BURNS AND ROE, INC.
WPPSS
NUCLEAR PROJECT
NO. 2

PROJECT
ENGINEERING
DIRECTIVE

CODE: PROJECT ENGINEERING DIRECTIVE

2	1		2	1	5		-		W	-	2	7	4	2
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15

DATE 03/14/80 PRIORITY I

INFORMATION COPIES

SHEET 1 OF 6

REASON FOR P. E. D.:

This PED is for the preparation of the partial penetration weld joint to be used on the sac. wall at 541'-5" el..

REFERENCES	
SUBJECT	Sac. Shield Wall Welds
LOCATION	541'-5" All A
ENG. SYSTEM	N/A
S/U SYSTEM	N/A
QUALITY CLASS	I

ORIGINATING DOCUMENTS NCR-215-5688

DESCRIPTION OF WORK:

Refer to pages 2 through 6 of this PED for direction of weld joint preparation as shown on attached details.

NOTES

1. THIS PED REVISES DIRECTION PREVIOUSLY PROVIDED BY THE FOLLOWING PED(s): N/A
2. THIS PED VOIDS DIRECTION PREVIOUSLY PROVIDED BY THE FOLLOWING PED(s): N/A
3. THIS PED WORK SHOULD BE COORDINATED WITH KNOWN OTHER WORK UNDER THE FOLLOWING PED'S: 215-W-2749, 215-CS-2741, 215-W-1604
4. THIS PED DEPENDS ON THE PRIOR INSTALLATION OF THE FOLLOWING PED'S: N/A

REVISE:

NONE
DRAWINGS N/A
SPECIFICATION

APPROVALS:

M Gottard 5-14-80
DISCIPLINE ENGINEER DATE

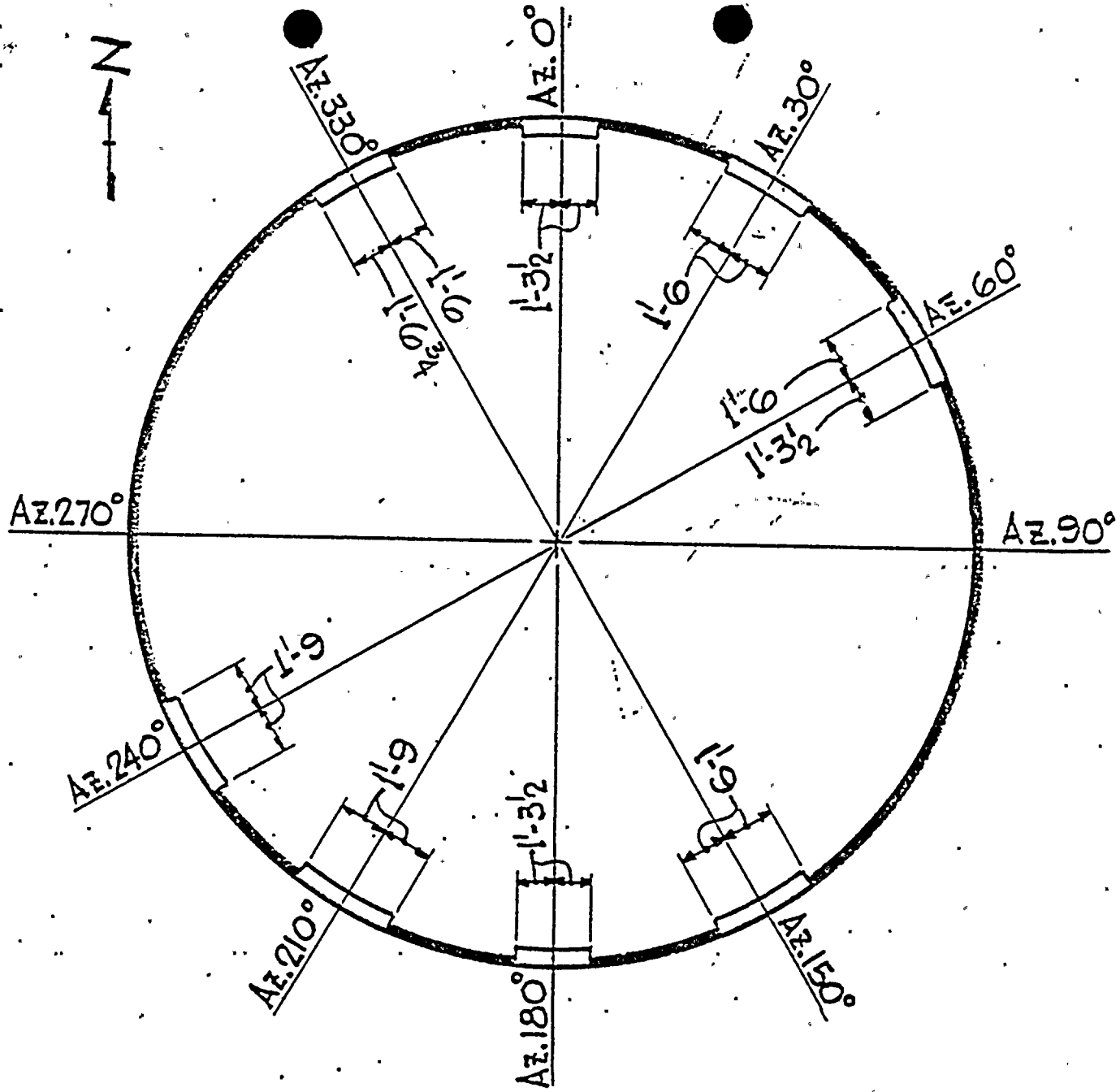
L.F Allers 3/25/80
LEAD DISCIPLINE ENGINEER DATE

