



QUANTITIES LISTED PARTS LIST FOR TWO (2) UPPER HALF BODY WELDMENTS				
PART NO.	SUB PART NO.	NO. REQD.	DESCRIPTION	MATERIAL
2101	A	1390	WELD ROD-	CARBON STEEL
2101	S	180	WELD ROD	5.5% L TYPE 305
2502	Z		FLANGED HUB CASTINGS	DWG. 5133-2500
2501	4		BODY BOLTING FLANGE	DWG. 5133-2500
2101	AA	4	3" R <sup>1</sup> / <sub>4</sub> " NET X 13" 2"	ASTM A 204-40 SA 285 F.R.
			BODY CENTER SECTIONS	
2101	AB	4	1 1/2" R	"
			BODY CONICAL SECTIONS	
2101	AC	4	1 1/2" R	"
			CURVED BODY OUTER RIB SEGMENTS CENTER	
2101	AD	8	1 1/2" R	"
			CURVED BODY CENTER RIB SEGMENTS	
2101	AE	8	1 1/2" R	"
			BODY RIB	
2101	AF	4	1 1/2" R	- GUSSETS "
2101	AG	4	1 1/2" R	- GUSSETS "
2101	AL	2	1 1/2" R X 12" X 20"	- OPERATOR DEFLECTOR "
2101	AM	2	1" R X 12" APPROX. 2" 11"	- DIPPERATOR DEFLECTOR "
2101	AN	2	1" R X 12" X APPROX. 2" 10"	- OPERATOR DEFLECTOR "
2101	AP	8	1 1/2" R	CURVED BODY OUTER RIB SEGMENTS END "
2101	AQ	4	1 1/2" R	BODY CONICAL SECTION "

GENERAL NOTES

1. FOR PROPOSED LAYOUT OF PLATE MATERIAL FOR VALVE BODY WELDMENT SEE CUTTING SHEET NO. 1

2. VALVE BODY FABRICATION TOLERANCES TO BE PER SPEC. CIVENG-32-015-08 PARAG. 2-04. THE MAXIMUM PERMISSIBLE OFFSET ON THE INSIDE FINISHED SHOP WELDED CIRCUMFERENTIAL JOINT TO BE  $\frac{1}{8}$  INCH. WATERWAY SURFACES OF ADJOINING PARTS TO BE BOLTED TOGETHER SHALL BE FLUSH.

3. ALL WELDING TO BE PER SPEC. PARAG. 1-14 WITH QUALIFIED WELDERS FOR PROCEDURE A-3885 & AS SPECIFIED.

4. INSPECTION OF WELDS TO BE PER SPEC. PARAG. 1-15 VALVE BODY WELDMENT -  
X-RAY ALL FULL PENETRATION BUTT WELDS.  
MAGNAFLUX ALL OTHER WELDS.  
MAGNAFLUX WELD INSPECTION WILL CONSIST OF FULL PENETRATION WELDS -  
MAGNAFLUX ROOT PASS & EACH  $\frac{1}{8}$  THICKNESS OF DEPOSITED METAL INCLUDING THE FINISH PASS.  
FILLET WELDS  
MAGNAFLUX FINISH PASS ONLY

5. STRESS RELIEVE VALVE BODY WELDMENT BEFORE MACHINING PER ASME CODE PARAG. UW-40

$\Delta^2$

6. CLEAN WELDS WITH SLAGGING GUN AND GRINDING AS REQUIRED TO REMOVE ALL SLAG AND SPLATTER

INSPECTION: SEE GENERAL NOTES ABOVE  
CLEANING: NONE, EIGHTH, PER. NOTE 6  
PAINTING: PER. DWG. 5233-1000 & 5233-1100

WELD PROCEDURE: SEE GENERAL NOTES ABOVE  
STRESS RELIEVE: " " " "  
TESTING: AT SHOP ASSEMBLY

LUBRICATION: NONE  
TOLERANCES: SHOP STD UNLESS SHOWN OTHERWISE

CUSTOMER'S APPROVAL

**FINAL RECORD**  
JAN 14 1960

REFERENCE DRAWINGS		5233-2200					
△	A-3	SPAL UN 17-1/2" WAS 17-1/2"		FEW	8/14/59		
△	B-6	DELETED CHIPPING OUT LIPS		TRF	7/14/59		
△	A-3	REVISED SECT C OF PECK & LETTER		A.R.	4/10/59		
△	A-5	CHANGED TO BUTTERFLY VALVE AND TAP WAS STD. 2000 R & D		FEW	9/14/59		
△	B-6	REVISED PER SEC LETTER		R.D.	7/27/59		
△	C-3, 4, 5, 6, 7, 8	REVISED PER SEC LETTER 12/16/58		A.R.	11/14/59	FEW	
MARK		ZONE		REVISIONS		BY	DATE
FOR CONTRACT		DA-32-015-CIVENG-59-113					
TITLE		FURT PECK DAM					
		18" BUTTERFLY VALVE ASSY.					
		UPPER HALF BODY WELDMENT					
WILLAMETTE IRON AND STEEL COMPANY							
2800 N. W. FRONT AVENUE PORTLAND 10, OREGON							
DR. V. H. R.		DATE		DATE ISSUED		JAN 5 1960	
TR.		DATE		FILE NO.		H- 4069	
CH. AD.		APPROV. FEW		COMPONENT		SUB	
SO. 5233		2100				6	



