

January 19, 2001
NG-01-0072

Office of Nuclear Reactor Regulation
U. S. Nuclear Regulatory Commission
Attn: Document Control Desk
Mail Station 0-P1-17
Washington, DC 20555-0001

Subject: Duane Arnold Energy Center
Docket No: 50-331
Op. License No: DPR-49
Additional Information Regarding Inservice
Inspection Relief Request NDE-R028, Revision 1

References: 1. Letter dated February 7, 2000, NG-00-0111, from K. Peveler
(IES Utilities Inc.) to NRC, Relief Requests NDE-R028, Revision 1
and MC-R008; RRF-F002 Flaw Evaluation
2. Letter dated October 18, 1999, from NRC to E. Protsch
(IES Utilities Inc.), Safety Evaluation of Third 10-Year Interval
Inservice Inspection Program Plan Requests for Relief for
Duane Arnold Energy Center

File: A-100, A-286

Reference 1 requested approval of Duane Arnold Energy Center (DAEC) Inservice Inspection Program Relief Request NDE-R028, Revision 1. NDE-R028 was approved by the NRC by letter dated October 18, 1999 (Reference 2). Revision 1 modified NDE-R028 to incorporate additional nozzle-to-vessel welds which were examined during refueling outage (RFO) 16 and for which 100% coverage could not be obtained.

On January 11, 2001, a teleconference was held between the NRC Staff and Nuclear Management Company, LLC (NMC) personnel to discuss NDE-R028, Revision 1. The Staff requested additional information as to which welds involve reactor pressure vessel (RPV) appurtenances which obstruct full examination coverage. The Staff also requested diagrams showing nozzle curvature which inhibits examination coverage. This information is provided on the attached examination summary sheets and nozzle diagrams. As shown on the summary sheets, examination coverages of the welds examined during RFO 16 were limited due to nozzle configurations; examination coverage of weld RCB-D001 was also limited due to insulation support bracket interference.

A047

January 19, 2001

NG-01-0072

Page 2

Should you have any questions regarding this matter, please contact this office.

Sincerely,



Kenneth E. Peveler
Manager, Regulatory Performance

Attachment

cc: G. Park (w/a) 
C. Rushworth (w/a)
M. Wadley (w/o)
G. VanMiddlesworth (w/o)
B. Mozafari (NRC-NRR) (w/a)
J. Dyer (Region III) (w/a)
NRC Resident Office (w/a)
Docu (w/a)

**Attachment to NG-01-0072
(13 Pages)**



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.: 199010

Site and Unit: Duane Arnold

Component ID: CSA-D001

Outage: RF016

REACTOR VESSEL - NOZZLE

ASME Cat.: B-D ASME Item B3.90 Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-052	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99
45° Shear	99DM-053	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99
60° Shear	99DM-054	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99

Examination Results:

During the manual ultrasonic examination of CSA-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

63% of the Code required volume was examined.

Examination results were compared to data report 88-143,144,145 from 1988 outage with No Change
 These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

Reviewed By: [Signature] Level: III Date: 11/4/99 Reviewed By: [Signature] Title: NA Date: _____

Reviewed By: [Signature] Level: III Date: 11/7/99 Reviewed By: [Signature] Title: AWII Date: 11/8/99

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.: 199112

Site and Unit: Duane Arnold

Component ID: MSB-D001

Outage: RF016

REACTOR VESSEL - NOZZLE

ASME Cat.: B-D ASME Item B3.90 Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-046	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99
45° Shear	99DM-047	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99
60° Shear	99DM-048	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99

Examination Results:

During the manual ultrasonic examination of MSB-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

63% of the Code required volume was examined.

Examination results were compared to data report 91-132A,B,C from 1991 outage with No Change
 These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

<u>John Shea</u>	<u>II</u>	<u>11/4/99</u>	<u>N/A</u>		
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:
<u>Frank Rooney</u>	<u>III</u>	<u>11/7/99</u>	<u>[Signature]</u>	<u>ANIE</u>	<u>11/8/99</u>
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.: 199114

Site and Unit: Duane Arnold

Component ID: RCA-D001

Outage: RF016

REACTOR VESSEL - NOZZLE

ASME Cat.: B-D ASME Item B3.90 Aug Requirements:

Exams Performed Data Sheet Cal Sheet Procedure Calibration Block Examination Personnel Cert Level Date

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-067	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/3/99
45° Shear	99DM-068	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/3/99
60° Shear	99DM-069	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/3/99

Examination Results:

During the manual ultrasonic examination of RCA-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

59% of the Code required volume was examined.

Examination results were compared to data report R-127 from 1990 outage with [checked] No Change
These examinations were performed under Work Order: N/A [unchecked] Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

Reviewed By: [Signature] Level: III Date: 11/4/99 Reviewed By: [Signature] Title: N/A Date:
Reviewed By: [Signature] Level: III Date: 11/7/99 Reviewed By: [Signature] Title: ASME Date: 11/8/99

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.: 199042

Site and Unit: Duane Arnold

Component ID: RCB-D001

Outage: RF016

REACTOR VESSEL - NOZZLE

ASME Cat.: B-D ASME Item B3.90 Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
45° Shear	99DM-020	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	10/28/99
0° Long.	99DM-021	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	10/28/99
60° Shear	99DM-022	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	10/28/99

Examination Results:

During the manual ultrasonic examination of RCB-D001 no recordable indications were detected by the 0° longitudinal wave and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to nozzle configuration. The examination was limited due to insulation support bracket interference.

