

NGG BOP Welding Sheet

Plant: CR3	Unit: 3	Non-Safety Related / Non-Seismic					WO#: 1284340-41 / EC 68886			
IDENTIFICATION OF WELD	WELDER SYMBOL	PREHEAT					WPS	FILLER METAL	FINAL VT	
		°F	H	INIT/DATE	H	INIT/DATE			H*	INIT/DATE
1 CS to CS		50					01 3 04	ER70S-2/E7018	X	
2 CS to CS		50					01 3 04	ER70S-2/E7018	X	
3 CS to CS		50					01 3 04	ER70S-2/E7018	X	
4 CS to CS		50					01 3 04	ER70S-2/E7018	X	
5 CS to CS		50					01 3 04	ER70S-2/E7018	X	
6 CS to CS		50					01 3 04	ER70S-2/E7018	X	
7 CS to CS		50					01 3 04	ER70S-2/E7018	X	
8 CS to CS		50					01 3 04	ER70S-2/E7018	X	
9 CS to CS		50					01 3 04	ER70S-2/E7018	X	
10 CS to CS		50					01 3 04	ER70S-2/E7018	X	
11 CS to CS		50					01 3 04	ER70S-2/E7018	X	
12 CS to CS		50					01 3 04	ER70S-2/E7018	X	
13 CS to CS		50					01 3 04	ER70S-2/E7018	X	
14 CS to CS		50					01 3 04	ER70S-2/E7018	X	
15 CS to CS		50					01 3 04	ER70S-2/E7018	X	
INSTRUCTIONS/REMARKS										
Installation Code: B31.1; Weld per Corporate Welding Manual, NGGM-PM-0003.							*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.			
Tag No.: Chilled Water Piping to new Cooling Water Mixing Skid										
Drawing No.: EC Attachment Z26 and Z49 Weld map 1284340-41 Sheet 1, 2, 3, 4 and 5										
Temp range = T < 350°F										
Socket fillet weld to meet WJD-10.										
1 inch SCH 40 socket fillet weld size = 3/16"										
Matl: A106 Gr. B and A105 1 in. dia. Sch 40										
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							Supervisor Review Initial/Date			
Contact QC or qualified inspector for final VT										
RELEASE FOR WELDING / DATE										

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IDENTIFICATION OF WELD	WELDER SYMBOL	PREHEAT					WPS	FILLER METAL	FINAL VT	
		°F	H	INIT/DATE	H	INIT/DATE			H*	INIT/DATE
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17 CS to CS		50					01 3 04	ER70S-2/E7018	X	
18 CS to CS		50					01 3 04	ER70S-2/E7018	X	
19 CS to CS		50					01 3 04	ER70S-2/E7018	X	
20 CS to CS		50					01 3 04	ER70S-2/E7018	X	
21 CS to CS		50					01 3 04	ER70S-2/E7018	X	
22 CS to CS		50					01 3 04	ER70S-2/E7018	X	
23 CS to CS		50					01 3 04	ER70S-2/E7018	X	
24 CS to CS		50					01 3 04	ER70S-2/E7018	X	
25 CS to CS		50					01 3 04	ER70S-2/E7018	X	
26 CS to CS		50					01 3 04	ER70S-2/E7018	X	
27 CS to CS		50					01 3 04	ER70S-2/E7018	X	
28 CS to CS		50					01 3 04	ER70S-2/E7018	X	
29 CS to CS		50					01 3 04	ER70S-2/E7018	X	
30 CS to CS		50					01 3 04	ER70S-2/E7018	X	
31 CS to CS		50					01 3 04	ER70S-2/E7018	X	
32 CS to CS		50					01 3 04	ER70S-2/E7018	X	
33 CS to CS		50					01 3 04	ER70S-2/E7018	X	
34 CS to CS		50					01 3 04	ER70S-2/E7018	X	
35 CS to CS		50					01 3 04	ER70S-2/E7018	X	
36 CS to CS		50					01 3 04	ER70S-2/E7018	X	
37 CS to CS		50					01 3 04	ER70S-2/E7018	X	
38 CS to CS		50					01 3 04	ER70S-2/E7018	X	
39 CS to CS		50					01 3 04	ER70S-2/E7018	X	
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50 CS to CS		50					01 3 04	ER70S-2/E7018	X	
51 CS to CS		50					01 3 04	ER70S-2/E7018	X	
52 CS to CS		50					01 3 04	ER70S-2/E7018	X	
53 CS to CS		50					01 3 04	ER70S-2/E7018	X	
54 CS to CS		50					01 3 04	ER70S-2/E7018	X	
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66 CS to CS		50					01 3 04	ER70S-2/E7018	X	
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93 CS to CS		50					01 3 04	ER70S-2/E7018	X	
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NGG BOP Continuation Sheet

