



# Specification Change Notice

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|--------------------------|--|------------------------|-----|
| JOB NO.<br>24590         | TITLE FOR CHANGE NOTICE<br>Cutting Method for Access Opening |                        |     |
| DESIGN DOCUMENT NUMBER   | REV  | DESIGN DOCUMENT NUMBER | REV |
| 24590-WTP-3PS-MVB2-T0002 | 0  |                        |     |

PART OF DESIGN CHANGE PACKAGE (DCP)?  Yes  No DCP No.: N/A Rev:

JUSTIFICATION FOR CHANGE  
Define requirements for Cutting method and weld preparation.

CAUSE CODE  
42

Supersedes Change Document  Yes  No

**REQUIREMENTS REVIEW**

Client Approval Required  Yes  No Interface Resolution Required \*  Yes  No

Address any "yes" answers in the description

DESCRIPTION OF CHANGE  
Specification Changes Retroactive  Yes  No

**Revise paragraph 3.1.16 to read as follows:**

**3.1.16**  
A temporary access opening in the vessel shell will need to be made in order to perform repairs or alterations. Subcontractor shall submit drawings showing access opening location relative to existing weld seams to avoid cutting across an existing weld seam. Subcontractor shall include proposed cutting method on drawing. The access opening shall be cut with a 2-inch minimum corner radius.

Subcontractor is responsible to clean up and remove any debris from the cutting or machining operation. The internal and external of the vessel and any nearby internal or external components shall be protected from molten metal, slag, dross, splatter, water or abrasives utilized in the cutting operation. Prior to performing the procedure, the subcontractor shall install protective measures which capture or direct the particulates in a controlled manner to the extent that minimal clean up is necessary.

**Add the following new paragraphs 3.1.17 & 3.1.18 as follows:**

**3.1.17**  
The original cut-out of the access opening shall be prepared and re-welded to the vessel using a full penetration butt weld. The root gap opening for re-welding shall be consistent with the Welding Procedure Specification(s) (WPS) utilized for the weld. Prior to performing welding the root gap shall be visually examined for compliance to the WPS(s). Cut-out shall be tacked into place and prepared for welding prior to the examination. All tack welds shall be made in the groove using an approved WPS and consumed in the weld out of the joint.

**3.1.18**  
100% of the new weld seam shall be examined using either radiographic or ultrasonic examination in accordance with the applicable submitted procedure and Project Specifications.

Please note that source, special nuclear, and byproduct materials, as defined in the Atomic Energy Act of 1954 (AEA) are regulated at the U. S. Department of Energy (DOE) facilities exclusively by DOE acting pursuant to its AEA authority. DOE asserts that pursuant to AEA, it has sole and exclusive responsibility and authority to regulate source, special nuclear, and byproduct materials at DOE-owned nuclear facilities. Information contained herein on radionuclides is provided for process description purposes only.



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24590-WTP-3PN-MVB2-00011

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## DESCRIPTION OF CHANGE

### Add the following new paragraph 5.1.2 for cleaning requirements as follows:

Contact materials including marking materials, temperature indicating crayons, adhesive backed and pressure sensitive tape, and barrier and wrap materials may be used only under the following limits **(not applicable to blankets, sheeting etc. to be used for temporary protective measures during cutting and welding operations):**

- The total halogen content shall not exceed 200 parts per million (PPM)
- The total sulfur content shall not exceed 400 PPM
- No intentionally added low melting point metals such as lead, zinc, copper, tin, antimony, and mercury.

Anti spatter compounds shall not contain chlorine, fluorine, sulfur, mercury or other low melting point metals.

Materials and residue shall be completely removed when no longer required. Cleaning materials may be non-halogenated solvents or potable water containing no more than 50 PPM chloride. Contact materials shall be controlled and documented in accordance with the subcontractor's inspection and test plan as approved by the Buyer.

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|---------------------------------|--|-----------------------|--|
| ORIGINATOR<br>Mohan Arulampalam |  | CHECKER<br>Steve Vail |  |
|---------------------------------|--|-----------------------|--|

## Reviews

|                         |                                |  |  |
|-------------------------|--------------------------------|--|--|
| E&NS - M. Rosenthal<br> | MET - R. Davis<br><br>10/19/10 |  |  |
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## Approval(s)

|                      |  |  |  |
|----------------------|--|--|--|
| PEQ - John Julyk<br> |  |  |  |
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Date (inserted by final approver): 10/18/10