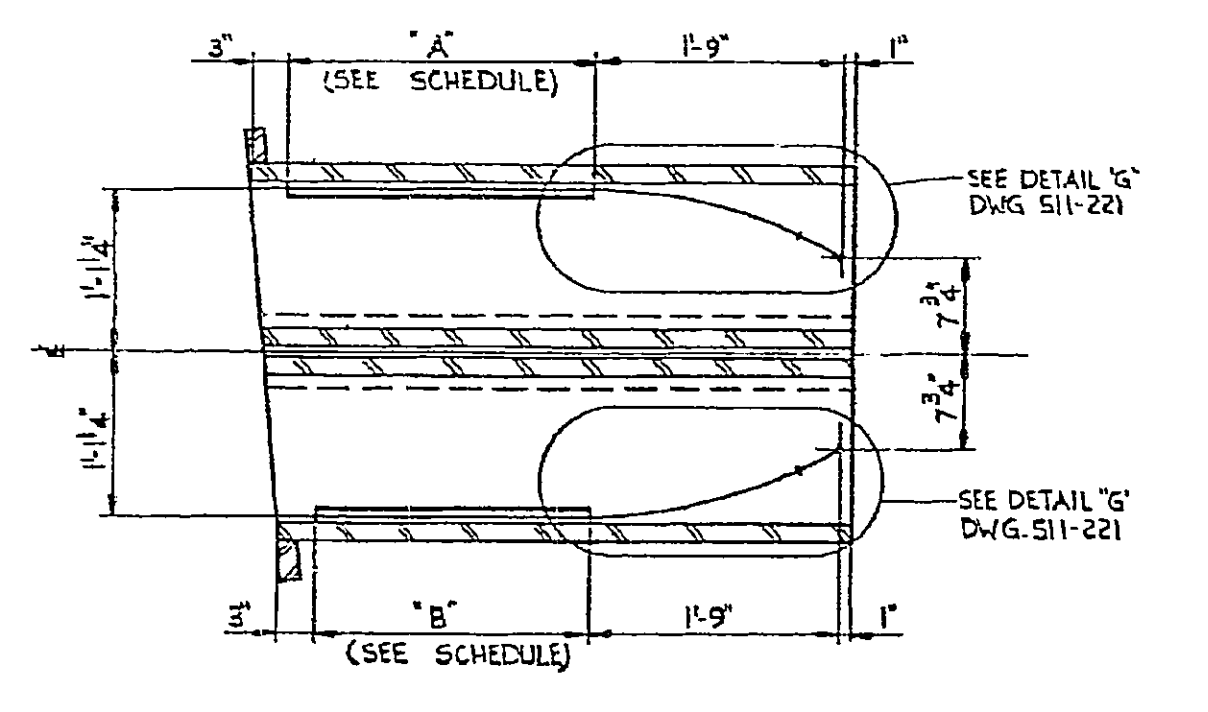
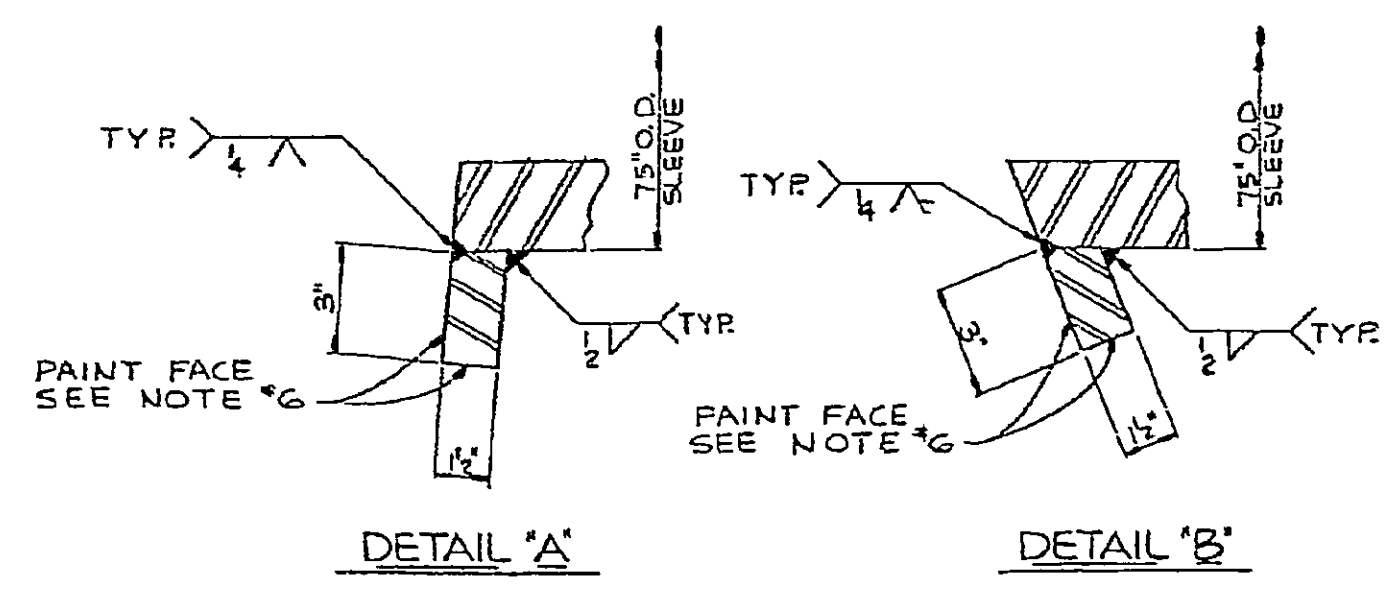
