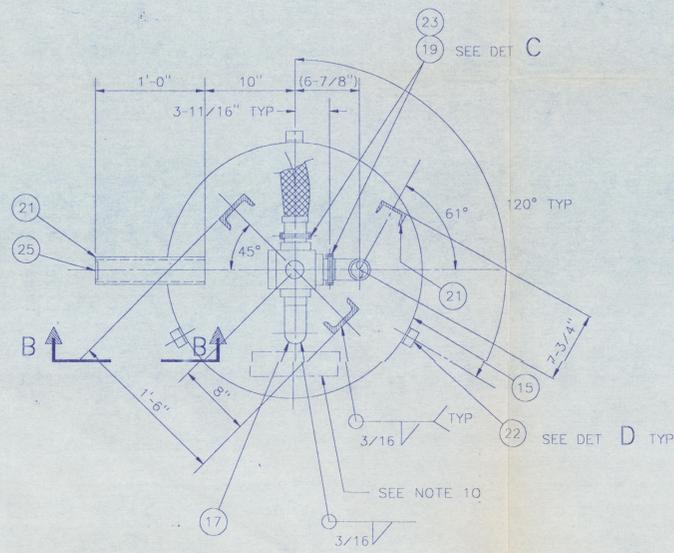
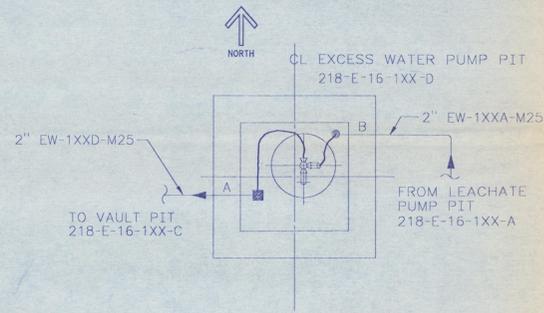


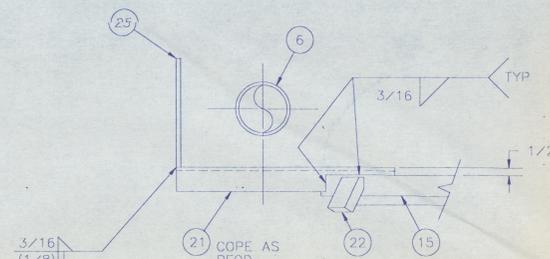
PLAN



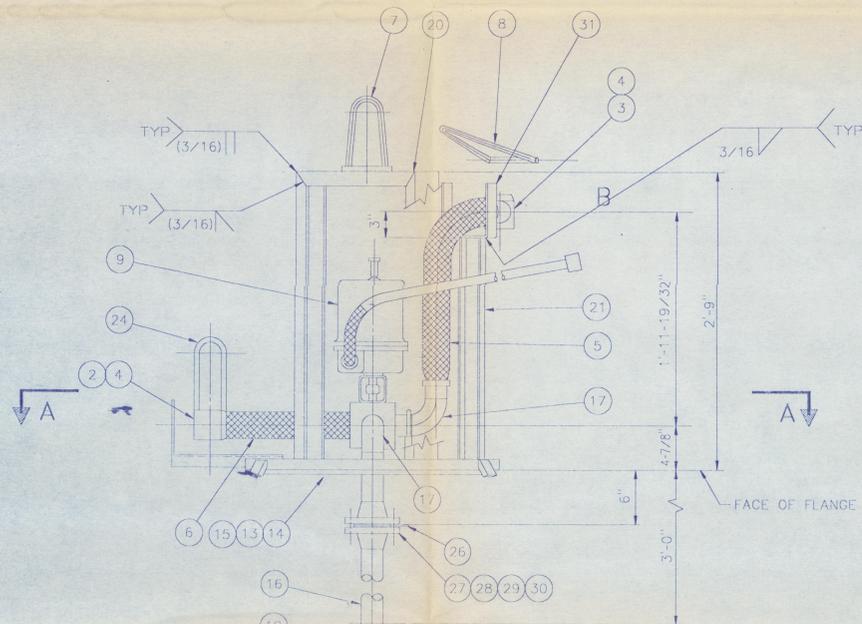
SECTION A-A
SCALE: 1-1/2"=1'-0"