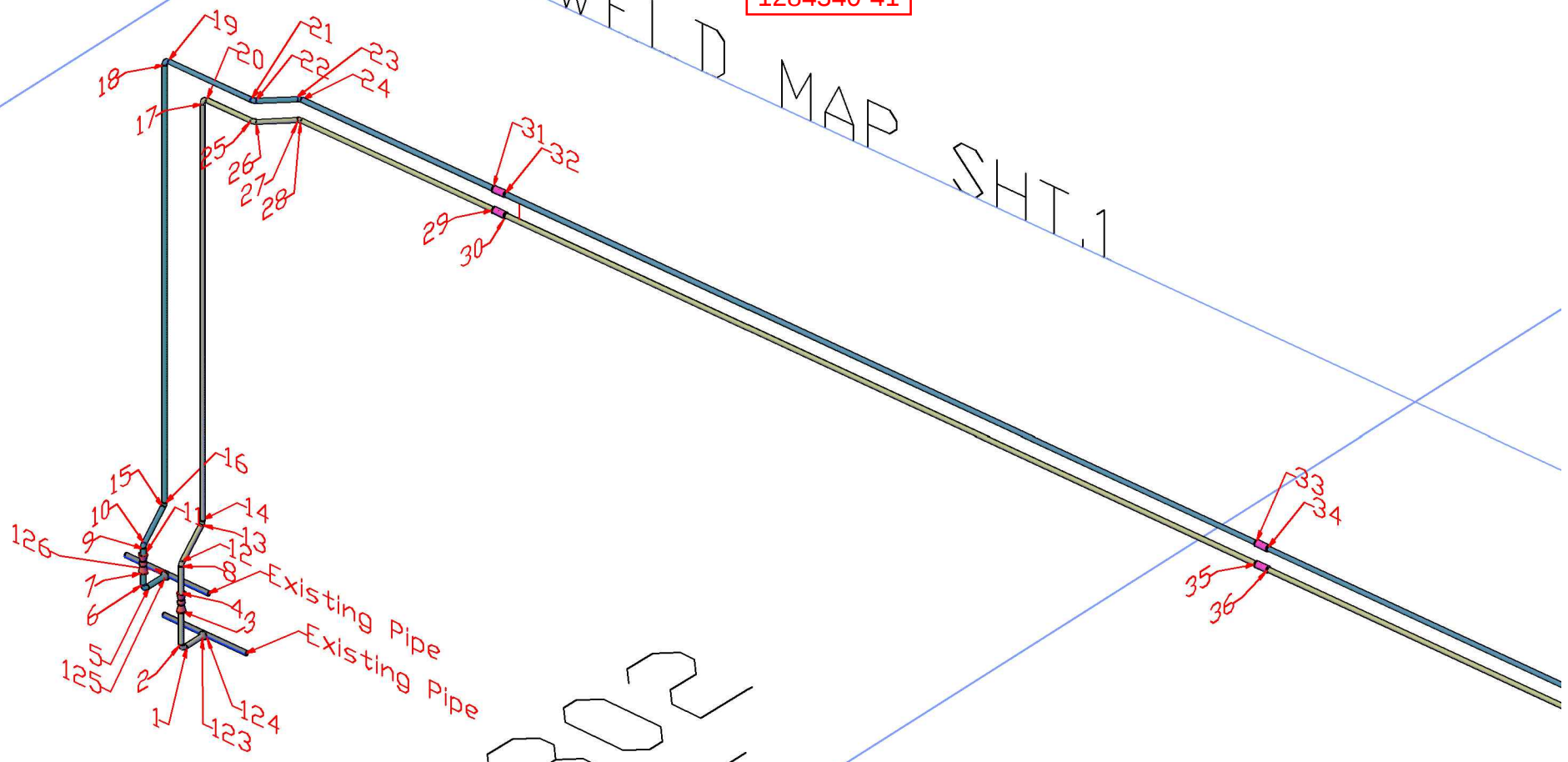
Weld ID:							WO#: 1284340-41 / EC 68886			
IDENTIFICATION OF WELD	WELDER SYMBOL	PREHEAT					WPS	FILLER METAL	FINAL VT	
		°F	H	INIT/DATE	H	INIT/DATE			H*	INIT/DATE
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124 CS to CS		50					01 3 04	ER70S-2/E7018	X	
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WELD MAP