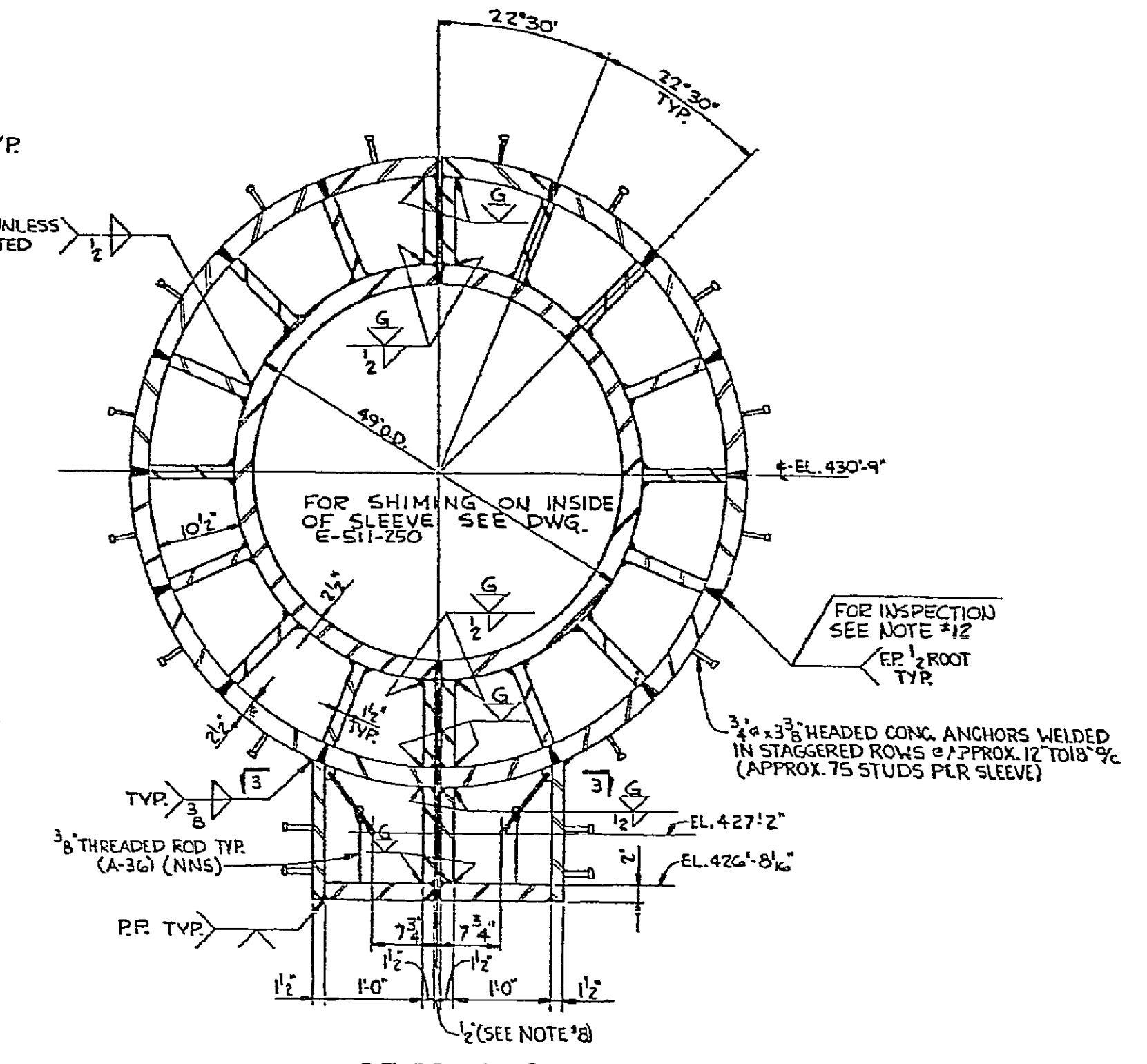