KEY PLAN
SCALE: NONE

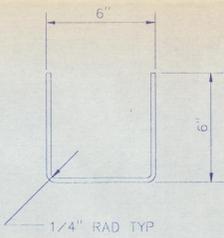


SECTION B-B
SCALE: 3"=1'-0"

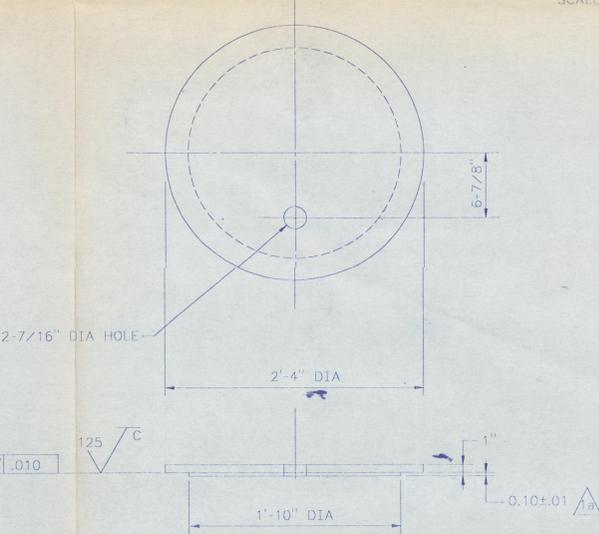


ELEVATION

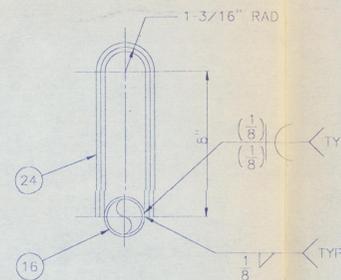
1 ASSEMBLY
SCALE: 1-1/2"=1'-0"



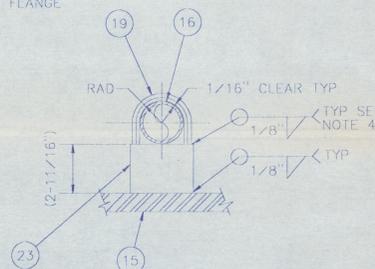
31 GUIDE
SCALE: 3"=1'-0"



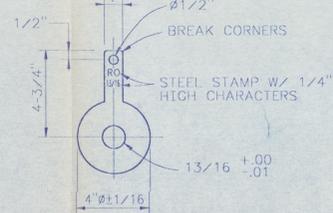
15 FLANGE
SCALE: 1-1/2"=1'-0"



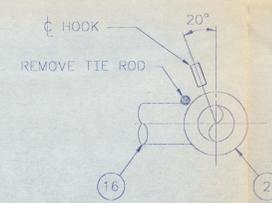
DETAIL E
SCALE: 3"=1'-0"



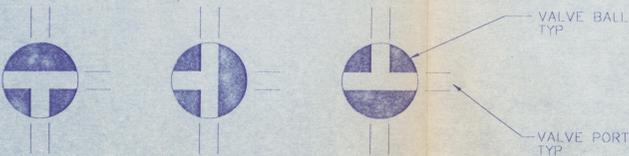
DETAIL C
SCALE: 3"=1'-0"



DETAIL D
SCALE: 3"=1'-0"



