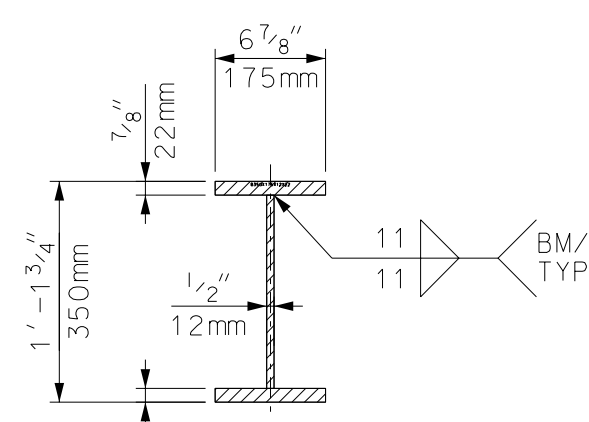
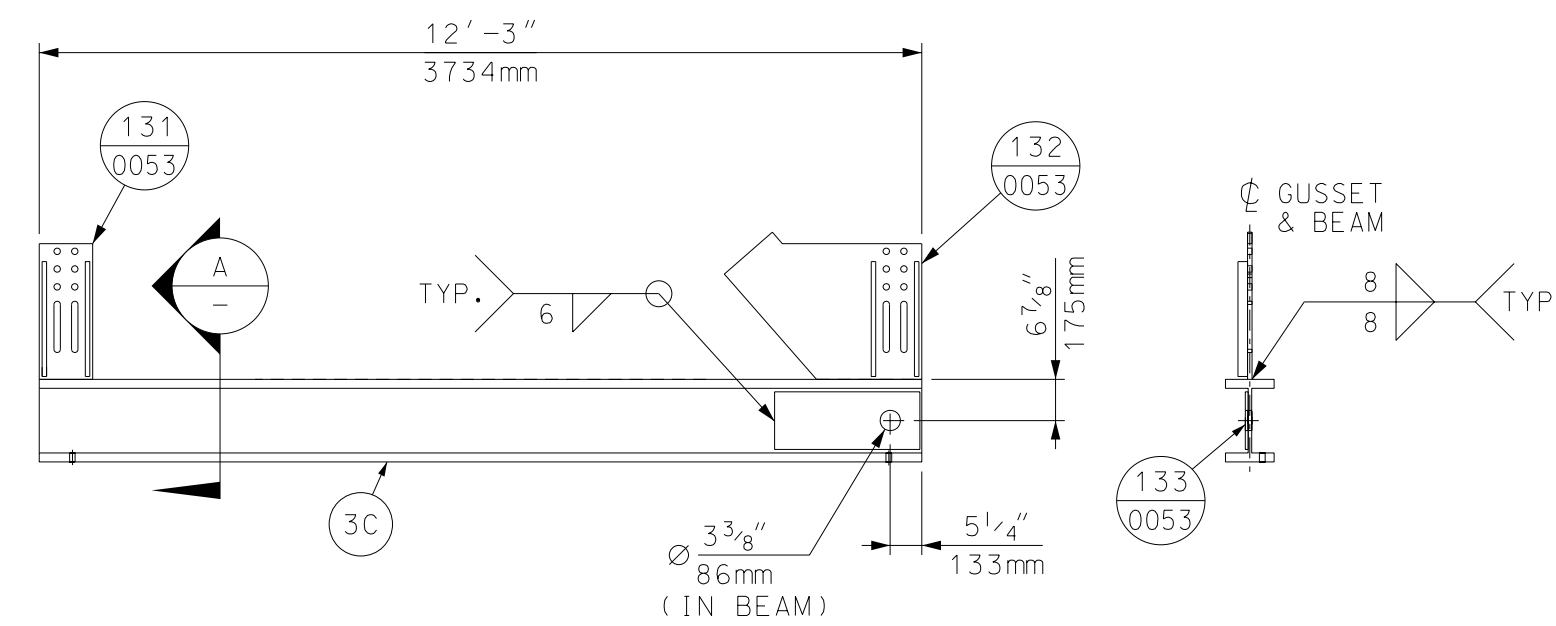


BEAM ASSEMBLY

ASS'Y 100 FRONT BOX 3A, 4A, 5A & BACK BOX 3C, 4C, 5C (SHOWN) 0030, 0040,
ASS'Y 101 FRONT BOX 3C, 4C, 5C & BACK BOX 3A, 4A, 5A (OPPOSITE) 0050

SECTION

B350x205x15x38
SCALE: 1"=1'-0"



BEAM ASSEMBLY

ASS'Y 102 FRONT BOX 3B, 4B, 5B (SHOWN) 0031, 0041
ASS'Y 103 BACK BOX 3B, 4B, 5B (OPPOSITE) 0051

SECTION

B350x175x12x22
SCALE: 1"=1'-0"

