

**HOT BENDING OF CARBON STEEL
AND FERRITIC ALLOYS**

SUBMITTED TO EBASCO
FOR CONTRACT NO. 435035
SF&W S.O. NO. 3301-3308
SUPPLEMENT NO. 1
ATTACHMENT NO. —

PAGE
NO.

PROCEDURE REVISION NO. & DATE

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5/4/73								

OF 1

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PDR ADOCK 05000400
E PDR

APPROVAL

MANAGER Q.A.

V.P. ENGINEERING

G.M. OPERATIONS

EXP

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HOT BENDING OF CARBON STEEL AND FERRITIC ALLOYS

PAGE
1 OF 1

DATE
3-26-74

SUPPLEMENT #1

S. O. 3301 thru 3304

Change Paragraph #3 to read:

3. The centerline radius of a bend shall not be less than five (5) times the nominal pipe diameter.

Change Paragraph #6 to read:

6. Bending methods and controls shall be such that the difference between the maximum and minimum diameter at any cross section to the bend shall not exceed 6% of the average measured outside diameter of the straight portion of the pipe or two inches (2") whichever is greater.

Change Paragraph 7 (a) to read:

7. a) The maximum vertical height of any wave, measured from the average height of two adjoining crests to the valley, shall not exceed 3/8" in depth over a 12" length.

Change Paragraph #9 to read:

9. All hot bends shall be stress relieved.

Par. 9 Deleted By SFCW Letter "5-EB-573"

Approved By Ebasco 2-1-80.

RPA

Approved:

P. H. Pearson

R Chen

B. G. Goodwin

REVISION	①	②	③	④	⑤	⑥	⑦	⑧	⑨
BY	DFH								
DATE	3/28/02								
APPROVED	EJP								

210.61
SOUTHWEST FABRICATING
 A WELDING CO INC
 A Subsidiary of GE International

7:30 AM 2-4-80

T. Feigenbaum

7575 Laramie Blvd / P.O. Box 9442 / Houston, Texas 77211 / (713) 978-3411 / TWX 910 881-1800

January 31, 1980

S-EB-373

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MAIN FILE
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J. Harris
RPB
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Mr. Ted Feigenbaum
 Ebasco Services, Inc.
 21 West Street
 New York, NY 10006

Dear Mr. Feigenbaum:

Subject: P.O. NY-435035
 Shearon Harris Nuclear Power Plant
 S.O. 3301 thru 3308 and 4121 thru 4128

This letter will confirm our telephone conversation today.

Supplement #1 to Southwest Procedure No. 4-108 (0) which has been approved by Ebasco changes Paragraph 9 to read "All hot bends shall be stress relieved."

Since this is no longer a specification requirement for hot bends, you have agreed to authorize us to delete Paragraph #9 from Supplement #1 and include any requirement for heat treating bends on the face of our detail sheet.

Please acknowledge your concurrence with this letter by signing in the space provided below and returning a signed copy for our files.

Yours very truly,

John E. Harris
 John E. Harris
 Project Manager

JEL:jh

JOHN HARRIS

HOT BENT CARBON STEEL DOES NOT REQUIRE STRESS RELIEF.
 ALLY FERRITIC STEEL WHEN HEAT TREATED BY FULL PROCESS ANNEALING NEEDS STRESS RELIEF AND TEMPERING FOR STRESS RELIEFING. ANNEALING PROCEDURE TO BE USED ACCORDINGLY.

Ted Feigenbaum

John Harris

Procedure 4-108 (0) the procedures in existing Paragraph #9 are to include reference to S.F. (1) Letter S-EB-373 with Ebasco's acknowledgment as 1/1/80 as authority for change. J. Harris 1/4/80
 Paragraph 9 in Supplement 1 has been deleted in all copies used at S.F.W. - QA Personnel are to include reference to S.F. (1) Letter S-EB-373 with Ebasco's acknowledgment as 1/1/80 as authority for change. J. Harris 1/4/80

THC: [unclear]
 to John Harris - [unclear]