DETAIL G
SCALE: NONE



DETAIL F
SCALE: NONE

26 RESTRICTING ORIFICE
SCALE: 3"=1'-0"

QTY	PN	DESCRIPTION	MATERIAL
1	2	ASSEMBLY	
1	3	CONNECTOR HORIZONTAL 2"	H-2-32420-1
1	4	CONNECTOR VERTICAL 2"	H-2-32420-2
2	5	GASKET 2" TYPE III	H-2-3997-6
1	6	HOSE FLEXIBLE METAL 2" X 2'-7" LONG	H-2-57901-5
1	7	HOSE FLEXIBLE METAL 2" X 4'-4" LONG	H-2-57901-5
1	8	BAIL STANDARD RIGID ASSEMBLY 1	H-2-90161
1	9	BAIL STANDARD FOLDING ASSMBLY 2	H-2-90160
1	10	VALVE BALL 2" 3-WAY (MOV-8)	SEE NOTE 9
1	11	CORD AND CABLE FITTING, CGB 3/4" WITH WIRE MESH GRIP CAT # RPE-417-117	CROUSE HINDS CAT NO CGB296-SG
1	12	CABLE CONNECTOR	ITT CANNON CAT NO CA-3101E-24 A24P-F80
1	13	CABLE, 9/C#12 TYPE TC 600V RADIATION RESISTANT 50 FT LONG	ROCKBETOS FIREWALL III
1	14	GASKET 26"OD X 24"ID X 1/2" THK	#B 43-N BOYD IND RUBBER DIV
AR	15	GASKET CEMENT	3-M FORMULA 1300 ADHESIVE
1	16	FLANGE	ASTM A 36
AR	17	PIPE 2" SCHED 40	ASTM A 106 GR B
2	18	ELBOW 90° 2" SCHED 40	ASTM A 234 GR WPB
1	19	ELBOW 45° 2" SCHED 40	ASTM A 234 GR WPB
2	20	BAR 3/8 DIA BY LENGTH AS REQD	ASTM A 36
AR	21	C4 X 5.4	ASTM A 36
AR	22	C3 X 4.1	ASTM A 36
3	23	BAR 2 X 1/2 X 2"	ASTM A 36
2	24	BAR 2-11/16 X 3/4 X 3 1/2"	ASTM A 36
1	25	BAR 1/2 DIA X LENGTH AS REQD	ASTM A 36
1	26	BAR 2 X 1/4 X 6"	ASTM A 36
1	27	RESTRICTING ORIFICE, 1/8" FLAT	ASTM A240 316
2	28	FLANGE 2" CLASS 150 WELD NECK RF	ASTM A105
2	29	GASKET 2", 1/16" THK	ANCHOR NO 443
4	30	BOLT, HEX 5/8-11 UNC-2A X 3"	ASTM A307 GR B
8	31	NUT, HEX 5/8-11 UNC-2B	ASTM A563 GR B
1	32	BAR 2 X 1/4" X L AS REQD	ASTM A36

NOTES

- FABRICATE IN ACCORDANCE WITH HS-B5-0084 EXCEPT AS NOTED IN SPECIFICATIONS (SEE H-2-77603 SHEET 2)
- THE ASSEMBLY SHALL BE BALANCED TO HANG VERTICAL ± 2" WHEN SUSPENDED FROM BAIL PART 7.
- MACHINE FINISH TO BE 250 UNLESS OTHERWISE NOTED
- WELD ALL AROUND AS FAR AS POSSIBLE
- REMOVE ALL BURRS AND BREAK SHARP EDGES ON ALL METAL PARTS
- TOTAL WEIGHT 375 POUNDS APPROXIMATELY
- SUBSTITUTE APPROPRIATE VAULT NUMBER IN PLACE OF "XX"
- FOR BALL VALVE (MOV-8) ELECTRICAL CONNECTIONS SEE ELEMENTARY DIAGRAM DWG H-2-77636 SH 1 AND CONNECTION SCHEDULE DWG H-2-77642 SH 1
- PITTSBURGH BRASS 3-WAY BALL VALVE NO. 2-MP-E-17-BW-2/P-POCOSO/H6, 1-PORT 180 DEGREE TURN, FLOW PATTERN #5 WITH ACTUATOR NO. ER-350-3-4-AE6-AE9B SERIES ER, MODEL 350, 3 SECOND TIME CYCLE, NEMA 4 ENCLOSURE, WITH BRAKE, 3 POSITION WITH CONTROL AT BOTH ENDS AND SHALL BE 120VAC, 1PH, 60 HZ, HAVING 3500 LB-IN TORQUE OUTPUT. MOTOR BRAKE SHALL BE 120 VAC. ACTUATOR TO HAVE DOUBLE POLE DOUBLE THROW (DPDT) SWITCHES FOR ALL THREE POSITIONS.
- IDENTIFY ASSEMBLY BY PAINTING BLACK STENCILLED LETTERS ON YELLOW, WITH THE FOLLOWING: H-2-77603 REV 0 LEACHATE RECYCLE A-B, WEIGHT = 375, USING 1" HIGH CHARACTERS, AND PAINT SPECIFIED ON SHEET 2.
- PREPARE AND PAINT ALL CARBON STEEL PARTS IN ACCORDANCE WITH SPECIFICATIONS ON SHEET 2.
- SURFACE TEXTURE SYMBOLS ARE IN ACCORDANCE WITH ANSI Y14.36. SURFACE TEXTURE VALUES ARE IN MICROINCHES AND IN ACCORDANCE WITH ANSI B46.1.

