINING - SHEET METAL	E-232-571	3-562	3-562
4	VESSEL SUPPORT SKIRT DETAILS (ASSY)	E-232-569	4-562	4-562
5	NOZZLE DETAILS - VESSEL	E-232-565	5-562	5-562
6	NOZZLE DETAILS - VESSEL	E-232-566	6-562	6-562

LIST OF MATERIAL QUANTITIES FOR 1 (ONE) UNIT

ITEM NO.	DESCRIPTION	QTY.	UNIT	MATERIAL	REMARKS
1	CORE OF PRESSURE NOZZLE ASSY.	1	UNIT	304 SS	
2	ASSY. REAR VET NOZZLE	1	UNIT	304 SS	
3	BACKING STRIPS - 1/4" X 1/4" X 1/4"	100	PCS.	304 SS	
4	SIDE SEGMENT - 1/4" MIN. THK. X 1/4" X 1/4"	100	PCS.	304 SS	
5	SIDE SEGMENT - 1/4" MIN. THK. X 1/4" X 1/4"	100	PCS.	304 SS	
6	DOME SEGMENT - 1/4" MIN. THK. X 1/4" X 1/4"	100	PCS.	304 SS	
7	BOTTOM HEAD ASSEMBLY - CONSISTING OF:	1	UNIT	304 SS	

COMBUSTION ENGINEERING, INC.
CHATTANOOGA DIVISION

BOTTOM HEAD FORMING & WELDING FOR GENERAL ELECTRIC REACTOR VESSEL

APPROVED: [Signature] DATE: 1/10/69

SCALE: AS SHOWN

3/10/110568

R101

8108110568

