

POOR ORIGINAL

WELDING REQUIREMENTS

Rev.	Init.	Desc.
15	20c	Pre-Heat 60 F
16	20c	Pre-Heat 200 F
17	20c	Pre-Heat 250 F
18	20c	Pre-Heat 375 F
19	20c	Pre-Heat 450 F
20	20c	Pre-Heat 500 F
21	20c	Inter Pass 350 F
22	20c	Backing Ring Req'd
23	20c	Argon Purge Req'd
24	20c	Preheat Insp. Req'd
25	20c	PT-5812 9c

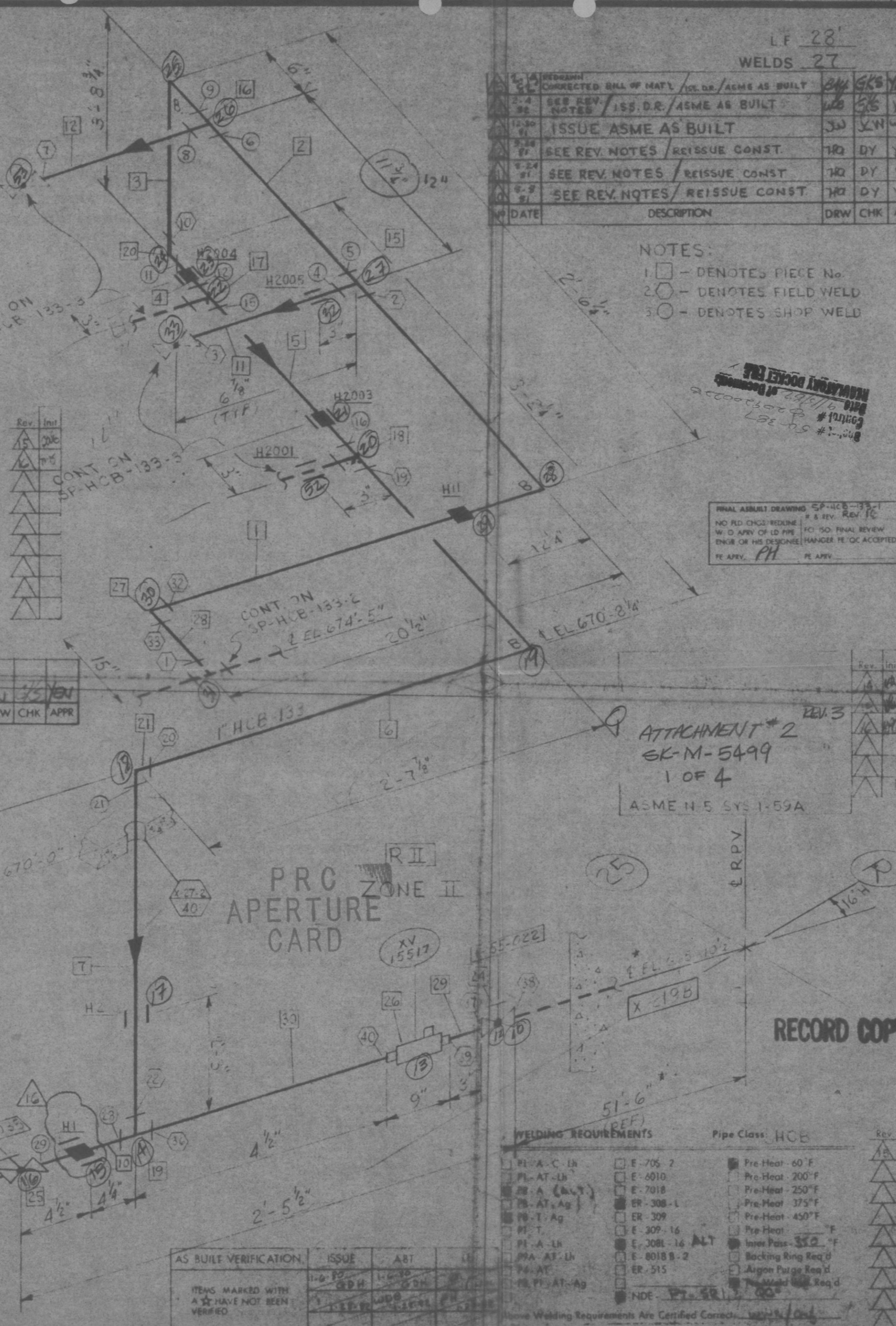
No	Date	Description	DRW	CHK	APPR
1		ADD RIG GUIDE / REISSUE DR ASME			
2		DELETED RIG / AS-BUILT			

REV. 14 NOTES:
CHANGED HANGER SYMBOL FOR HI.