CHARLES R. ZODIAC
Professional Engineer
REGISTERED PROFESSIONAL ENGINEER
No. 11112
EXPIRES 12/31/90

DOES NOT CONTAIN CLASSIFIED OR UNCLASSIFIED CONTROLLED INFORMATION

APPROVED FOR IMPLEMENTATION
BY: W.W. RUTHERFORD
FOR: WHC DATE: 2/7/90

NUMBER	TITLE	REFERENCES
H-2-77573	DRAWING LIST	
H-2-77602	SH 2	

REV. NO.	DESCRIPTION	DATE	APPROVED FOR IMPLEMENTATION
1	b) B-714-59 ZN E7 a) B-714-27 ZN C4 THRU B-714-61 GEN REV: ENCORP ALL ECNS	2/7/90	W.W. RUTHERFORD

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1	2/7/90	W.W		

SPECIFICATIONS

1. SUBMITTALS

- 1.1 SUBMIT FOR REVIEW AND APPROVAL 10 COPIES OF: DIMENSIONAL DRAWINGS, EQUIPMENT WEIGHTS, SPECIFICATION, MATERIAL DESCRIPTIONS, PERFORMANCE DATA, CIRCUIT OR CONTROL DIAGRAMS, DATA SHEETS, INSTALLATION INSTRUCTIONS FOR PART 9.
- 2.0 QUALIFICATION OF WELDING PERSONNEL AND PROCEDURES
- 2.1 PERSONNEL AND PROCEDURES FOR WELDING PRESSURE RETAINING COMPONENTS ALONG WITH ATTACHMENTS THERETO SHALL HAVE BEEN QUALIFIED IN ACCORDANCE WITH ANSI B31.3, 1987 EDITION WITH ADDENDA ANSI B31.3 a AND B31.3 b BEFORE WELDING
- 2.2 MAINTAIN FILE OF WELDING PROCEDURE SPECIFICATIONS, PROCEDURE QUALIFICATION RECORDS AND WELDER PERFORMANCE QUALIFICATION TEST RESULTS AT FABRICATION SITE FOR REVIEW.
- 3.0 QUALIFICATION OF NONDESTRUCTIVE EXAMINATION (NDE) PERSONNEL
- 3.1 "VISUAL WELD EXAMINATIONS AND APPROPRIATE DOCUMENTATION SHALL BE PERFORMED BY PERSONNEL QUALIFIED TO THE EXISTING WESTINGHOUSE HANFORD COMPANY PROGRAM WITH OVERSIGHT BY CERTIFIED WELDING INSPECTORS (CWI) WHO HAVE RECEIVED CERTIFICATION IN ACCORDANCE WITH AWS QC1. DOCUMENTATION SHALL BE SIGNED OR BEAR THE WELDING INSPECTOR'S STAMP, IN ADDITION TO THE CWI UNDER WHOM THE EXAMINATION WAS PERFORMED."
- 3.2 PERSONNEL PERFORMING OTHER NDE SHALL HAVE BEEN CERTIFIED IN ACCORDANCE WITH CONTRACTOR'S WRITTEN PRACTICE, WHICH SHALL MEET THE REQUIREMENTS OF ASNT NO. SNT-TC-1A, 1984 EDITION AND ANSI B31.3, 1987 EDITION WITH ADDENDA ANSI B31.3 a AND B31.3 b. BEFORE PERFORMING NDE. USE LEVEL II OR III PERSONNEL TO INTERPRET TEST RESULTS.
- 3.3 MAINTAIN FILE OF PERSONNEL CERTIFICATIONS, CONTRACTOR'S WRITTEN PRACTICE, AND WRITTEN NDE PERFORMANCE PROCEDURES, OTHER THAN VISUAL, AT FABRICATION SITE FOR REVIEW.

4.0 DELIVERY, STORAGE, AND HANDLING

4.1 PIPE

- 4.1.1 PRESERVE IDENTITY OF PIPE FROM TIME OF RECEIPT ON SITE UNTIL INSTALLATION IS COMPLETE. STORE PIPE OF DIFFERENT MATERIAL SPECIFICATION AND GRADE SEPARATELY.
- 4.1.2 WHEN PIPE IS REMOVED FROM BUNDLE AND CUT, RETURN REMAINING PIECE TO BUNDLE OR CLEARLY AND PERMANENTLY MARK. DO NOT REMOVE MANUFACTURER'S IDENTIFYING TAGS FROM BUNDLES.
- 4.1.3 WHEN MATERIAL IDENTIFYING MARK IS CUT FROM LENGTH OF PIPE RE-MARK REMAINING SECTION CLEARLY AND PERMANENTLY. USE EITHER ORIGINAL MARKING OR FIELD CODE IDENTIFICATION SYMBOL.