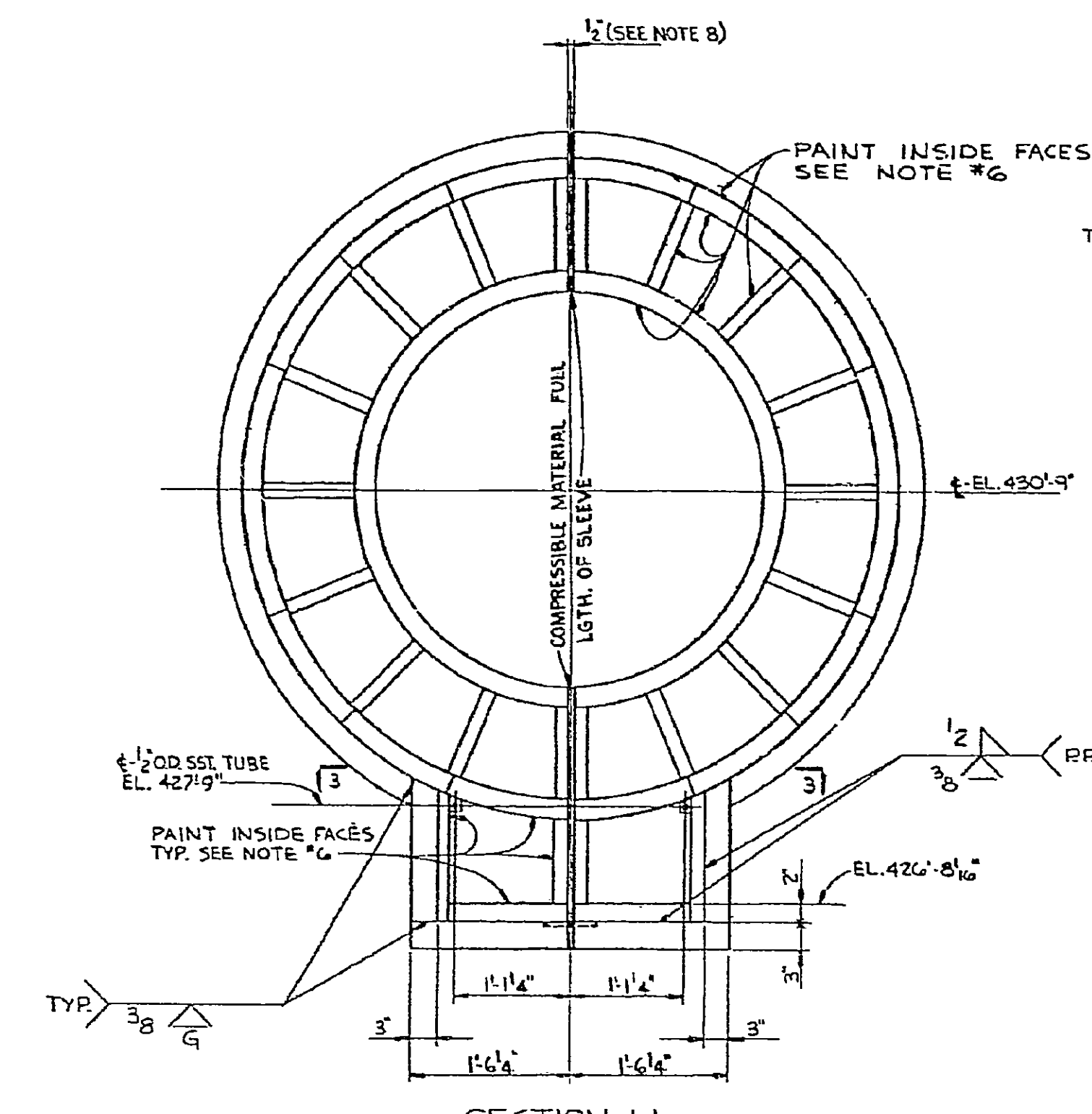
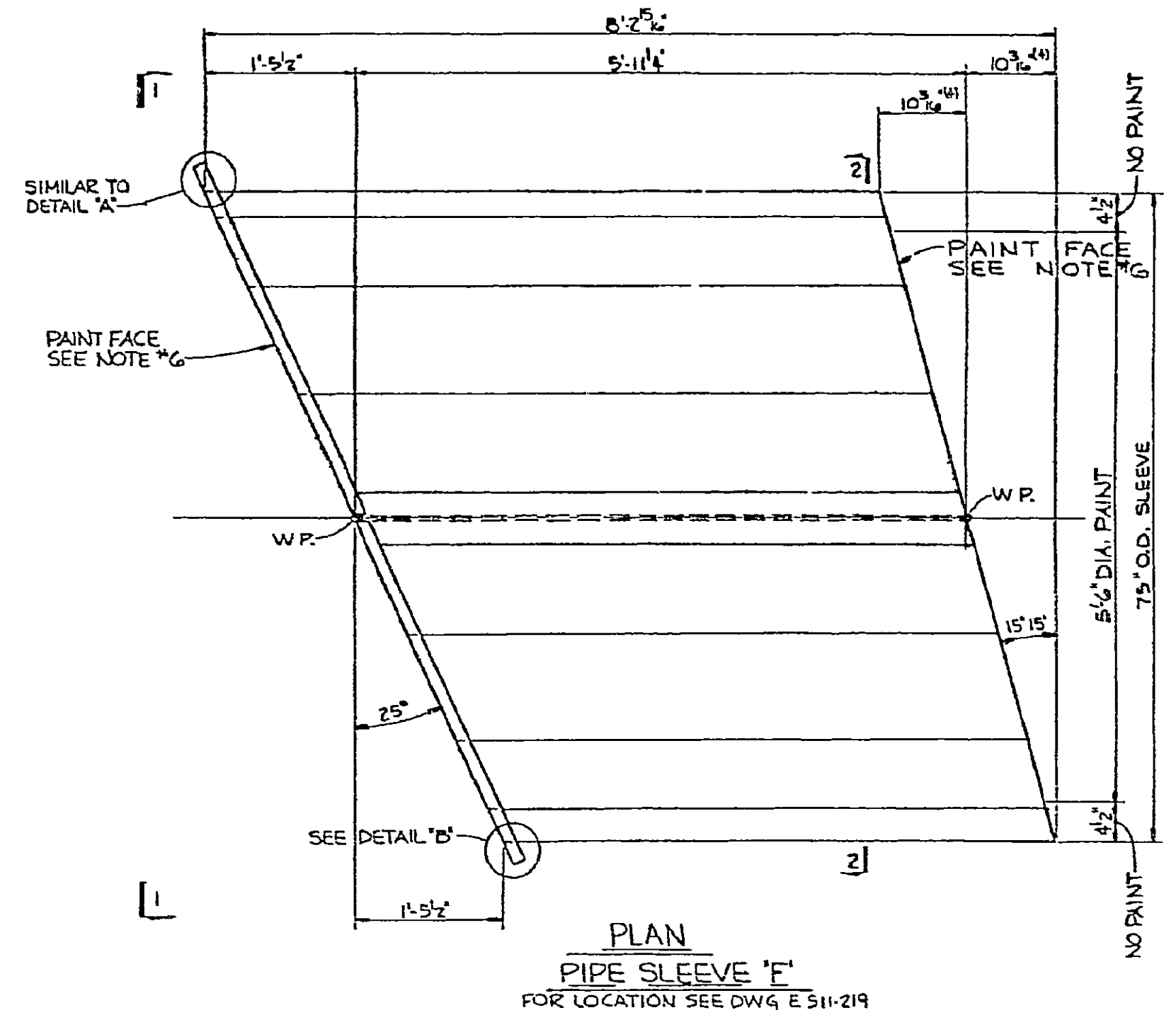