REV. 15 NOTES:
REINSTATED AS BUILT CONDITION VOICING REV 11 NOTES
REINSTATED WELDS 22, 32, 33
DELETED: PW 31, 32 WELD AT THRU 45
NOTE 4 REVISED FROM LF 1 SW TO COMPLY WITH EXISTING CONDITION. SWR 2437 HAS BEEN DELETED AND SWR 2399, 15 SUPERCEDED BY SWR 2369

REV. 16 NOTES:
DELETED: WELDS 22, 32, 33
ADDED: PW 31, 32
WELDS AT THRU 45
NOTE 4
REVISED BOM L.F. 304-5 SW
REVISED TAG PER SKR 23 1 Y
SWR 2457

REV. 17 NOTES:
DELETED HGRS H3 H5 H7 H9
ADDED HGRS H2001 H2003 H2004 H2005, CH 1 SYM FOR HI PER ENGR REV 9E1
DELETED: PW 13, 14
WELDS 13, 14, 17, 18
REVISED FOOTAGE NO OF WELDS 7
BOM CHG'D PER SWR 2324



LF 28'
WELDS 27

DATE	DESCRIPTION	DRW	CHK	APPR
1-14-81	ISSUE ASME AS BUILT	SK	SKS	YEN
2-4-81	SEE REV. NOTES / REISSUE CONST.	WB	SKS	YEN
12-30-81	ISSUE ASME AS BUILT	JD	LN	WDC
1-18-82	SEE REV. NOTES / REISSUE CONST.	TR	DY	YEN
2-24-82	SEE REV. NOTES / REISSUE CONST.	TR	DY	YEN
6-9-82	SEE REV. NOTES / REISSUE CONST.	TR	DY	YEN

NOTES:
1. □ - DENOTES PIECE No.
2. ○ - DENOTES FIELD WELD
3. ● - DENOTES SHOP WELD

REVISIONS
ACCEPTED BY
DATE

FINAL AS-BUILT DRAWING SP-HCB-133-1
NO RD CHG'D REDLINE
W/O APVY OF LD PIPE
ENGR OR HIS DESIGNER
HANGER RE QC ACCEPTED
RE APVY, PH RE APVY

BILL OF MATERIAL

QTY	SIZE AND DESCRIPTION	ASME	GR	PC NO	HEAT NO
3	1" PIPE SCH 40 SS SMLS.	SA 376	TP 304		
1	1" TEE 3000"	SW	SA 182	304	
1	1" 90° ELL				
1	1" 90°				
1	1" CCA GB			24	11828
1	1" CCA GB			25	11830
1	XV 15517			26	353
1	1" 90° ELL 3000"	SW	SA 182	304	27
2	1" PIPE SCH 40 SS SMLS	SA 376	TP 304		28
1					29
1					30

NUCLEAR CL 2
SEISMIC CL I
HGR CRITICAL
KAPLOACTIVE

QUALITY CONTROL DATA

Q-DOCUMENTATION	SEISMIC ANALYSIS
REQ'D X	NOT REQ'D
SHOP FAB X	FIELD FAB
START UP NO	COST CODE
M-59A	55.34
PAID	PLANT DESIGN DWG
M-155	(B-5) SP-27-1 / SP-27-2
UNIT	AREA
1	670'-0"
	27

No	Date	Description	DRWN	CHK'D	APPR
1	1-17-81	REV'D DIMS / REISSUE DR AS BUILT	SK	SKS	YEN
2	2-11-81	CHG'D DIMS / ISSUE DR AS BUILT	SK	SKS	YEN
3	2-19-81	DELETE SW 26 / 27 / 28 / 29 / 30 / REISS CONST	SK	DH	YEN
4	2-23-81	DELETE PW 31 32 33 / REISS CONST	SK	SKS	YEN
5	2-24-81	DELETE WELD AT THRU 45 / REISS CONST	SK	SKS	YEN
6	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
7	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
8	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
9	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
10	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
11	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
12	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
13	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
14	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
15	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
16	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
17	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
18	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
19	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
20	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
21	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
22	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
23	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
24	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
25	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
26	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
27	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
28	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
29	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN
30	2-24-81	DELETE SW 14 PW 27 AT 87 / REISS CONST	SK	SKS	YEN

BECHTEL POWER CORPORATION
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SUBQUEHANNA STEAM ELECTRIC STATION - UNIT 1 UNIT 2

TITLE
FOR SUPPRESSION POOL WATER LEVEL INSTRUMENTATION
JOB NO 8856
DRAWING NO SP-HCB-133-1
REV 16

LOW 1/16" ROOT GAP ON ALL SOCKET WELDS
*VENDOR SUPPLIED
H = HORIZONTAL V = VERTICAL
B = BEND
F.T.F. = FIELD TO FIT
SFHO-SK-M-5499