S/U LIAISON ENGINEER DATE

RESIDENT PROJECT ENGINEER DATE

REV 1 BR 803-2

8004070 372

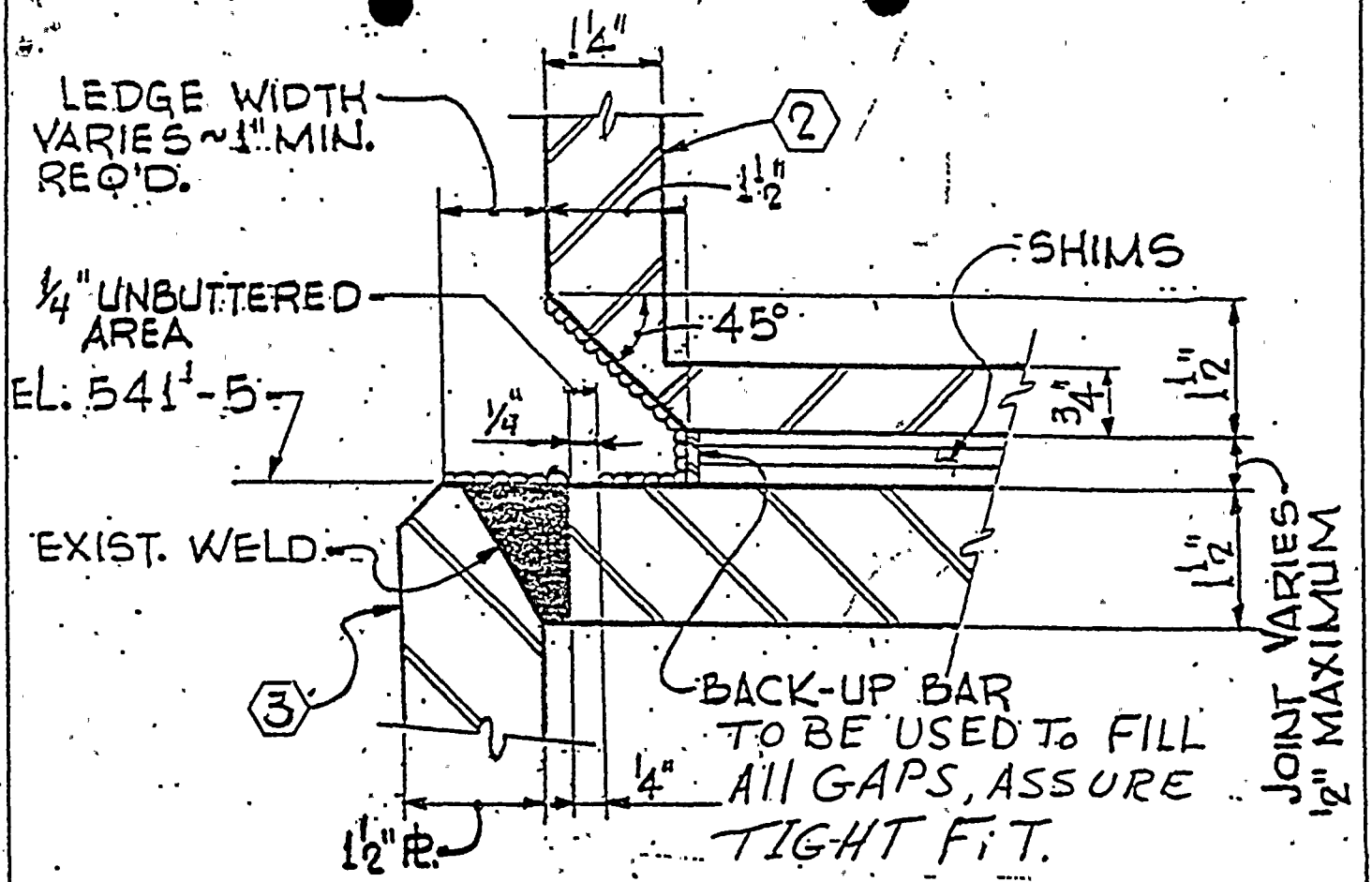


PLAN (T.O.S. EL. 541'-5)

SHADED AREAS INDICATE 1½" THK. SIDE PL. ON BUILT-UP MEMBER (3)

UNSHADED AREAS INDICATE 3" THK. SIDE PL. ON BUILT-UP MEMBER (3)

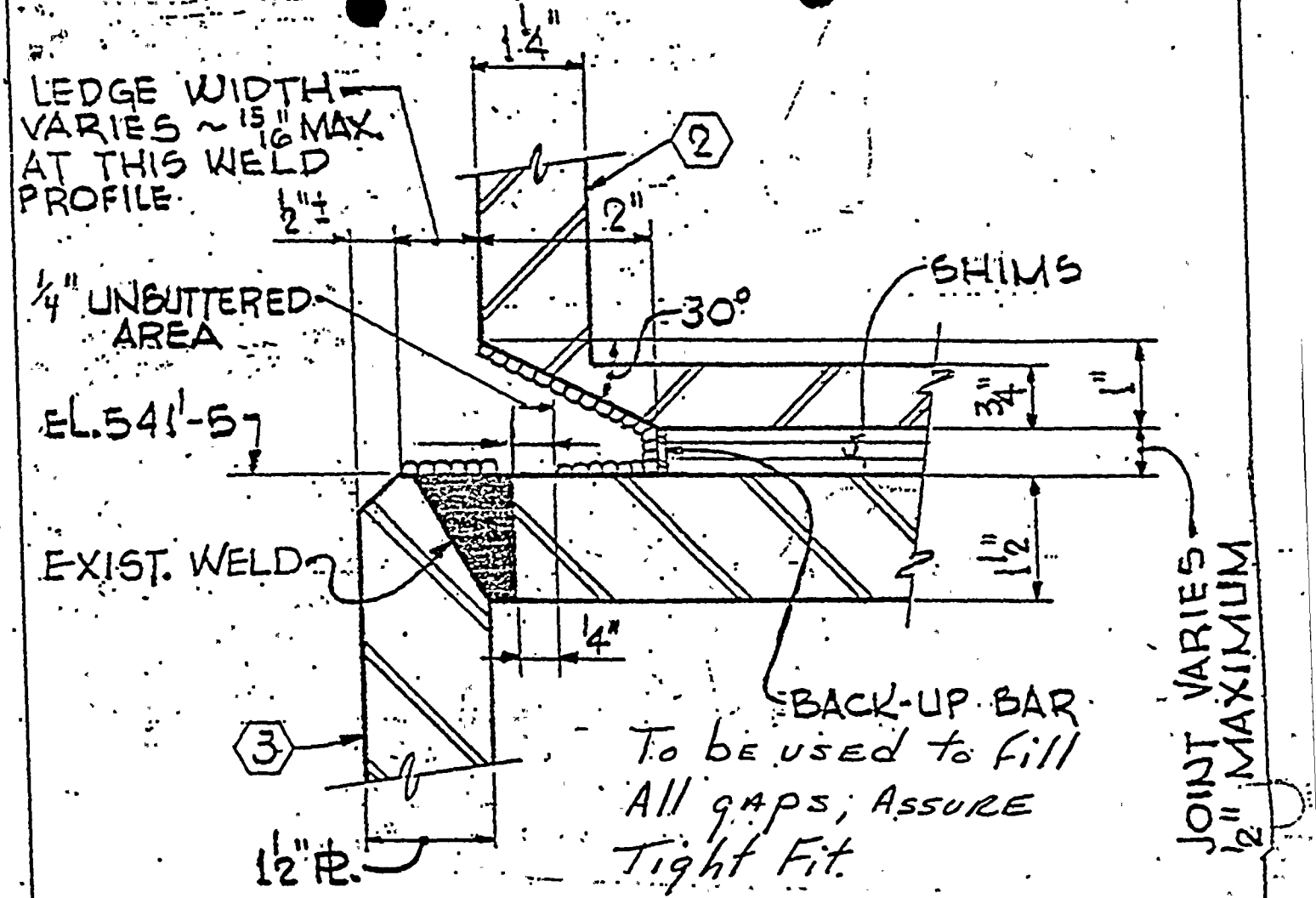
REF. DOC.: PCN — RF NCR 215-5688		WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: — PAGE: — PARA: —		BURNS AND ROE, INC.
REF. DWG.: —	DWG. ZONE: —	PED 215-W-2742 SHT 2 OF 6
SCALE: N.T.S.	DRAWN BY: DATE:	TITLE: PLAN OF BUILT-UP MEMBER (3)
	CHKD BY: DATE: 3-24-80 DATE: 3/31/80	



