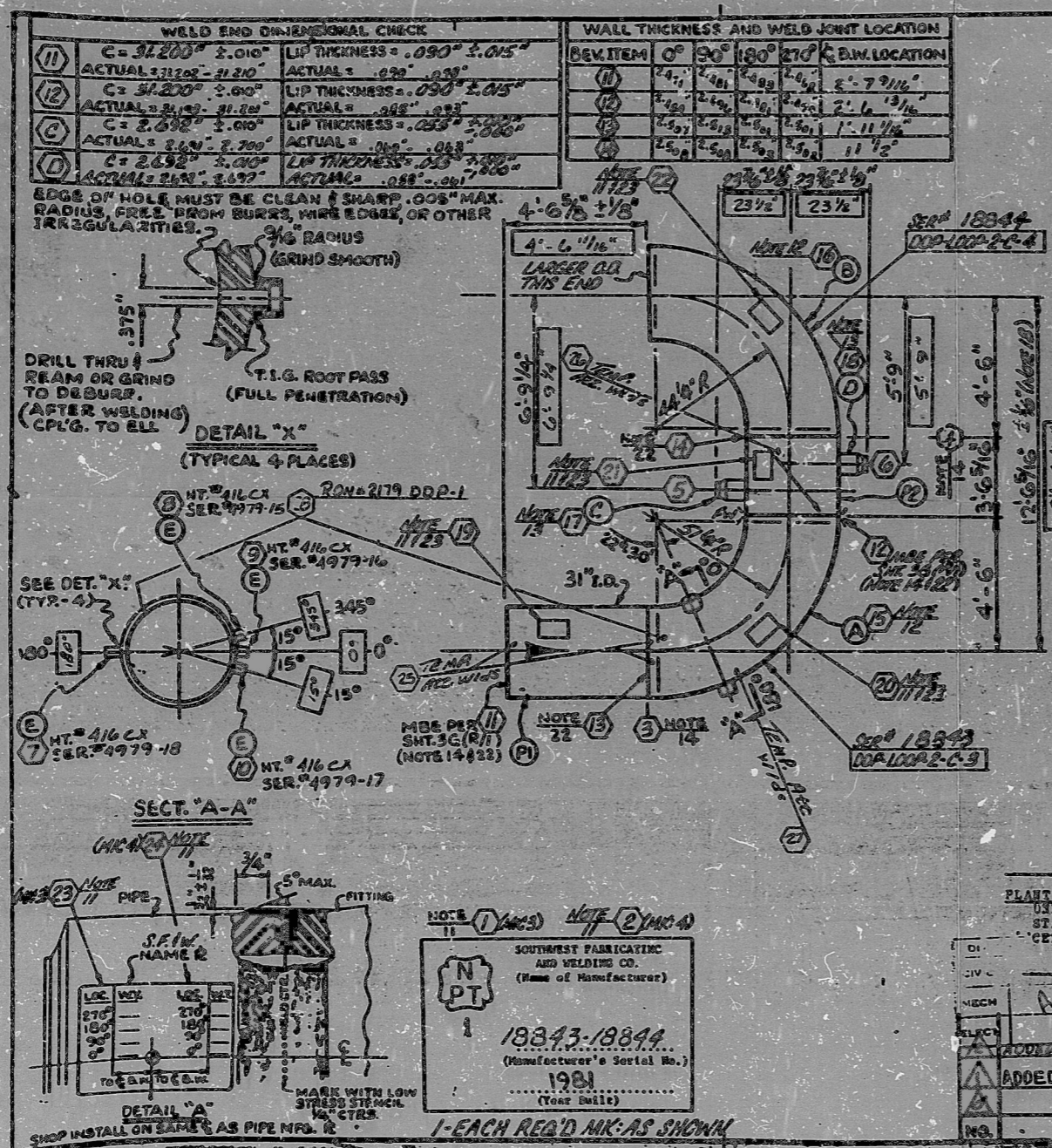


ANSTEC  
APERTURE  
CARD



- APR 11 1974 TIME ADDED 1/4  
# 0008 CASE 1423-2
1. MARK WITH LOW STRESS STEEL OR ENCL. MARK AND SERIAL NO. TO BE APPLIED TO EACH PART OF THE FABRICATED ASSEMBLY.
  2. SEE ATTACHED MANUFACTURING RECORD SHEET FOR DIMENSIONAL AND PROCEDURAL.
  3. INITIALS 3/4" TYP 2" HEIGHTS PER SHEET 30 (1/2)
  4. INITIALS 2" AND LARGER HEIGHTS PER SHEET 30 (1/2)
  5. T.S.G. ROOT PASS OF ALL WELDS.
  6. COVERED GRADE ALL WELDS - 250 GHS MAX. MAXIMUM REINFORCEMENT OF BUTT WELDS IS 1/16" FOR 3/4" DIA.
  7. ALL TIGHTENING SPECIFICATIONS SHALL BE OF A COMPATIBLE AND IDENTIFIED MATERIAL.
  8. ALL SURFACES FROM WHICH METAL HAS BEEN GRINDING BY THE SHOP, SHALL BE LIQUID PENETRANT INSPECTED PER PROCEDURE.
  9. LIQUID PENETRANT INSPECTED PER PROCEDURE THE BUTT JOINTS, AND ALL ACCESSIBLE SURFACES OF FUSED BUTT WELDS, WELDED WELDS, FILLER WELDS, AND THE HEAT AFFECTED ZONE OF THE BASE METAL.
  10. LIQUID PENETRANT INSPECTED PER PROCEDURE FOR WELDS 2" AND SMALLER, LIQUID PENETRANT INSPECTED PER 1/2" INCREASING OF WELD HEIGHTS.
  11. REMOVE WELD FROM SEE 1. T.S.G. CENTER SURFACES PER PROCEDURE.
  12. LIQUID PENETRANT INSPECTED PER PROCEDURE ACCESSIBLE FUSED WELDED WELDS JOINTS, BEVELS AND COVER SURFACES FOR THE REASON AS NOTED WELDS.
  13. LIQUID PENETRANT INSPECTED PER PROCEDURE ALL WELD BEVELS AND WELD JOINTS CUT TO CALL FOR T.S.G. WELDED WELDS.
  14. HARDENING 4" AND LARGER BUTT WELDS AND WELDED BEVELS PER PROCEDURE.
  15. ALL WELDS SHALL BE 1/2" MIN. THICKNESS.
