



**Northeast  
Nuclear Energy**

Rope Ferry Rd. (Route 156), Waterford, CT 06385

Millstone Nuclear Power Station  
Northeast Nuclear Energy Company  
P.O. Box 128  
Waterford, CT 06385-0128  
(860) 447-1791  
Fax (860) 444-4277

The Northeast Utilities System

MAY 31 2000

Docket No. 50-423  
B18098

U.S. Nuclear Regulatory Commission  
Attention: Document Control Desk  
Washington, DC 20555

Millstone Nuclear Power Station, Unit No. 3  
Inservice Inspection Program  
Request For Relief From ASME Section XI

Northeast Nuclear Energy Company (NNECO) hereby requests relief from the requirements of 10 CFR 50.55a(g) for performing the required examinations for certain Class 2 components in accordance with the American Society of Mechanical Engineers (ASME) Section XI for Millstone Unit No. 3.

Technical Specification 4.0.5 states that the Inservice Inspection and Testing of the ASME Code Class 1, 2, and 3 components shall be performed in accordance with Section XI of the ASME Boiler and Pressure Vessel Code and applicable addenda as required by 10 CFR 50.55a. 10 CFR 50.55a(a)(3) allows that alternatives to specific provisions of the Code may be used when approved by the Director, Office of Nuclear Reactor Regulation. Accordingly, pursuant to 10 CFR 50.55a(g)(5)(iii), NNECO hereby requests relief from performing the volumetric and surface examination on the inaccessible portions of the Steam Generator (S/G) 1A Feedwater Nozzle-to-Shell Weld and from performing the volumetric examination on the inaccessible portions of the "B" Residual Heat Removal (RHR) Heat Exchanger Shell-to-Flange Weld. Detailed relief descriptions are provided in Attachments 1 and 2. The alternatives described herein are determined to provide a commensurate level of quality and safety as allowed under 10 CFR 50.55a(a)(3)(i)

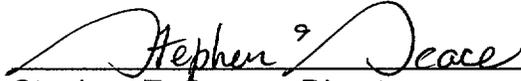
It is requested that NRC approval be provided by December 31, 2000, to support timely implementation of these Relief Requests prior to the next planned refueling outage scheduled for February 2001.

U.S. Nuclear Regulatory Commission  
B18098/Page 2

Should you have any questions regarding this matter, please contact Mr. R. G. Joshi at (860) 440-2080.

Very truly yours,

NORTHEAST NUCLEAR ENERGY COMPANY

A handwritten signature in cursive script that reads "Stephen E. Scace". The signature is written in black ink and is positioned above a horizontal line.

Stephen E. Scace - Director  
Nuclear Oversight and Regulatory Affairs

Attachments (2): Relief From Inservice Inspection Requirements (IR-2-13): Second Inspection Interval - Pressure Retaining Nozzle Welds in Vessels

Relief From Inservice Inspection Requirements (IR-2-14): Second Inspection Interval - Pressure Retaining Welds in Pressure Vessels

cc: H. J. Miller, Region I Administrator  
V. Nerses, NRC Senior Project Manager, Millstone Unit No. 3  
A. C. Cerne, Senior Resident Inspector, Millstone Unit No. 3

Attachment 1

Millstone Nuclear Power Station, Unit No. 3

Relief From Inservice Inspection Requirements (IR-2-13)  
Second Inspection Interval - Pressure Retaining Nozzle Welds in Vessels

Attachment 1

Relief From Inservice Inspection Requirements

**Relief Request:**

IR-2-13

Second Inspection Interval - Pressure Retaining Nozzle Welds in Vessels.

**Component Identification:**

Code Class: 2

Examination Category: C-B

Item Number: C2.21 - Steam Generator Nozzle-to-Shell  
Welds

Component Identification Number: 03-053-SW-R  
(S/G 1A Feedwater nozzle to shell)

**Code Requirements**

A volumetric and surface examination of essentially 100 percent of the weld length shall be conducted in accordance with the 1989 Edition of the ASME Boiler and Pressure Code, Table IWC-2500-1 and as clarified in Code Case N-460.

**Code Relief Request**

Pursuant to 10 CFR 50.55a(g)(5)(iii) relief is requested from performing the volumetric and surface examination on the inaccessible portions of the subject vessel weld to the extent required by code.

**Basis for Relief**

Permanent obstructions limit the volumetric and surface examination of the subject weld. The examination is limited to approximately 82 percent coverage for the surface exam and approximately 70 percent coverage for the volumetric exam using the most current examination technology. The obstruction consists of permanently mounted supports for insulation panels as shown on the attached sketch. Based on these permanent obstructions, relief is requested on complying with the 100 percent required examination coverage of this weld.

The limitations described above were included in a request for relief (IR-7) during the First Inspection Interval, with relief granted by (NRC) Letter dated February 8, 1991.