TYPICAL WELD PREPARATION WHERE LEDGE IS A MINIMUM OF 1" WIDE & SIDE R: / BUILT-UP MEMBER (3) IS 1½"

NOTE:
1) Insure proper preheat of 200°F. ± 25°F. with 1½ hrs. soak time prior to air arc-gouging joint preparation.
2) Clean and grind after air arc-gouging to a visual acceptance per AWS D1.1 prior to welding.
3) Joint preparation shall have a minimum root gap of 3/8" with installation of backing where open root exist.
4) Complete I.D. of weld joint shall be buttered with SMAW E7018 process prior to welding except ¼" area of base material shown on detail.
5) Existing column splice welds shall not be removed, only beveled to make joint preparation acceptable.

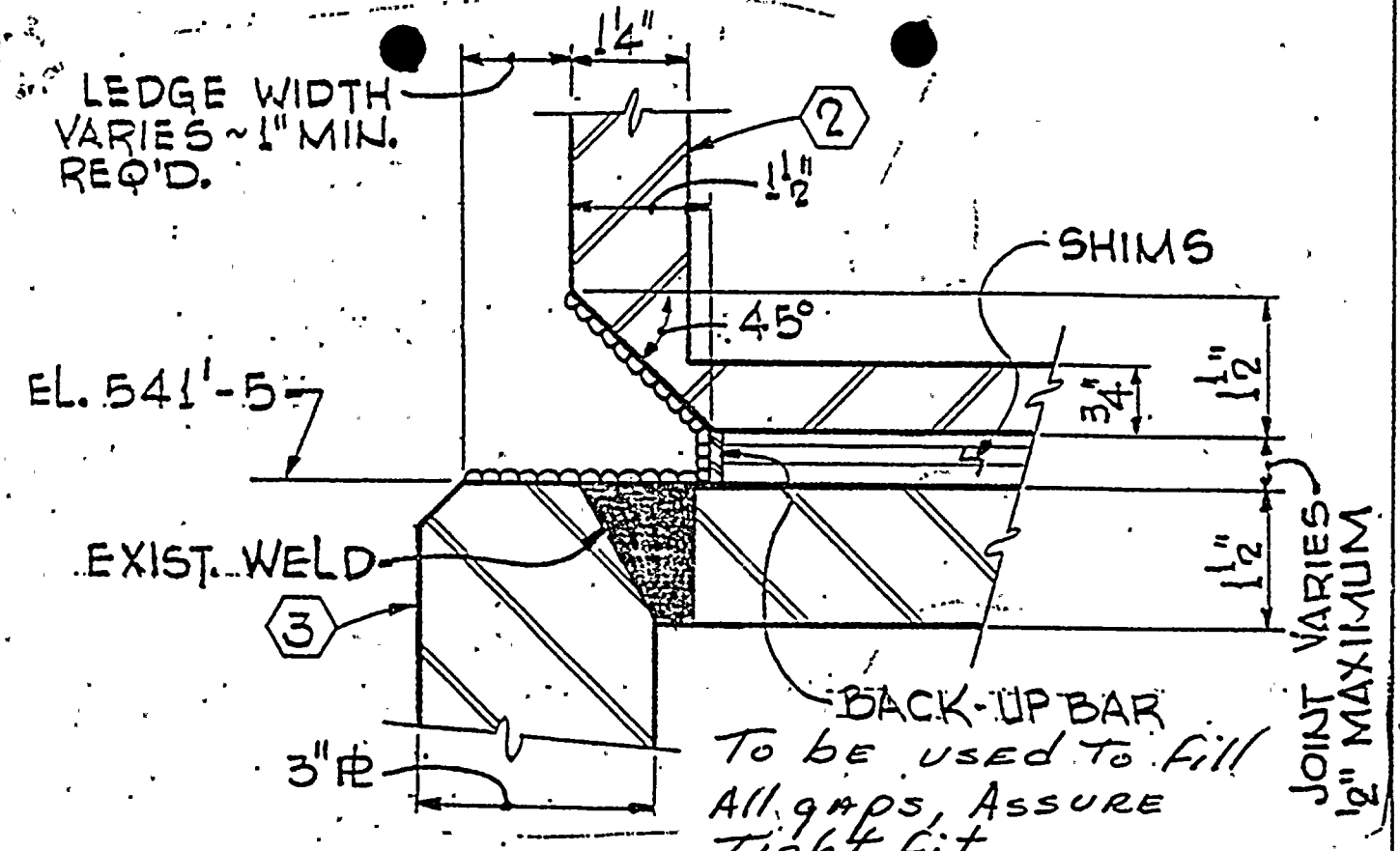
REF. DOC.: PCN — RPT NCR 215-5688			WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: — PAGE: — PARA:			BURNS AND ROE, INC.
REF. DWG.:	DWG. ZONE:		PED 215-W-2742 SHT. 3 OF 6
SCALE: N.T.S.	DRAWN BY: DATE:	CHKD BY: DATE: 3-24-83	APPVD DATE: 4-25-83
			TITLE: WELD PREPARATION



