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AS BUILT VERIFICATION	ISSUE	REV

**REV 6 NOTES:**  
 DELETE PC 1, 2, 3, 6 & 9  
 WELD 1, 2, 3, 4, 5, 6, 8, 10 & 11  
 ADDED PC 12 THRU 20  
 WELD 12 THRU 24  
 REROUTED & REDRAWN

**NOTES:**  
 1. ○ DENOTES SHOP WELD  
 2. ○ DENOTES FIELD WELD  
 3. □ DENOTES PIECE NO.  
 4. LAST PC. NO. USED IS 28.  
 LAST WELD NO. USED IS 33.  
 5. SV-15738 IS TO BE INSTALLED IN THE NORMAL DIRECTION OF FLOW.  
 6. SV-15734B, SV-15736B & SV-15737 ARE TO BE INSTALLED OPPOSITE THE NORMAL DIRECTION OF FLOW PER EMC-5465.

**REV 7 NOTES**  
 INC. REDLINE  
 DELETE WELD 22 (PC 15)  
 ADD WELD 25 (PC 21)  
 ALSO DELETE WELD 12 (PC 13, PC 19)  
 ADD WELD 26 THRU 33  
 ADD PC 22 THRU 28  
 ADD NON-Q MAT'L.

ASME AS BUILT  
 N-5 PACKAGE PREPARED  
 ALL CHANGES AFTER REV. 10  
 THIS DRAWING MUST BE APPROVED BY  
 CODE DATA ENGINEER.  
 KANE N-5 SYSTEM-1-13A

**POOR ORIGINAL**

NO.	DATE	DESCRIPTION	BY	CHKD.

**HANGER LEGEND**

○	SPRING HANGER
■	RIGID HANGER
▲	ANCHOR
□	GUIDE

ALLOW 1/8" ROOT GAP ON ALL SOCKET WELDS

VENDOR SUPPLIED

H - HORIZONTAL V - VERTICAL

S - S.W. F - F.W.

W - WELD

L.F. 14  
 WELDS 22

REV 127000 ANNOTATION SHEET  
 Date: 9/18/82  
 Project: 8209200228  
 50-387

DO NOT REMOVE THIS LABEL FROM THE DRAWING  
 THIS LABEL IS TO BE USED TO IDENTIFY THE DRAWING IN THE EVENT OF A FIRE  
 DATE OF THIS LABEL: 10/1/82  
 BY: [Signature]

**REV 8 NOTES:**  
 ADDED HBR'S H2022 THRU H2025  
 REVISED PER ENGR REV 8E1  
 CHG'D SV-15734A & SV-15736A TO  
 SV-15734B & SV-15736B PER  
 EMC 47130  
 CHG'D FOOTING TO COMPLY WITH DWG.

**WELDING REQUIREMENTS** CW-25 Pipe Class: SS-C.S

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

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

QTY	SIZE AND DESCRIPTION	ASME OR	PC NO.	HEAT NO.
2	1" PIPE SCH 40S SS SMLS SA316		4	
1	1" TEE 3000" SS S.W. SA316		5	
1	1" PIPE SCH 40S SS SMLS SA316		7	
1	1" PIPE SCH 40S SS SMLS SA316		28	
1	1" PIPE SCH 40S SS SMLS SA316		28	
1	1" PIPE SCH 40S SS SMLS SA316		28	
1	1" SV-15734B		8	
1	1" SV-15737		10	
1	1" SV-15736B		11	
1	1" SV-15738		20	
1	1" PIPE SCH 40S SS SMLS SA316		12	
2	1" PIPE SCH 40S SS SMLS SA316		13	
1	1" PIPE SCH 40S SS SMLS SA316		14	
3	1" PIPE SCH 40S SS SMLS SA316		21	
1	1" PIPE SCH 40S SS SMLS SA316		16	
1	1" 90° ELL 3000" SS SW SA316		17	
1	1" 45° ELL		18	
1	1" TEE		24	
1	1" CCA-GB		25	16012
1	1" CCA-GB		26	16010
1	1" CCA-GB		27	16019

NON-Q HCB MAT'L  
 1" PIPE SCH 40S SS SMLS SA316  
 1" CAP 3000" SS THR'D SA316

NUCLEAR CL 2  
 SEISMIC CL I  
 HANGER CRITICAL  
 RADIOACTIVE

WELD DOCUMENTATION REQUIRED  
 MATERIAL TRACEABILITY REQUIRED

**QUALITY CONTROL DATA**

Q-DOCUMENTATION	SEISMIC ANALYSIS
REQ'D <input checked="" type="checkbox"/>	REQ'D <input checked="" type="checkbox"/>
NOT REQ'D <input type="checkbox"/>	NOT REQ'D <input type="checkbox"/>

SHOP FAB.  FIELD FAB.

START UP NO. 1-73A  
 COST CODE 5534  
 INSUL. CL. THICK. 10F3

PAID M-157 SH1 (84)  
 PLANT DESIGN DWG. SP-25-2

UNIT	ELEV.	AREA	DATE	DESCRIPTION	DRW. NO.	APPV.
1	670'-0"	25		SEE REV NOTES / REISS CONST	10	DY/VE
2				REV DIM / ADD HANGERS / REISS CONST	10	DY/VE
3				SEE REV 4 NOTE / REISS CONST	10	DY/VE
4				SEE REV 4 NOTE / REISS CONST	10	DY/VE
5				ADDED CONTINUOUS / REISS CONST	10	DY/VE
6				ADDED NOTE / REISS CONST	10	DY/VE
7				REVISED WELDING REQUIREMENTS	10	DY/VE
8				REVISED WELDING REQUIREMENTS	10	DY/VE
9				REVISED WELDING REQUIREMENTS	10	DY/VE
10				ISSUED FOR CONST	10	DY/VE

**BECHTEL POWER CORPORATION**  
 BERWICK, PENNSYLVANIA - SAN FRANCISCO, CALIFORNIA

**PENNSYLVANIA POWER & LIGHT COMPANY**  
 ALLENTOWN, PENNSYLVANIA  
 SUSQUEHANNA STEAM ELECTRIC STATION - UNIT 1 - UNIT 2

HYDROGEN OXYGEN ANALYSER SYS  
 226B RETURN LINE TO SUPPRESSION  
 CHAMBER

JOB NO. 8856 SP-HCB-126-1  
 DRAWING NO. 10

8809200248