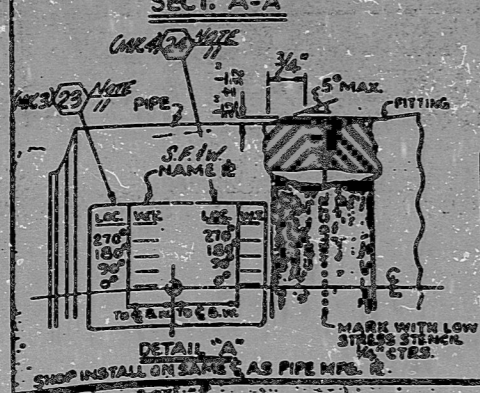
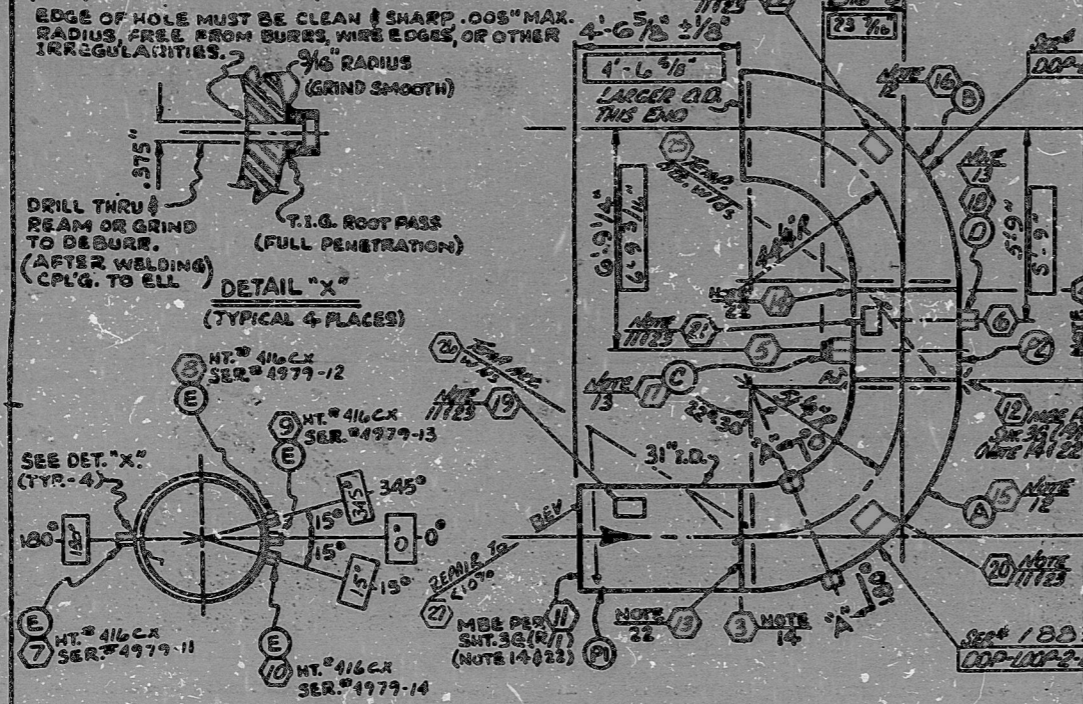


ANSTEC
APERTURE
CARD

WELD END DIMENSIONAL CHECK		LIP THICKNESS		WALL THICKNESS AND WELD JOINT LOCATION	
ITEM	C = 2.000 ± .010	ITEM	90°	ITEM	180°
(11)	ACTUAL = 2.132 - 2.229	(1)	2.00	(1)	2.00
(12)	ACTUAL = 2.197 - 2.219	(2)	2.00	(2)	2.00
(13)	ACTUAL = 2.181 - 2.291	(3)	2.00	(3)	2.00



NOTE (1) (2) (3) (4)

SOUTHWEST FABRICATING AND WELDING CO.
(Name of Manufacturer)

18032-18040
(Manufacturer's Serial No.)