- NOTES:
1. NUCLEAR SAFETY CLASS (NSC) FOR ITEMS SPECIFICALLY MARKED NON-NUCLEAR SAFETY (NNS), SPECIFICATION SP-701-4461-00 IS NOT APPLICABLE.
 2. QUALITY ASSURANCE PROGRAM REQUIREMENTS QA-1 SEE GAI SPECIFICATION "QUALITY ASSURANCE PROGRAM REQUIREMENTS" SP-701-4461-00
 3. MATERIAL, WELDING, FABRICATION AND TOLERANCES OF SPECIAL STEEL FOR REACTOR BUILDING, TO BE IN ACCORDANCE WITH GAI SPECIFICATION SPECIAL STEEL FOR REACTOR BUILDING SPECIFICATION SP-823-84461-000
 4. ALL STRUCTURAL STEEL IS SHOWN ON THIS DRAWING SHALL BE MADE OF ASTM A302 GRADE B MATERIAL, WITH SUPPLEMENTAL REQUIREMENT TO ASTM A302, 31, 33, AND 34, UNLESS NOTED OTHERWISE.
 5. 20% MAGNETIC PARTICLE TESTING OF WELDS ON RANDOM SELECTED BASIS WILL BE REQUIRED AS ADVISED BY THE ENGINEER.
 6. ALL EXPOSED CARBON STEEL SURFACES TO BE PAINTED IN ACCORDANCE WITH GAI SPECIFICATION, "PAINTING STEEL-INSIDE REACTOR BUILDING" SP-713-4461-00.
 7. TOLERANCES ON THE PIPE SLEEVES AS A COMPLETED ASSEMBLY WILL BE AS FOLLOWS:
 A. INNER RADIUS $\pm 1/16$ TO $1/8$
 B. OUTER RADIUS $\pm 1/4$
 C. RAMPING $\pm 1/8$
 D. CENTER LINE STRAIGHTNESS $\pm 1/8$
 E. THE 1/2" INCH CLEARANCE IS NOTED ON SECTION 3-2 IS A REQUIRED FIELD GAP. A 1/8" (MIN) MAXIMUM GAP IS ALLOWED DURING SHOP ASSEMBLY AND TOLERANCE VERIFICATION.
 8. UNLESS INDICATED OTHERWISE ON THE DRAWING, ALL FULL PENETRATION GROOVE WELDS SHALL BE 100% ULTRASONICALLY INSPECTED IN ACCORDANCE WITH ASTM E164-74 "ULTRASONIC CONTACT EXAMINATION OF WELDMENTS, RECOMMENDED PRACTICE FOR".
 9. THE ANGLE OF THE PREPARATION GROOVE SHALL BE IN ACCORDANCE WITH THE WELDING PROCESSES USED AND SHALL BE SUBMITTED TO THE ENGINEER FOR APPROVAL.
 10. ALL WELDS INDICATED T.P. SHALL BE FULL PENETRATION AND WELDS INDICATED P.P. SHALL BE PARTIAL PENETRATION.
 11. VOLUMETRIC MAGNETIC PARTICLE INSPECTION OF FIRST TWO ROOT WELD PASSES, WITH ULTRASONIC INSPECTION OF REMAINING PASSES.