TYPICAL WELD PREPARATION WHERE LEDGE IS LESS THAN 1" WIDE & SIDE PL. / BUILT-UP MEMBER (3) IS 1½"

NOTE:
1) Insure proper preheat of 200°F. ± 25°F. with 1½ hrs. soak time prior to air arc-gouging joint preparation.
2) Clean and grind after air arc-gouging to a visual acceptance per AWS D1.1 prior to welding.
3) Joint preparation shall have a minimum root gap of 3/8" with installation of backing where open root exist.
4) Complete I.D. of weld joint shall be buttered with SMAW E7018 process prior to welding except ¼" area of base material shown on detail.
5) Existing column splice welds shall not be removed, only beveled to make joint preparation acceptable.

REF. DOC.: PCN — ~~REF~~ NCR 215-5688			WPPSS NUCLEAR PROJECT NO. 2
REF. SPEC. SECTION: — PAGE: — PARA:			BURNS AND ROE, INC.
REF. DWG.:		DWG. ZONE:	PED 215-W-2742 SHT. 4 OF 6
SCALE: N.T.S.	DRAWN BY: DATE		TITLE: WELD PREPARATION
	CHKD BY: DATE 3-24-80	APPD: DATE 5-1-80	



TYPICAL WELD PREPARATION WHERE LEDGE IS A MINIMUM OF 1" WIDE & SIDE PL. / BUILT-UP MEMBER (3) IS 3"