1961
(Year Built)

1-EACH REQ'D MK'G AS SHOWN

- ASSE 111 154 TRES ASSEMBLY
4 CODE CASE 1423-2
1. MAKE WITH LOW STRESS STEEL OR TYP. METAL AND SERIAL NO. TO BE APPLIED TO EACH PART OF THE FABRICATED ASSEMBLY.
 2. SEE ATTACHED MANUFACTURING DESIGNS SHEET FOR DOCUMENTATION AND PROCEDURES.
 3. INSTALL 1/4" THICK 2" HOLEDRILL PIN SIZE 35(1/2) AND LARGER HOLES PER SHEET SA(1/2)
 4. T.I.G. ROOT PASS OF ALL WELDS.
 5. COMPLETE GRIND ALL WELDS - 250 GRIT FOLLOWS IMPROVEMENT OF BETT WELDS IN 1/16" PER DAY.
 6. ALL THROUGH ATTACHMENTS SHALL BE OF A COMPARABLE AND IDENTIFIED MATERIAL.
 7. ALL SURFACES FROM WHICH METAL HAS BEEN GRIND BY THE SHOP, SHALL BE LUBED PERMANENTLY EXCEPT FOR PORTS.
 8. LIQUID PENETRANT EXAMINE PER PROCEDURE THE ROOT PASS, AND ALL ACCESSIBLE SURFACES OF FINISHED WELDS, BEHIND WELDS, FILLER WELDS, AND THE WELD AFFECTION ZONE OF THE BASE METAL ADJACENT TO THE WELD. IN ADDITION, FOR HOLES 3" AND SMALLER, LIQUID PENETRANT EXAMINE EACH 1/2" INCREMENT OF WELD CORROSION.
 9. REMOVE SOOT FROM ALL S.P.T. CORROSION SURFACES PER PROCEDURE.
 10. LIQUID PENETRANT EXAMINE PER PROCEDURE ACCESSIBLE FINISHED INSIDING HOLES CORROSION AND CORROSION SURFACE INSIDING HOLES OF INSIDING WELDS.
 11. LIQUID PENETRANT EXAMINE PER PROCEDURE ALL PIPE WELD SEAMS AND WELD SURFACE OFF THE WALL FOR I.D. HOLES WELD. RADIOGRAPH 2" AND LARGER WELD WELD AND HOLES WELD FOR PROTECTIVE.
 12. CLEAN AND PREPARE FOR SHIPPING PER PROCEDURE (NOTE 1) (NOTE 2) (NOTE 3).
 13. DIMENSION LISTING 2" (3" FOR FIELD WELD SURFACES) (1- PLACES).
 14. DIMENSION LISTING 3" (3" FOR FIELD WELD SURFACES) (1- PLACES).
 15. SHOP TO COMPLETE 1/2" DIA. HOLES ON PIPE AND FITTING PLATE.
 16. FILLER METAL: TYP. (STAINLESS STEEL)
 17. APPROX WELD TENSILE STRENGTH AND MEASURED LOCATION OF WELD JOINT OR WELD PLATE AND TABLE PER DETAIL 'A'
 18. 3/4" MIN. DESIGN THICKNESS 2 1/2"
 19. SHOP WELD CUSTOMER FURNISHED MATERIAL IN SPACES INDICATED.

NO: 171903

QA CONDITION 1

DUKE POWER COMPANY
PLANT - CATAWBA NUCLEAR STATION
UNITS: 1 & 2
STATUS: AS MANUFACTURED
CERTIFICATION LTR. NO. CATAWBA-3306
AUTHORITY: P. J. TWOGOOD
ENGR. LTR. NO. EP/SA-5197

SOUTHWEST FABRICATING & WELDING CO. P.O. BOX 340 DUKESVILLE, MISSISSIPPI

NO.	DATE	BY	REVISION	REASON
1	11/11/68	JJK	1	ISSUE FOR FABRICATION
2	12/13/68	JJK	2	ADD DIMENSIONS
3	4/22/78	JJK	3	ORIGINAL ISSUE
4	1/19/79	JJK	4	REVISION

ALL NOTES (1) (2) (3) (4) (5) (6) (7) (8) (9) (10) (11) (12) (13) (14) (15) (16) (17) (18) (19) (20) (21) (22) (23) (24) (25) (26) (27) (28) (29) (30) (31) (32) (33) (34) (35) (36) (37) (38) (39) (40) (41) (42) (43) (44) (45) (46) (47) (48) (49) (50) (51) (52) (53) (54) (55) (56) (57) (58) (59) (60) (61) (62) (63) (64) (65) (66) (67) (68) (69) (70) (71) (72) (73) (74) (75) (76) (77) (78) (79) (80) (81) (82) (83) (84) (85) (86) (87) (88) (89) (90) (91) (92) (93) (94) (95) (96) (97) (98) (99) (100)

54-CVN-174715-CN
DDRRCPCFB-35

FOR INFORMATION ONLY

TRANSVERSE TO TEST @ 620°

** COBALT COUT NOT LIMITED BY SPEC.

TEMPERATURE	60°-100°F	WELDINGHOUSE ELECTRIC
DATE	12/13/68	345-CVN-174715-CN
DRIVEN BY	JJK	CN-2600-1(1)
CLASS	ASME III CLASS 1	DATE
DATE	1940	NO. 7207

PDR RIDS

9603180100