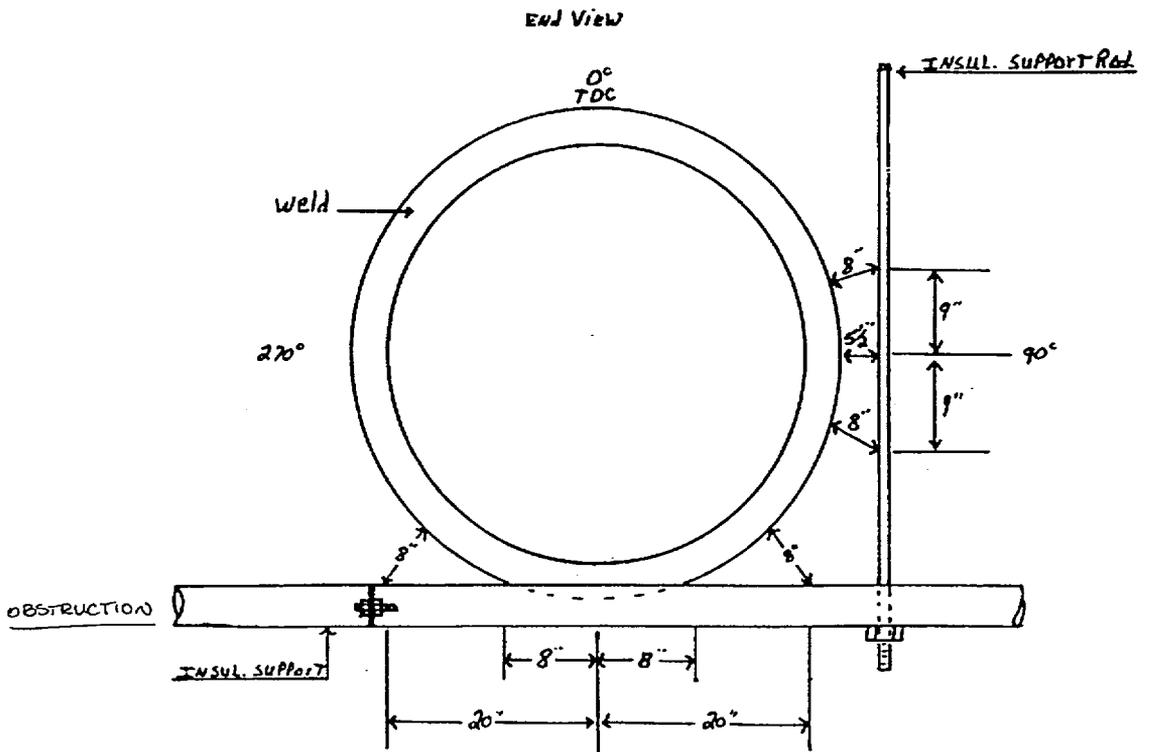
Note that the subject weld was identified in the first interval request for (IR-7) as component number 03-003-SW-R. This weld is currently located in Zone 053 of the ISI Program Manual identified as 03-053-SW-R.

**Proposed Alternative Examination**

- A. The subject weld will receive a volumetric and surface examination on the accessible areas in accordance with ASME Section XI (IWC-2500-1).
- B. NNECO will perform visual examination during system leakage tests as required by Section XI and Code Case N-498-1.

CAL. DATA SH. NO. MP3-CAL-052  
 PAGE 2 OF 4  
 WELL NO. D3-053-SW-R  
 ZONE 53  
 CODE CAT. C-B  
 DATA SH. MP3-CT-126

- \* 0° OBSTRUCTED FOR 20" TOTAL @ Bottom Dead Center.
- \* 45° OBSTRUCTED FOR 32" TOTAL @ Bottom Dead Center.
- \* 60° OBSTRUCTED FOR 40" TOTAL @ Bottom Dead Center.



\* NOTE: OBSTRUCTION DRAWING  
 OBTAINED FROM PREVIOUS  
 DATA. APR 5-16-79  
 SCALE-NONE

BDC 180°  
 No SCAN 8" ea. Side of Bottom Dead Center (180°)  
 Limited SCAN 8" to 20" ea. Side of B.D.C. (180°)

TECH. Robert S. Bell  
 DATE 5-16-99

R. Muller L-III 5/24/99

Attachment 2

Millstone Nuclear Power Station, Unit No. 3

Relief From Inservice Inspection Requirements (IR-2-14)  
Second Inspection Interval - Pressure Retaining Welds in Pressure Vessels.

Attachment 2

Relief From Inservice Inspection Requirements

**Relief Request**

IR-2-14

Second Inspection Interval - Pressure Retaining Welds in Pressure Vessels.

**Component Identification**

Code Class: 2

Examination Category: C-A

Item Number: C1.10 - Shell-to-Flange Weld

Component Identification Number: 03-074-004  
(B RHR Heat Exchanger Shell-to-Flange)

**Code Requirements**

A volumetric examination of essentially 100 percent of the weld length shall be conducted in accordance with the 1989 Edition of the ASME Boiler and Pressure Code, Table IWC-2500-1 and as clarified in Code Case N-460.

**Code Relief Request**

Pursuant to 10 CFR 50.55a(g)(5)(iii) relief is requested from performing the volumetric examination on the inaccessible portions of the subject vessel weld to the extent required by code.

**Basis for Relief**

Geometric configuration and permanent obstructions limit the volumetric examination of the subject weld. The obstruction consists of permanently welded pipe-to-vessel reinforcing plates which limit the ultrasonic examination to approximately 58 percent (%) of the required weld length as shown on the attached sketch. Based on these permanent obstructions relief is requested on complying with the 100 percent required examination coverage of this weld.

The limitations described above were included in a request for relief (IR-14) during the First Inspection Interval, with relief granted by (NRC) letter dated February 8, 1991.

**Proposed Alternative Examination**

- A. The subject weld will receive a volumetric examination on the accessible areas in accordance with ASME Section XI , Table IWC-2500-1.
- B. The inaccessible area of the subject weld is accessible for a surface examination and will receive a liquid penetrant examination in accordance with Section XI, Table IWC-2500-1
- C. NNECO will perform visual examination during system leakage tests as required by Section XI and Code Case N-498-1.

