

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

PROJECT
ENGINEERING
DIRECTIVE

CODE		PROJECT ENGINEERING DIRECTIVE														
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1	2	3	4	5	6	7	8	9	10	11	12	13	14	15		
DATE		0	3	/	1	4	/	8	10	PRIORITY						
		16	17		18	19		20	21	I						

REASON FOR P. E. D.:

This PED is to allow the contractor to prepare for welding to be done by Dual Shield FCAW Process.

INFORMATION
COPIES

SHEET 1 OF 1

REFERENCES

SUBJECT Dual Shield FCAW Qualification
LOCATION El. 54' 5"
ENG. SYSTEM N/A
S/U SYSTEM N/A
QUALITY CLASS I

ORIGINATING
DOCUMENTS

NRK-215-5688

DESCRIPTION OF WORK:

Contractor shall obtain machinery, welding wire and test materials to qualify a procedure and personnel, suitable to perform necessary capacity of welding to be done on the Sac. Wall.

Contractor shall coordinate all operations with Burns and Roe Welding Engineer in contractors establishment for qualifying procedures and personnel, to inable this program to be expedited.

The procedure and personnel shall be qualified in the horizontal position. The test plate for qualifying the procedure and personnel shall be in accordance with AWS D1.1 and Spec. 215-17D. A 2'x 2' mock-up of the plate thickness (as close as possible), and joint design shall be welded by each welder prior to welding on the Sac. Wall.

Type of Machinery Required

12
Manufacturer: Airco Flux
Core Welding Machines

John Brosnann
(415) 658-5010

Type of Filler Metal Required

25 lb. spools
(1500 lbs)
(Dia. .045)
Dual Shield
(E-70T-1)

Manufacturer: Chemetrom Welding Supply
(206) 682-2880
Gas - Argon - CO₂
98-2%

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: N/A
4. THIS PED DEPENDS ON THE PRIOR INSTALLATION OF THE FOLLOWING PED'S: N/A

REVISE:

NONE
DRAWINGS
SPECIFICATION

APPROVALS:

[Signature] 3-24-80
DISCIPLINE ENGINEER DATE
[Signature] 3-25-80
LEAD DISCIPLINE ENGINEER DATE
S/U LIAISON ENGINEER DATE
RESIDENT PROJECT ENGINEER DATE

