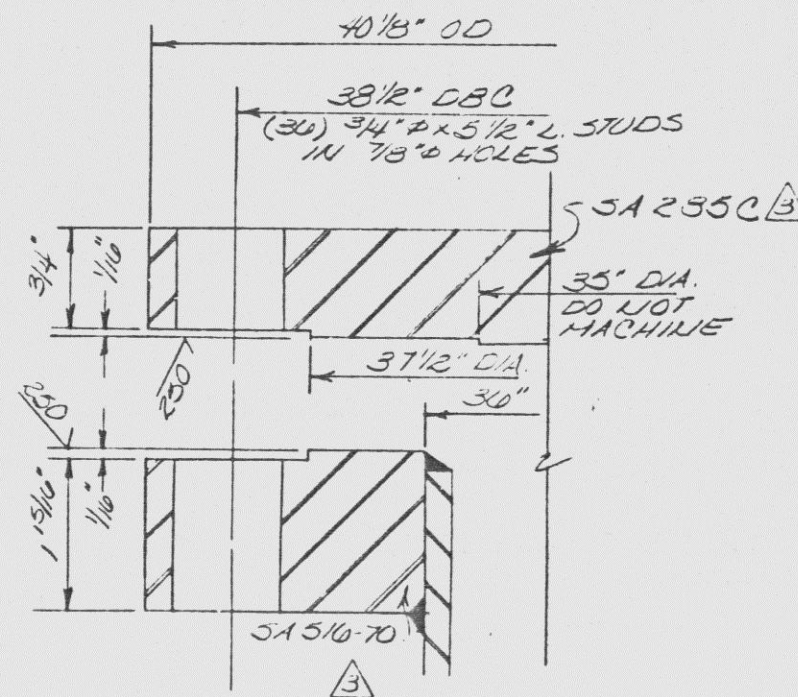


NOTES:

1. No foreign materials shall be used.
2. Certified Mill Test Reports are required. All material marking is to be in accord with ASME Sect. III.
3. All stainless steel shall be furnished in the solution-annealed condition. All 304 and 304L stainless steel must be water quenched or A285-A.
4. The surface of welds shall be free from weld splatter, coarse ripples or grooves, undercuts, overlaps, and abrupt ridges or valleys.
5. If the surface of welds require grinding, care shall be taken to avoid reducing the weld or base metal below the required thickness.
6. The maximum interpass temperature shall be 350°F. FOR AUSTENITIC STAINLESS STEEL.
7. No welding shall be performed on materials that are below a minimum temperature of 50°F.
8. Hydro-testing shall be done with fresh water and then rinsed with demineralized water.
9. A certificate of compliance shall be supplied for demineralized water.
10. Carbon steel nozzle butt weld end preps shall have the machined surfaces to 2" from the weld end coated with deoxidant.
11. Uncoated carbon steel surfaces, i.e. flange faces, bolts, nuts, etc., shall be protected with a coating of tectyl 502C.
12. RECO to notify customer of any impending test at least 10 working days prior to such tests.
13. WITNESS POINTS.
 1. soap bubble test of all reinforcing pads and saddle pads (UNLESS OTHERWISE NOTED IN DWG.)
 2. dimensional check
 3. hydrostatic test OR PNEUMATIC TEST IS APPLICABLE
14. After cleaning and drying the vessels, carbon steel nozzle prepared for welding direct to piping shall be covered with pressed steel or plastic caps. Nozzles other than carbon or low alloy steel, prepared for welding direct to piping, shall be covered with plastic caps for nozzles less than 6" and stainless steel caps for nozzles 6" and larger. These caps shall be sealed with waterproof tape. Exposed flange faces shall be covered by plywood covers securely fastened in place by at least (2) two bolts located at opposite sides of the opening. These closures shall also be sealed with waterproof tape. UNCOATED MATERIALS SHALL NOT BE USED.
15. Tag & ship (1) one spare set of gaskets with each vessel. Shipping preparations must comply with ANSI W45.2.2, Class B.
16. All stainless steel welding must comply with MTEB 5-1.

UPDATE



FLANGE DETAIL FOR H3

SURFACE PREPARATION AND PAINTING (SEE ES-104 NO REV. 2 & ANSI 45.2.1)

Chilled Water Expansion Tanks Standby Diesel Generator Fuel Oil Day Tanks
Mark Nos. 2HVK-TK1A 2EGP-TK3A
2HVK-TK1B 2EGP-TK3B
2EGP-TK4

INTERIOR - CLASS B CLEANING

EXTERIOR - Sandblast per SSPC-SP7, "Brush-off blast cleaning". Prime with one coat Mobil Chemical Co.'s "No Rust" Primer 13-R-53". (1.5 mils DFT)

Standby Diesel Generator Fuel Oil Storage Tk.

