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AS BUILT VERIFICATION	ISSUE	ABT	LE
ITEMS MARKED WITH A "V" HAVE NOT BEEN VERIFIED	1-11-82	11-13-82	PH 1-10-82
	2-1-82	2-3-82	PH 3-1-82

NOTES

DELETED WELD 1
ADDED WELDS 11-THRU-15
ADDED PC 10-THRU-13

REV. NOTE:

INCORP REDLINE
DELETE: FW#8
ADD: FW#20

REV. NOTE:

DELETE WELD 2, 3, 9, 16, 18, PC 4, 10, 14.
ADD WELD 21 THRU 28.
ADD PC 16 THRU 20.
DELETE HSB MAT'L.
ADD NON Q MAT'L.

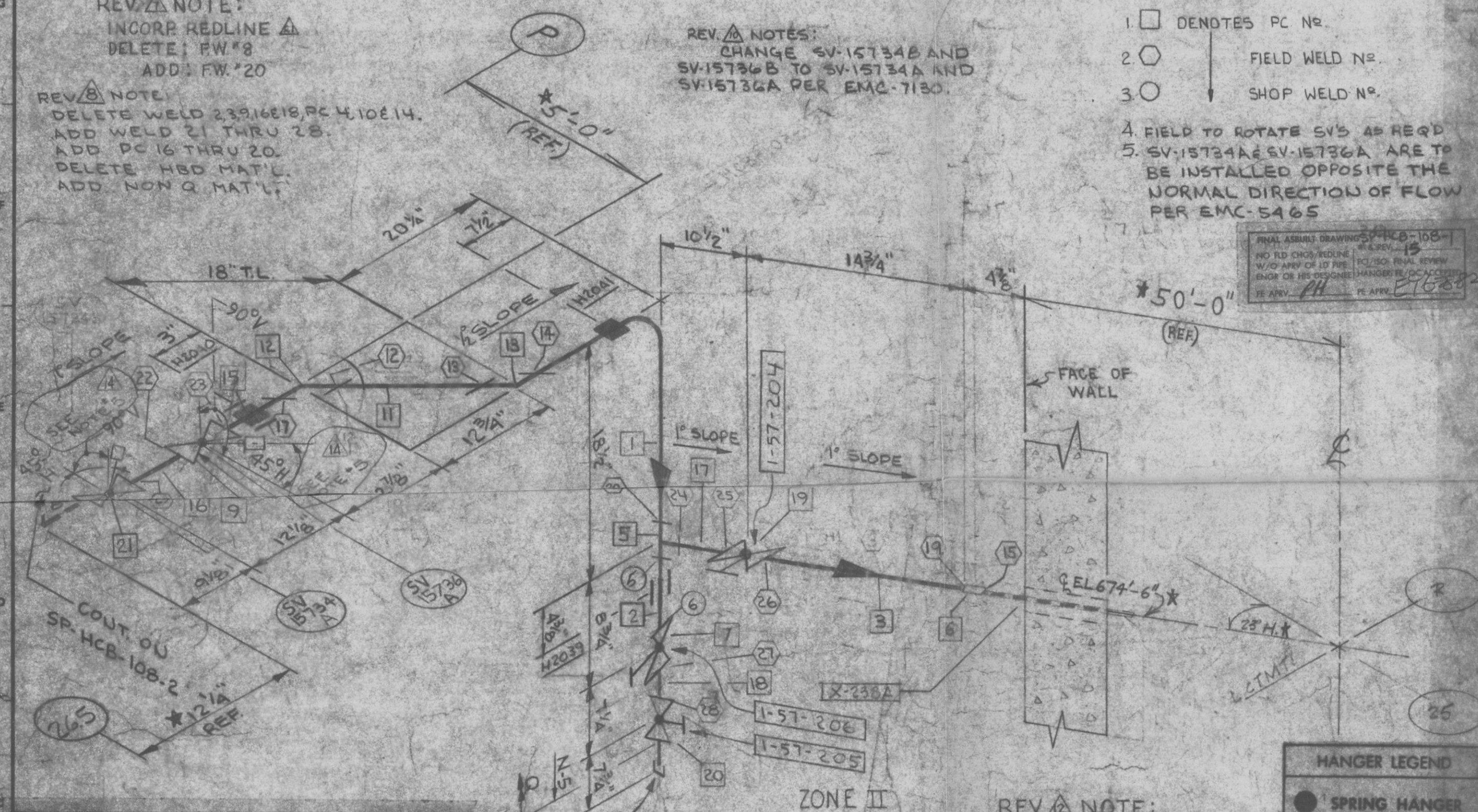
REV. NOTES:

CHANGE SV-15734B AND SV-15736B TO SV-15734A AND SV-15736A PER EMC-7130.