4.2 WELDING MATERIALS

- 4.2.1 STORE SEPARATELY, WELDING MATERIALS OF DIFFERENT MATERIAL SPECIFICATIONS.
- 4.2.2 STORE AND CONTROL FILLER MATERIAL IN ACCORDANCE WITH APPROVED PROCEDURE.
- 4.2.3 PRESERVE IDENTITY FROM TIME OF RECEIPT ON SITE UNTIL USE IN FABRICATED ASSEMBLY.

5.0 WELDING

5.1 WELD IN ACCORDANCE WITH ANSI B31.3.

5.2 WELD IDENTIFICATION

- 5.2.1 PREPARE WELD IDENTIFICATION DRAWING WHICH SHOWS RELATIVE LOCATION OF EACH WELDMENT IN PRESSURE CONTAINING PIPING. ASSIGN WELD NUMBER TO EACH PRESSURE CONTAINING WELD AND EACH ATTACHMENT WELD TO PRESSURE RETAINING COMPONENTS. RECORD WELD NUMBER ON WELD IDENTIFICATION DRAWINGS AS WELD IS MADE.
- 5.2.2 PERFORM NONDESTRUCTIVE WELD EXAMINATION IN ACCORDANCE WITH PARAGRAPH 6.0

5.3 COMPLETE NDE AND LEAK TESTING BEFORE APPLICATION OF EXTERIOR PROTECTIVE COATING.

6.0 NONDESTRUCTIVE WELD EXAMINATION (NDE)

- 6.1 VISUAL EXAMINATION: EXAMINE ALL WELDS (INCLUDING STRUCTURAL WELDS) IN ACCORDANCE WITH ANSI B31.3, 1987 EDITION PARAGRAPH 341.4.1 AND 344.2, NORMAL SERVICE.
- 6.2 MAGNETIC PARTIAL EXAMINATION): EXAMINE 100% OF ALL COMPLETED LIFTING BAIL WELDS IN ACCORDANCE WITH B31.3, 1987 EDITION PARAGRAPH 344.3 (NORMAL SERVICE).
- 6.3 RADIOGRAPHIC EXAMINATIONS: EXAMINE NOT LESS THAN 5% OF ALL COMPLETED PRESSURE CONTAINING BUTT WELDS IN ACCORDANCE WITH ANSI B31.3, 1987 EDITION PARAGRAPH 344.5
 - A. IF IRIIDIUM 192 SOURCE IS USED, DELIVER VERIFIED RADIOGRAPHIC EXAMINATION PROCEDURES, BEFORE PRODUCTION RADIOGRAPHS ARE PERFORMED. PROCEDURES SHALL BE VERIFIED BY DEMONSTRATION THAT REQUIRED RADIOGRAPHIC SENSITIVITY HAS BEEN OBTAINED FOR MATERIAL TO BE RADIOGRAPHED. PROCEDURE SHALL BE PROVEN SATISFACTORY BY ACTUAL DEMONSTRATION OF PENETRAMETER RESOLUTION ON MINIMUM THICKNESS OF MATERIAL TO BE RADIOGRAPHED. USE OF COBALT 60 WILL NOT BE PERMITTED.
 - B. IDENTIFY RADIOGRAPHIC FILM WITH WELD NUMBER AND PROJECT OR WORK ORDER NUMBER ASSIGNED TO WORK COVERED BY THIS SECTION.

- C. PREPARE RADIOGRAPHIC EXAMINATION REPORTS AS FOLLOWS: LIST EACH RADIOGRAPHIC EXPOSURE LOCATION (0-1, 1-2, ...) INDIVIDUALLY ON RADIOGRAPHIC EXAMINATION REPORT. INDICATE LOCATION ACCEPTABILITY OR REJECTABILITY AND NOTE DISCONTINUITIES WHETHER REJECTABLE OR NOT. WHEN REPORT INCLUDES RADIOGRAPHS OF WELDS WHICH HAVE BEEN REPAIRED, INDICATE WHICH WELDS ARE REPAIR WELDS AND HOW MANY TIMES EACH WELD HAS BEEN REPAIRED.
- D. IF ADDITIONAL WELDING IS PERFORMED ON WELD AREA WHICH HAS ALREADY BEEN EXAMINED RADIOGRAPHICALLY, THIS AREA IS REPAIR AREA. IDENTIFY SUBSEQUENT RADIOGRAPHS BY "R-1, R-2" ETC.