| SCHEDULE FOR 1 1/2" x 1 1/4" x 1/8" (A-36) (NNS) | | |
|--|------------|-----------|
| | "A" | "B" |
| PIPE SLEEVE "A" | 3'-7 3/4" | 3'-3 3/4" |
| PIPE SLEEVE "C" | 1'-7 7/8" | 0'-9 1/8" |
| PIPE SLEEVE "D" | 3'-0 1/2" | 3'-2 1/2" |
| PIPE SLEEVE "E" | 1'-10 3/8" | 1'-7 5/8" |
| PIPE SLEEVE "F" | 4'-2 3/8" | 3'-1 3/4" |

RELEASED FOR DETAILING & FABRICATION 7/3/75

THIS IS A NUCLEAR SAFETY RELATED DOCUMENT. NO DEVIATION SHALL BE INITIATED OR PERFORMED WITHOUT PRIOR DOCUMENTATION AND WRITTEN APPROVAL.

FSAR Figure 6.2-66

SOUTH CAROLINA ELECTRIC & GAS COMPANY
 VIRGIL C. SUMNER NUCLEAR STATION
 REACTOR BUILDING
 PIPE SLEEVES

SECTIONS AND DETAILS
 DESIGN ENGINEERING

| | | | |
|-------------|-----|------------|--------|
| DESIGNED BY | DDJ | CHECKED BY | DDJ |
| APPROVED BY | MGR | DATE | 7/3/75 |
| REVISION | | DATE | |

E-511-220