  16. CLAD AND FUSION FOR SURFACES PER PROCEDURE WELD 1/2" WELD 1/2" WELD SURFACES. 1/2" PLATES.
  17. DIMENSIONAL INSPECTION FOR FIELD WELD SURFACES. 1/2" PLATES.
  18. DIMENSIONAL INSPECTION FOR FIELD WELD SURFACES. 1/2" PLATES.
  19. SHOP TO COMPLETE 1/2" DIA. OF PIPE WITH 1/2" WELD PLATE. (1/2" WELD PLATE)
  20. FIELD WELDS SHALL BE WELDED TO THE LOCATION OF BUTT WELD ON WELD PLATE AND YIELD PER DETAIL 2.
  21. 3/4" MIN. DESIGN THICKNESS 1/2" DIA.
  22. SHOP WELD CUSTOMER APPOINTED NAME 12 IN SPACE INDICATED

NO.	DESCRIPTION	DATE	BY	CHKD.
1	31.200 ± 0.010	3/18/74	JSW	
2	31.200 ± 0.010	3/18/74	JSW	
3	2.692 ± 0.010	3/18/74	JSW	
4	2.692 ± 0.010	3/18/74	JSW	
5	2.692 ± 0.010	3/18/74	JSW	
6	2.692 ± 0.010	3/18/74	JSW	
7	2.692 ± 0.010	3/18/74	JSW	
8	2.692 ± 0.010	3/18/74	JSW	
9	2.692 ± 0.010	3/18/74	JSW	
10	2.692 ± 0.010	3/18/74	JSW	
11	2.692 ± 0.010	3/18/74	JSW	
12	2.692 ± 0.010	3/18/74	JSW	
13	2.692 ± 0.010	3/18/74	JSW	
14	2.692 ± 0.010	3/18/74	JSW	
15	2.692 ± 0.010	3/18/74	JSW	
16	2.692 ± 0.010	3/18/74	JSW	
17	2.692 ± 0.010	3/18/74	JSW	
18	2.692 ± 0.010	3/18/74	JSW	
19	2.692 ± 0.010	3/18/74	JSW	
20	2.692 ± 0.010	3/18/74	JSW	
21	2.692 ± 0.010	3/18/74	JSW	
22	2.692 ± 0.010	3/18/74	JSW	
23	2.692 ± 0.010	3/18/74	JSW	

QA CONDITION: APPROVED

PLANT: CATARAUGUS NUCLEAR STATION  
STATUS: AS MANUFACTURED  
CERTIFICATION LTR. NO. CATAMBA-3306

DUKE POWER COMPANY  
AUTHORITY: F. J. TWOGGON  
ENGR. LTR. NO. EP/SA-4384

NOV 1 1983

FOR INFORMATION ONLY

546-CVH-1747B-6  
DDP-RREF-03



PDR RIDS

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