6.4 HYDRO TEST AT 225 PSI PER ANSI/ASME B31.3.

6.5 NDE DOCUMENTATION

- A. DOCUMENT EXAMINATION OF PRESSURE CONTAINMENT WELDS AND WELDS TO PRESSURE RETAINING COMPONENTS FOR PIPING SYSTEMS ON NDE/WELD RECORD FORM.
- B. DOCUMENTATION SHALL BE KEPT CURRENT AND IS SUBJECT TO REVIEW. PREPARE AND CERTIFY RECORDS AS WORK PROGRESSES.
- C. REQUIRED NDE/WELD EXAMINATIONS SHALL BE COMPLETED AND DOCUMENTED BEFORE PAINTING PER PARA 7.0.
- D. NDE/WELD RECORD INFORMATION INCORPORATED ON SINGLE FORMAT OR TRAVELER FOR SPECIFIC WORK PACKAGE.
- E. DELIVER COMPLETED NDE/WELD RECORD AND RECORD WELD IDENTIFICATION DRAWINGS TO PROJECT FILE.
- F. DELIVER COMPLETED HYDRO TEST RECORD.

7.0 PAINTING

- 7.1 PAINT ALL EXPOSED CARBON STEEL SURFACES, EXCEPT PIPE NOZZLE CONTACT SURFACES AND GASKET SEAL SURFACES.
- 7.2 PREPARE FERROUS METAL IN ACCORDANCE WITH SSPC-SP-3, REMOVE ABRASIVE RESIDUE AND DUST, AND PRIME WITHIN 4 HOURS AFTER PREPARATION.
- 7.3 APPLY COATING MATERIALS IN ACCORDANCE WITH MANUFACTURER'S RECOMMENDATIONS.
- 7.4 THE FOLLOWING MATERIALS SHALL BE USED.

SURFACE CONDITIONER: CARBOLINE THINNER #2 OR TULUOL
 PRIMER: CARBOLINE D893
 FINISH COATINGS: CARBOLINE D890

FINISH COLOR SHALL BE GRAY
 MATERIAL RESTRICTIONS: ZINC BASED PRIMERS AND PAINTS SHALL NOT BE USED



DOES NOT CONTAIN CLASSIFIED OR UNCLASSIFIED CONTROLLED NUCLEAR INFORMATION
 REVIEWING OFFICIAL/ADC: *[Signature]*
 DATE: 11-28-90

DRAWN KC KENOYER 3/12/89		IMPACT LEVEL 3		EDT 151523	
CHECKED RP ZAMA 2-1-90		M		U.S. DEPARTMENT OF ENERGY	
SAFETY D LUNDGREN 2-5-90		RICHLAND OPERATIONS OFFICE		KAISER ENGINEERS HANFORD COMPANY	
ENVR RG HOLLENBECK 2-5-90		PROJECT		B-714 GROUT VAULT PAIR 218-E16-102 & 103	
DET D HAYS 2-5-90		SIZE		218E-1E 8405	
LEAD ENG APPV CR ZOOK 2-5-90		INDEX NO.		H-2-77603	
KEH REP KC BURGARD 2-5-90		DWG NO.		218E-1E 8405	
REV NO. 1		DESCRIPTION		B-714-27 ZN E8 THRU B-714-61 GEN REV; INCORP ALL ECNS	
REV BY DATE		KEH APPROVALS		APVD FOR IMP/CNC FOR DATE	
CAD FILE B077603B		CAD CODE 2J:IBM:ACD2:10:0:NN (1=1)		APPROVED FOR IMPLEMENTATION BY YW RUTHERFORD DATE 2-7-90	
SCALE NONE		JOB NO. 242500		SHEET 2 OF 2	

NUMBER	TITLE	NUMBER	TITLE
	DRAWING TRACEABILITY LIST		REFERENCES
			NEXT USED ON H-2-77573

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