WELD NDT REQUIREMENTS			
		SEISMIC WELD DEMAND CATEGORY	
		A	B
			C
SEISMIC WELD CONSEQUENCE CATEGORY	H	CJP MT 100% OF JOINTS, FULL LENGTH UT 100% OF JOINTS, FULL LENGTH PJP, FILLETS MT 100% OF JOINTS, FULL LENGTH	CJP MT 100% OF JOINTS, FULL LENGTH IF TRANSVERSELY LOADED, PARTIAL LENGTH IF LONGITUDINALLY LOADED. UT 100% OF JOINTS, FULL LENGTH IF TRANSVERSELY LOADED, PARTIAL LENGTH IF LONGITUDINALLY LOADED. (REDUCE UT TO 25% OF JOINTS, OF LENGTH ABOVE, WITH LOW REJECT RATE) PJP, FILLETS MT 25% OF JOINTS, FULL LENGTH IF TRANSVERSELY LOADED, PARTIAL LENGTH IF LONGITUDINALLY LOADED.
	M	CJP MT 100% OF JOINTS, FULL LENGTH UT 100% OF JOINTS, FULL LENGTH (REDUCE UT TO 25% OF JOINTS, FULL LENGTH, WITH HIGH ACCEPTANCE RATE) PJP, FILLETS MT 100% OF JOINTS, FULL LENGTH	CJP MT 100% OF JOINTS, FULL LENGTH IF TRANSVERSELY LOADED, PARTIAL LENGTH IF LONGITUDINALLY LOADED. UT 100% OF JOINTS, FULL LENGTH IF TRANSVERSELY LOADED, PARTIAL LENGTH IF LONGITUDINALLY LOADED. (REDUCE UT TO 25% OF JOINTS, OF LENGTH ABOVE, WITH LOW REJECT RATE) PJP, FILLETS MT 25% OF JOINTS, FULL LENGTH IF TRANSVERSELY LOADED, PARTIAL LENGTH IF LONGITUDINALLY LOADED.
	L	CJP MT 25% OF JOINTS, FULL LENGTH UT 25% OF JOINTS, FULL LENGTH PJP, FILLETS MT 10% OF JOINTS, 6" SPOT AT RANDOM	CJP UT 10% OF JOINTS, FULL LENGTH PJP, FILLETS MT 10% OF JOINTS, 6" SPOT AT RANDOM

[illegible]

PART NUMBERS ARE TO HAVE THE PREFIX OF "BC". FOR EXAMPLE, "30A" (ASSEMBLY) + "1R" (PART NUMBER) WOULD BE "BC30A1R".

NOTE:

1. SEE ASSEMBLY DRAWINGS FOR GENERAL NOTES.
2. ALL WELDS P1-P1, UNLESS INDICATED OTHERWISE.
3. QUANTITIES SHOWN ARE FOR (1) ONE UNIT,
-(1) ONE UNIT REQUIRED FOR MIDDLETOWN PROJECT.
-(1) ONE UNIT REQUIRED FOR KINGS MOUNTAIN PROJECT.
4. UT IS ONLY REQUIRED WHEN THE WELD THROAT IS $\geq \frac{5}{16}$ " (8mm)
OR GREATER
5. REDUCE THE RATE OF UT, WHERE NOTED, IF AFTER 40 WELDS
AN INDIVIDUAL WELDER'S REJECT RATE IS LESS THAN 5%.
6. PARTIAL LENGTH TESTING IS APPLICABLE FOR LONGITUDINAL
LOADED WELDS OVER 24 INCHES(600mm) LONG.
INSPECT SIX INCHES(150mm) AT THE BEGINNING AND END OF
EACH WELD, PLUS ANY LOCATION ALONG THE WELD WHERE
A START OR RESTART IS VISUALLY NOTED FOR A DISTANCE
OF SIX INCHES(150mm) ON EITHER SIDE OF THE START/
STOP LOCATION, AND A SIX INCH LENGTH (150mm) FOR EVERY
TEN FEET (3M) FOR A GIVEN WELD.
7. THE QA/QC CATEGORY IS LISTED FOR EVERY DEMAND CRITICAL
WELD. IT HAS THREE LETTERS WITH A FORWARD SLASH (/)
SEPARATING THE SECOND AND THIRD LETTERS. (E.G. AH/T)
- THE FIRST LETTER OF THE QA/QC CATEGORY IS THE
SEISMIC WELD DEMAND CATEGORY (A, B, OR C).
- THE SECOND LETTER OF THE QA/QC CATEGORY IS THE
SEISMIC WELD SEQUENCE CATEGORY (H, M, OR L).
- THE THIRD LETTER OF THE QA/QC CATEGORY
(AFTER THE SLASH) IS THE DIRECTION OF LOAD (I OR L).


REFERENCE DRAWINGS:

V17494-BCND-0030 - BOTTOM CASING BOX 3 (BC30A & BC30C)
V17494-BCND-0031 - BOTTOM CASING BOX 3 (BC30B)
V17494-BCND-0040 - BOTTOM CASING BOX 4 (BC40A & BC40C)
V17494-BCND-0041 - BOTTOM CASING BOX 4 (BC40B)
V17494-BCND-0050 - BOTTOM CASING BOX 5 (BC50A & BC50C)
V17494-BCND-0051 - BOTTOM CASING BOX 5 (BC50B)
V17494-BCND-0053 - BOTTOM CASING BOX 3 THRU 5 DETAILS
V17494-BCND-0090 - STANDARD CASING & LINER DETAILS
V17494-EBND-0103 - STANDARD FABRICATION TOLERANCES
FOR TOP AND BOTTOM CASINGS

[illegible]

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MIDDLETOWN ENERGY CENTER and KINGS MOUNTAIN ENERGY CENTER for NTE ENERGY and GEMMA POWER SYSTEMS VOGT POWER PROJECTS V17494 & V17495	3rd ANGLE PROJECTION  Scale: 3/8" = 1' - 0"
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Title	BOTTOM CASING BOX 3 THRU 5 DETAILS
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Internal Drawing Status	Size	Drawing No.	Rev.
FOR RECORD	D	V17494-BCND-0052	00