NOTES:

- DENOTES PC NO.
- FIELD WELD NO.
- SHOP WELD NO.
- FIELD TO ROTATE SV'S AS REQ'D
- SV-15734A & SV-15736A ARE TO BE INSTALLED OPPOSITE THE NORMAL DIRECTION OF FLOW PER EMC-5465

FINAL AS-BUILT DRAWING SV-HCB-108-1
NO RED CHG. REDLINE
W/O ANY OF 10 PIPE
ENGR OR HIS DESIGNEE
FE APRV. *PH* FE APRV. *E76882*



1	10-10	REV. SERIAL NO.	REISS. ASME AS-BUILT	GFB	VN	YEN
2	10-10	CORRECTED NOTE NO. FOR SV'S.	REISS. ASME AS-BUILT	MNS	DN	YEN
3	10-10	HSUE/ASME AS-BUILT		GFB	DN	YEN
4	10-10	SEE REV. NOTES	REISS. DR AS-BUILT	KNA	GS	YEN
5	10-10	CHG DIM.	REISS. DR AS-BUILT	ES	GS	YEN
6	10-10	SEE REV. NOTES	REISS. CONST.	SD	DY	YEN

REV. NOTE:
INCORP REDLINE
DELETE: PC#8 & FW#21
ADD: PC#21 & FW#29
PER SWA 11615 & SWR 4506
REV ORIENTATION OF VALVES

HANGER LEGEND	
●	SPRING HANGER
■	RIGID HANGER
▲	ANCHOR
■	GUIDE

WELDING REQUIREMENTS		Pipe Class: HCB
PI-A C-1H	E-705-2	Pre-Heat 60°F
PI-AT-LH	E-6010	Pre-Heat 200°F
PB-A (A-L)	E-7018	Pre-Heat 250°F
PB-AT-Ag	ER-308-L	Pre-Heat 375°F
PB-T-Ag	ER-309	Pre-Heat 450°F
PI-T	E-309-16	Pre-Heat 375°F
PI-A-LH	E-308-L (ALT)	Inter Pass 330°F
P9A-AT-LH	E-8018-B-2	Backing Ring Req'd
P4-AT	ER-515	Argon Purge Req'd
PB-PI-AT-Ag	NDE	Insp. Req'd

WELDING REQUIREMENTS		Pipe Class: SS/CS
PI-A C-1H	E-705-2	Pre-Heat 60°F
PI-AT-LH	E-6010	Pre-Heat 200°F
PB-A	E-7018	Pre-Heat 250°F
PB-AT-Ag	ER-308-L	Pre-Heat 375°F
PB-T-Ag	ER-309	Pre-Heat 450°F
PI-T	E-309-16	Pre-Heat 375°F
PI-A-LH	E-308-L-16	Inter Pass 330°F
P9A-AT-LH	E-8018-B-2	Backing Ring Req'd
P4-AT	ER-515	Argon Purge Req'd
PB-PI-AT-Ag	NDE	Insp. Req'd

BILL OF MATERIAL					
QTY	SIZE AND DESCRIPTION	ASTM	GR	PC NO	HEAT NO
4'	1" PIPE SCH. 40S S.S. 5MLS	SA-376	TP 304	1	
1'	1" "			2	
2'	1" "			3	
1	1" TEE 3000# S.W.	SA-182	5A	5	
1	1" COUPLING			6	
1	1" CCA-CB			7	11823
1	1" SV-15734A			21	75KK-201-51
1	1" SV-15736A			9	75KK-201-7
2'	1" PIPE SCH. 40S SS 5MLS	SA-376	TP 304	11	
1	1" 4" ELL 3000# S.W.	SA-182	5A	12	
1	1" "			13	
1	1" PIPE SCH. 40S SS 5MLS	SA-376	TP 304	15	
1	1" "			16	
1	1" "			17	
1	1" "			18	
1	1" CCA-CB			19	12216
1	1" CCA-CB			20	11814
(NON-Q - HCB MATERIAL)					
1	1" PIPE SCH. 40S SS 5MLS	SA-376	TP 304		
1	1" CAP 3000# SS THRD.	SA-182	304		
RADIOACTIVE NUCLEAR CLASS II SEISMIC CL. I HANGER CRITICAL					
WELD DOCUMENTATION REQUIRED MATERIAL TRACEABILITY REQUIRED					

QUALITY CONTROL DATA			
Q-DOCUMENTATION		SEISMIC ANALYSIS	
REQ'D X	NOT REQ'D	REQ'D X	NOT REQ'D
SHOP FAB X		FIELD FAB	
START UP NO	COST CODE	INSUL CL	THICK
1-73A	55-34	F	1"
P&ID	PLANT DESIGN DWG		
M-157 SHT.1 (EG)	SP-27-2		
UNIT	ELEV	AREA	
1	670'-0"	27	
REVISED DIMENSIONS / ISSUE DR AS-BUILT			
1-10	SEE REV. NOTES / REISS. FOR CONST.	WPC	DY YEN
1-14	SEE REV. NOTES / REISS. FOR CONST.	WPC	DY YEN
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1-99	SEE REV. NOTES / REISS. FOR CONST.	WPC	DY YEN
1-100	SEE REV. NOTES / REISS. FOR CONST.	WPC	DY YEN

BECHTEL POWER CORPORATION
BERWICK, PENNSYLVANIA - SAN FRANCISCO, CALIFORNIA

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

TITLE
1" HCB-108 WETWELL ATMOSPHERE
SAMPLE RETURN FROM ANALYZER

JOB NO 8856 DRAWING NO SP-HCB-108-1 REV 15

8209200234

ISO FORM 100 Rev 1

POOR ORIGINAL

ALLOW 1/16" ROOT GAP ON ALL SOCKET WELDS

*VENDOR SUPPLIED Y. H = HORIZONTAL V = VERTICAL

B = BEND T = FIELD TYPED