

## NGG BOP Welding Sheet

Plant: CR3	Unit 3	Non-Safety Related / Non-Seismic						WO#: 1284340-17 / EC 68886		
IDENTIFICATION OF WELD	WELDER SYMBOL	PREHEAT					WPS	FILLER METAL	FINAL VT	
		°F		INIT/DATE	H	INIT/DATE			H	INIT/DATE
1A CR-Mo to CR-Mo		400					05 3 31	ER90SB3(L)/E9018B3(L)	X	
2A CR-Mo to CR-Mo		400					05 3 31	ER90SB3(L)/E9018B3(L)	X	
3A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
4A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
5A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
6A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
7A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
8A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
9A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
10A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
Note:11A CR-Mo to SS		300					08 3 31	ER309/E309	X	
Note:12A CR-Mo to SS		300					08 3 31	ER309/E309	X	
13A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
14A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
15A CR-Mo to CR-Mo		400					05 3 02	ER90SB3(L)/E9018B3(L)	X	
INSTRUCTIONS/REMARKS										
Installation Code: B31.1; Weld per Corporate Welding Manual, NGGM-PM-0003.										
Tag No.: "A" Deaerator Bypass Line							*Asterisk in front of weld number indicates weld numbers that may be added by the Weld Engineer or Work Group Supervisor (WGS) via pen/ink mark-up to the weld map as needed during fabrication or installation.			
Drawing No. / Weld Map EC Attachment Z10										
Matl: A106 Gr. B and A234 WP22 16 in. dia. Sch 40										
Matl: A335 P22 and A217 WC9 10 in. dia. Sch 40										
Matl: A335 P22 and A182 F316 10in. dia. Sch 40										
Matl: A335 P22 and A234 WP22 10 in. dia. Sch 40										
Note: Welds 11A and 12A require purging (backing gas)										
Prep and fit-up fillet welds in accordance with WJD – 08										
butt welds in accordance with WJD – 02, and socket welds										
in accordance with WJD – 10										
VT per NDEP-601 with acceptance to VA-N02 for AWS D 1.1, and VA-N14 for ASME B31.1										
Contact QC or qualified inspector for final VT										
RELEASE FOR WELDING / DATE										
Supervisor Review										
Initial/Date										

## NGG BOP Continuation Sheet

[illegible]

# WELD MAP 1284340-17

## 'B' Bypass Line