NOTE:
1) Insure proper preheat of 200°F. ± 25°F. with 1½ hrs. soak time prior to air arc-gouging joint preparation.
2) Clean and grind after air arc-gouging to a visual acceptance per AWS D1.1 prior to welding.
3) Joint preparation shall have a minimum root gap of 3/8" with installation of backing where open root exist.
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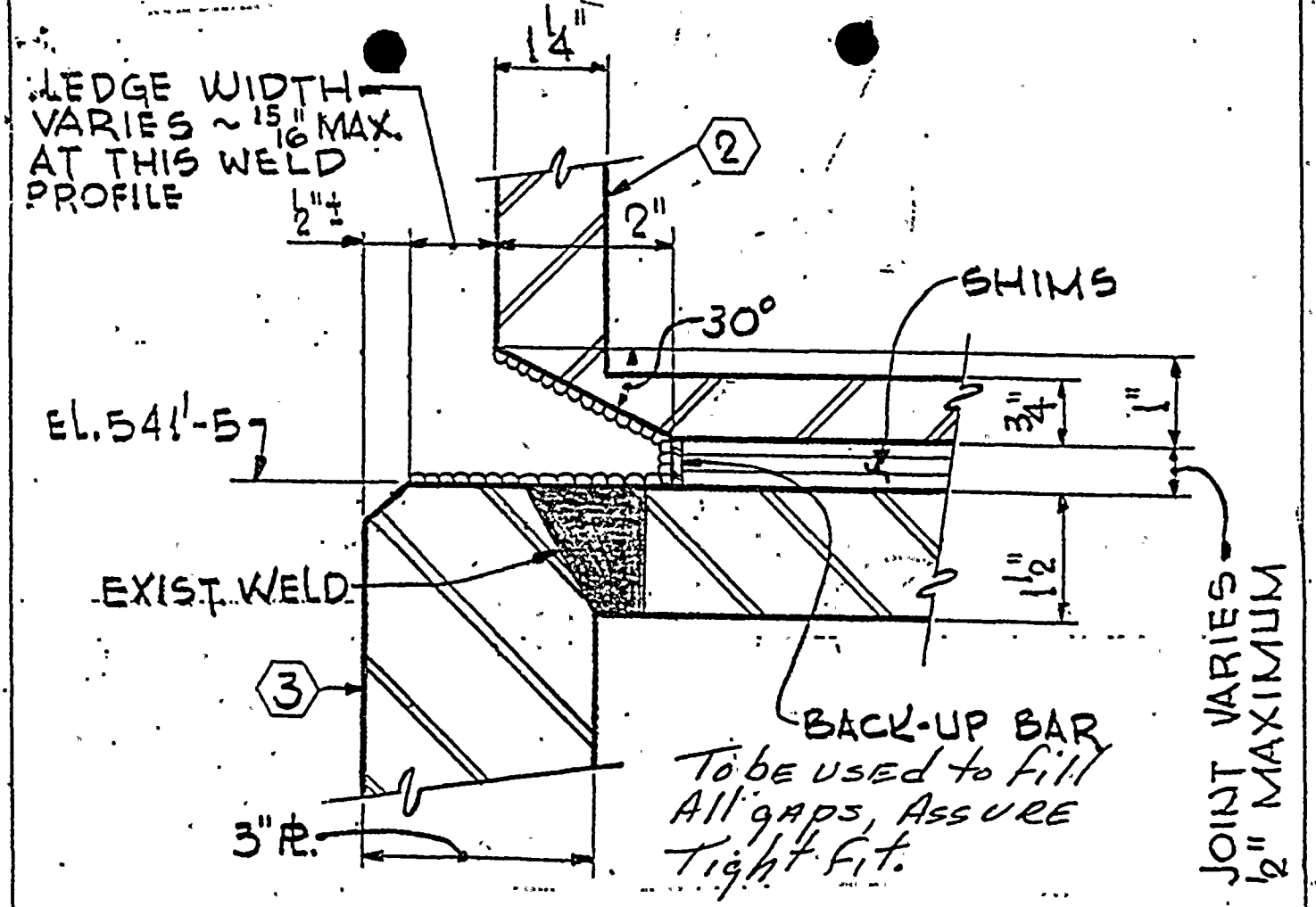
REF. SPEC. SECTION: — PAGE: — PARA: —			BURNS AND ROE, INC.
REF. DWG.: —	DWG. ZONE: —		PED 215-W-2742 SHT. 5 OF 6
SCALE: N.T.S.	DRAWN BY: DATE:		TITLE: WELD PREPARATION
	CHKD BY: MH DATE: 3-24-80	APPVD: L Baker DATE: 3-25-80	



TYPICAL WELD PREPARATION WHERE LEDGE IS LESS THAN 1" WIDE & SIDE R. / BUILT-UP MEMBER (3) IS 3"

NOTE:
1) Insure proper preheat of 200°F. ± 25°F. with 1½ hrs. soak time prior to air arc-gouging joint preparation.
2) Clean and grind after air arc-gouging to a visual acceptance per AWS D1.1 prior to welding.
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REF. SPEC. SECTION: — PAGE: — PARA: —			BURNS AND ROE, INC.
REF. DWG.: —	DWG. ZONE: —		PED 215-W-2742 SHT. 6 OF 6
SCALE: N.T.S.	DRAWN BY: DATE:		TITLE: WELD PREPARATION
	CHKD BY: DATE: 3-24-80	APPVD: DATE: 3/24/80	