Mark Nos. 2EGP-TK1A
2EGP-TK1B
2EGP-TK2

INTERIOR - CLASS C CLEANING

EXTERIOR - FREE FROM OIL GREASE LOOSE RUST, LOOSE PAINT & LOOSE MILL SCALE (SEE ANSI 45.2.1 CLASS C)

Main Steam Safety Relief Valve Accumulator
Mark Nos. 21AS-TK 14 thru TK31

Ada Valve Accumulator
Mark Nos. 21AS-TK 12 thru TK 38

INTERIOR - Class B Cleaning

EXTERIOR - Class B Cleaning - STAINLESS STEEL - CLASS B CLEANING. CARBON STEEL BASES, 3-BLAST PER SSPC-SP7 BRUSH OFF BLAST CLEANING. PRIME (1) COAT MOBIL CHEM. CO. "NO RUST" PRIMER 13-R-53" (1.5 MILS DFT)

Skimmer Surge Tank
Mark Nos. 2SFC-TK1A
2SFC-TK1B

INTERIOR - Class B Cleaning

EXTERIOR - Stainless steel - class B cleaning, SKIET - Sandblast per SSPC-SP7 "Brush-off blast cleaning". Prime with one coat Mobil Chemical Co.'s "No Rust" Primer 13-R-53" (1.5 mils DFT)

PREPARATION FOR SHIPMENT

Provide sufficient protection for shop applied painting and/or coating systems to ensure that the coating film is not damaged or removed as a result of shop handling or during delivery. Properly designed slings consisting of web straps or similar material shall be used for handling coated equipment to prevent damage. Bore cables, chais, hooks, metal bars, and unspaced skids shall not be permitted to come in contact with the painting and/or coating. During shipment, the vessel shall be suitably protected by being supported on wooden saddles or dunnage, homosote, or a similar compressible material having been placed between the vessel coating and the supporting cribbing at all points of support. The vessels shall be kept physically separated from other materials comprising the shipment so that these items do not bear upon each other; the entire load shall be secured to prevent its shifting during transit.

TI
APERTURE
CARD

NINE MILE POINT NUCLEAR STATION-UNIT 2
NIAGARA MOHAWK POWER CORPORATION
I.O. No. 12177-P.O. No NMP2-P223E

NO. UNITS REQ'D		CUST. DWG. OR SPEC.	
CUSTOMER ORDER NO.		CUST. TAG OR ITEM NO.	
NMP2-P223E			
RICHMOND ENGINEERING CO., INC. RICHMOND VIRGINIA			
NOTES			
NIAGARA MOHAWK/STONE & WEBSTER			
REV. NO.	CHANGE NOTICE NO.	DESCRIPTION	BY DATE
1		AS SHOWN	5/16/78
2		THRU	5/16/78
3		BT	5/16/78

STONE & WEBSTER ENGINEERING CORPORATION NINE MILE POINT NUCLEAR STATION - UNIT 2 NIAGARA MOHAWK POWER CORPORATION I.O. 12177			
INSTRUCTIONS TO SUPPLIER (E2)			
APPROVED		AS DEFINED IN SPECIFICATION	
APPROVED AS REVISED			
RELEASED FOR FABRICATION			
RELEASED FOR MATERIAL PURCHASE			
SUPPLIER TO RESUBMIT	Q	REVISOR	REVISED PRINTS
	N	1	REPRODUCIBLE
	T		FOR REVIEW
			FOR RECORD
NONE REQUIRED			
NOTES:			
(E1) FOR INFORMATION ONLY RETURN TO SUPPLIER NOT REQUIRED			
INSTRUCTIONS TO DESIGN ENGINEER (E1)			
I-O	P-L	P-S	R-C F-D NEW REV
DESIGN ENGINEER'S DATE STAMP (D)			
OUT.			
INITIALS OF SELECTED REVIEWERS			
RESPONSIBLE ENGINEER'S DATE STAMP (E2)			
NOTED MAY 1 1984 L.L. 3000			
SUPERSEDES S & W FILE NO. (E1) (25-34) (35-38)			
REMARKS (C) (LIMIT TO 22 CHARACTERS & BLANKS) (33-74)			
S & W EQUIP. I.D. CODE (E1) AREA DESIGNATION (25-34)			
MFR'S. DWG. NO. (C) (LIMIT TO 24 CHARACTERS & BLANKS) (37-60)			
MFR'S. NAME (C) (LIMIT TO 20 CHARACTERS & BLANKS) (61-80)			
DATE MONTH DAY YEAR (31) MAX DATE (32-33)			
DESIGN TYPE (34) IN DESIGN (35) (36)			
FUNCTIONAL TITLE (E1) (LIMIT TO 44 CHARACTERS & BLANKS)			
NOTES			
S & W FILE NO. (E1) (25-34) (35-38)			
JOB ORDER NO. (M) 12177 00			

ATTACH TO MFR'S. C

8407260356

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