1284340-41

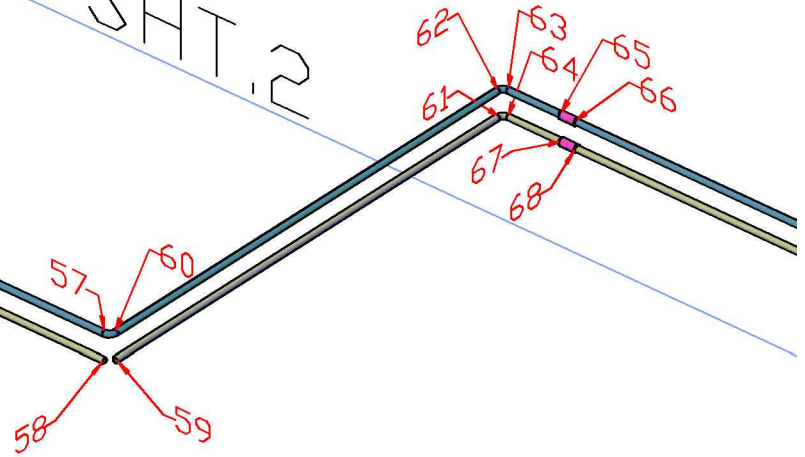
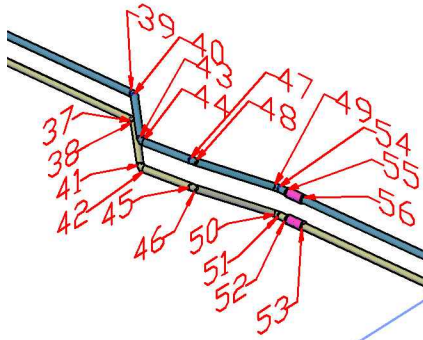
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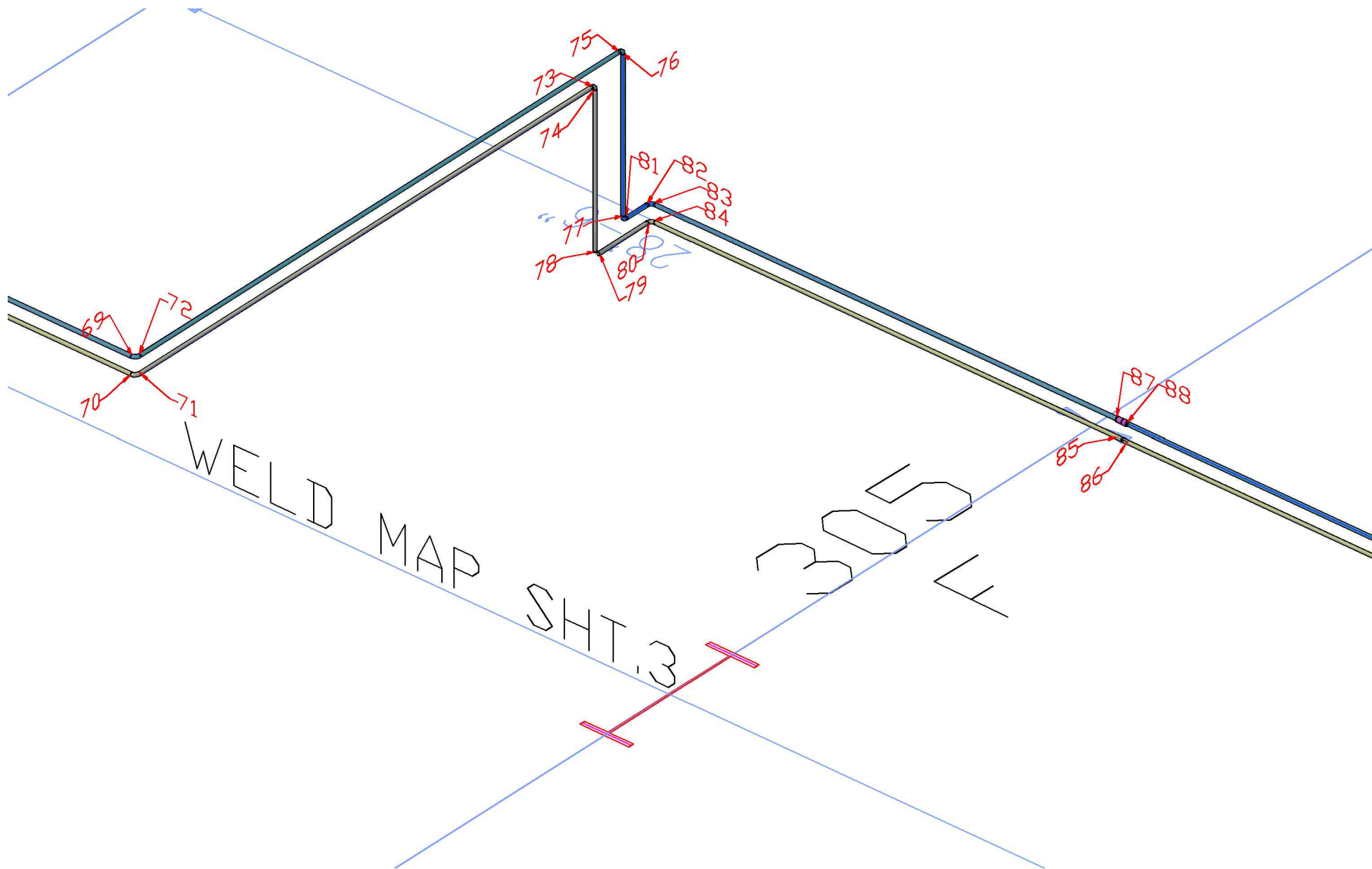


WELD MAP SHT. 2

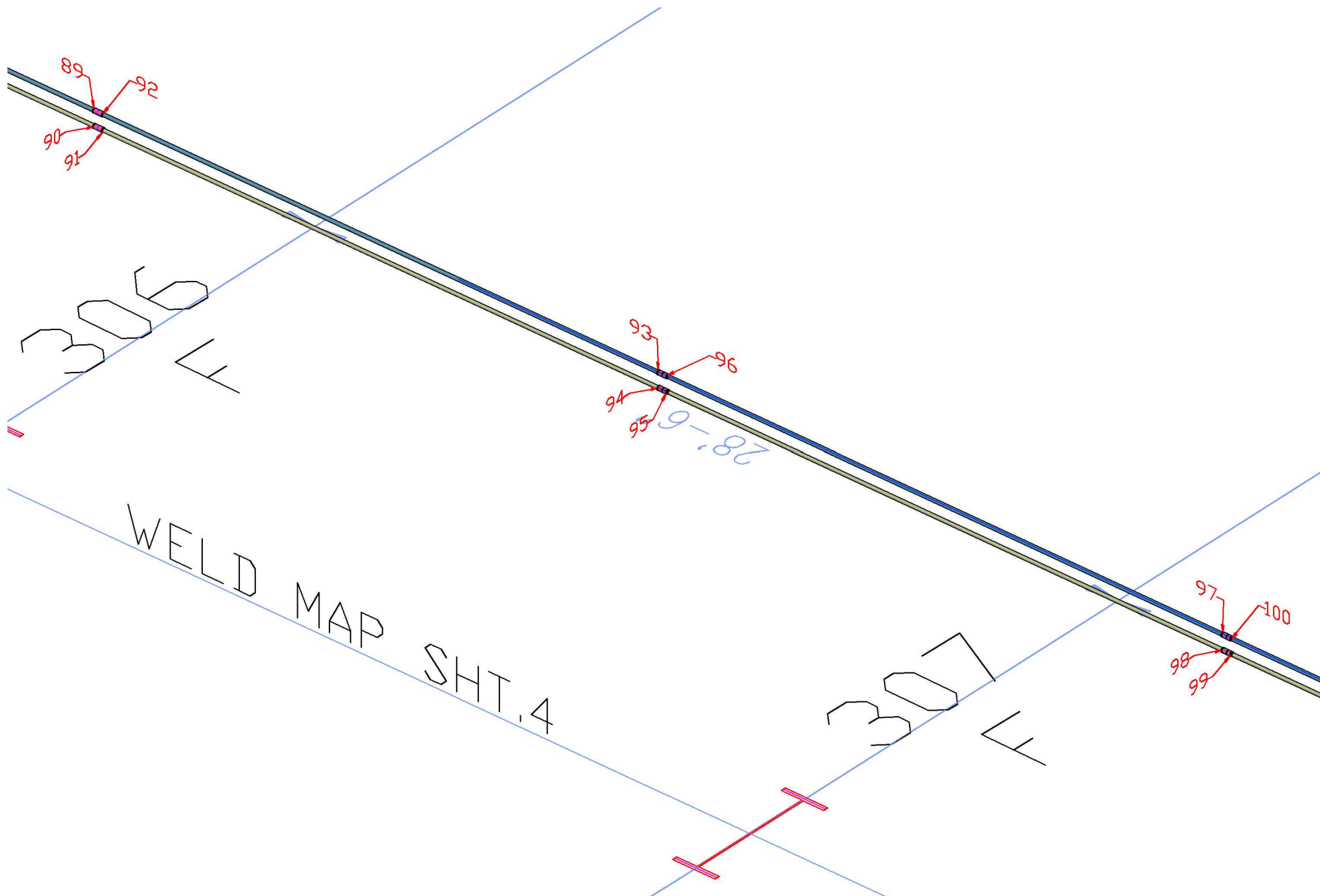
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