57% of the Code required volume was examined.

Examination results were compared to data report 88-266 from 1988 outage with No Change

These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

Reviewed By: <u>[Signature]</u>	Level: <u>III</u>	Date: <u>11/3/99</u>	Reviewed By: <u>[Signature]</u>	Title: <u>N/A</u>	Date: _____
Reviewed By: <u>[Signature]</u>	Level: <u>III</u>	Date: <u>11/7/99</u>	Reviewed By: <u>[Signature]</u>	Title: <u>A.I.S.S.</u>	Date: <u>11/16/99</u>

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.: 199046

Site and Unit: Duane Arnold

Component ID: RRA-D001

Outage: RF016

REACTOR VESSEL - NOZZLE

ASME Cat.: B-D ASME Item B3.90 Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-070	N/A	UT-DAC-300V0 Rev. 0	IE-30	Bob Paszkowski	III	11/4/99
45° Shear	99DM-071	N/A	UT-DAC-300V0 Rev. 0	IE-30	Bob Paszkowski	III	11/4/99
60° Shear	99DM-072	N/A	UT-DAC-300V0 Rev. 0	IE-30	Bob Paszkowski	III	11/4/99

Examination Results:

During the manual ultrasonic examination of RRA-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

63% of the Code required volume was examined.

Examination results were compared to data report 88-821 from 1988 outage with No Change
These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

<u>[Signature]</u>	<u>III</u>	<u>11/12/99</u>	<u>NA</u>	_____	_____
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:
<u>[Signature]</u>	<u>III</u>	<u>11/12/99</u>	<u>[Signature]</u>	<u>ANEE</u>	<u>11/12/99</u>
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.: 199048

Site and Unit: Duane Arnold

Component ID: RRB-D001

Outage: RF016

REACTOR VESSEL - NOZZLE

ASME Cat.: B-D

ASME Item

B3.90

Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-101	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/6/99
45° Shear	99DM-102	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/6/99
60° Shear	99DM-103	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/6/99

Examination Results:

During the manual ultrasonic examination of RRB-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

63% of the Code required volume was examined.

Examination results were compared to data report 88-289 from 1988 outage with No Change

These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

<u>[Signature]</u>	<u>II</u>	<u>11/12/99</u>	<u>UA</u>	Reviewed By:	Title:	Date:
<u>[Signature]</u>	<u>III</u>	<u>11/12/99</u>	<u>[Signature]</u>	Reviewed By:	<u>ANET</u>	<u>11/15/99</u>
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:	

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.:
199050

Site and Unit: **Duane Arnold**

Component ID: **RRC-D001**

Outage: **RF016**

REACTOR VESSEL - NOZZLE

ASME Cat.: **B-D** ASME Item **B3.90** Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-073	N/A	UT-DAC-300V0 Rev. 0	IE-30	Bob Paszkowski	III	11/4/99
45° Shear	99DM-074	N/A	UT-DAC-300V0 Rev. 0	IE-30	Bob Paszkowski	III	11/4/99
60° Shear	99DM-075	N/A	UT-DAC-300V0 Rev. 0	IE-30	Bob Paszkowski	III	11/4/99

Examination Results:

During the manual ultrasonic examination of RRC-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

63% of the Code required volume was examined.

Examination results were compared to data report 87-409 from 1987 outage with No Change

These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

	III	11/14/99			
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:
	III	11/14/99		ANEL	11/15/99
Reviewed By:	Level:	Date:	Reviewed By:	Title:	Date:

RWP: _____
Dose: _____ mr.



GE NUCLEAR ENERGY

EXAMINATION SUMMARY SHEET

Report No.:
199117

Site and Unit: **Duane Arnold**

Component ID: **VID-D001**

Outage: **RF016**

REACTOR VESSEL - NOZZLE

ASME Cat: **B-D** ASME Item **B3.90** Aug Requirements:

Exams Performed	Data Sheet	Cal Sheet	Procedure	Calibration Block	Examination Personnel	Cert Level	Date
0° Long.	99DM-049	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99
45° Shear	99DM-050	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99
60° Shear	99DM-051	N/A	UT-DAC-300V0 Rev. 0	IE-30	John Shea	II	11/2/99

Examination Results:

During the manual ultrasonic examination of VID-D001 no recordable indications were detected by the 0° longitudinal and 45° and 60° shear wave search units.

The examination was performed from the RPV shell side only due to the nozzle configuration.

63% of the Code required volume was examined.

Examination results were compared to data report R-129 from 1990 outage with No Change

These examinations were performed under Work Order: N/A Change

This Summary and the following data sheets have been reviewed and accepted by the following personnel:

RWP: _____
Dose: _____ mr.

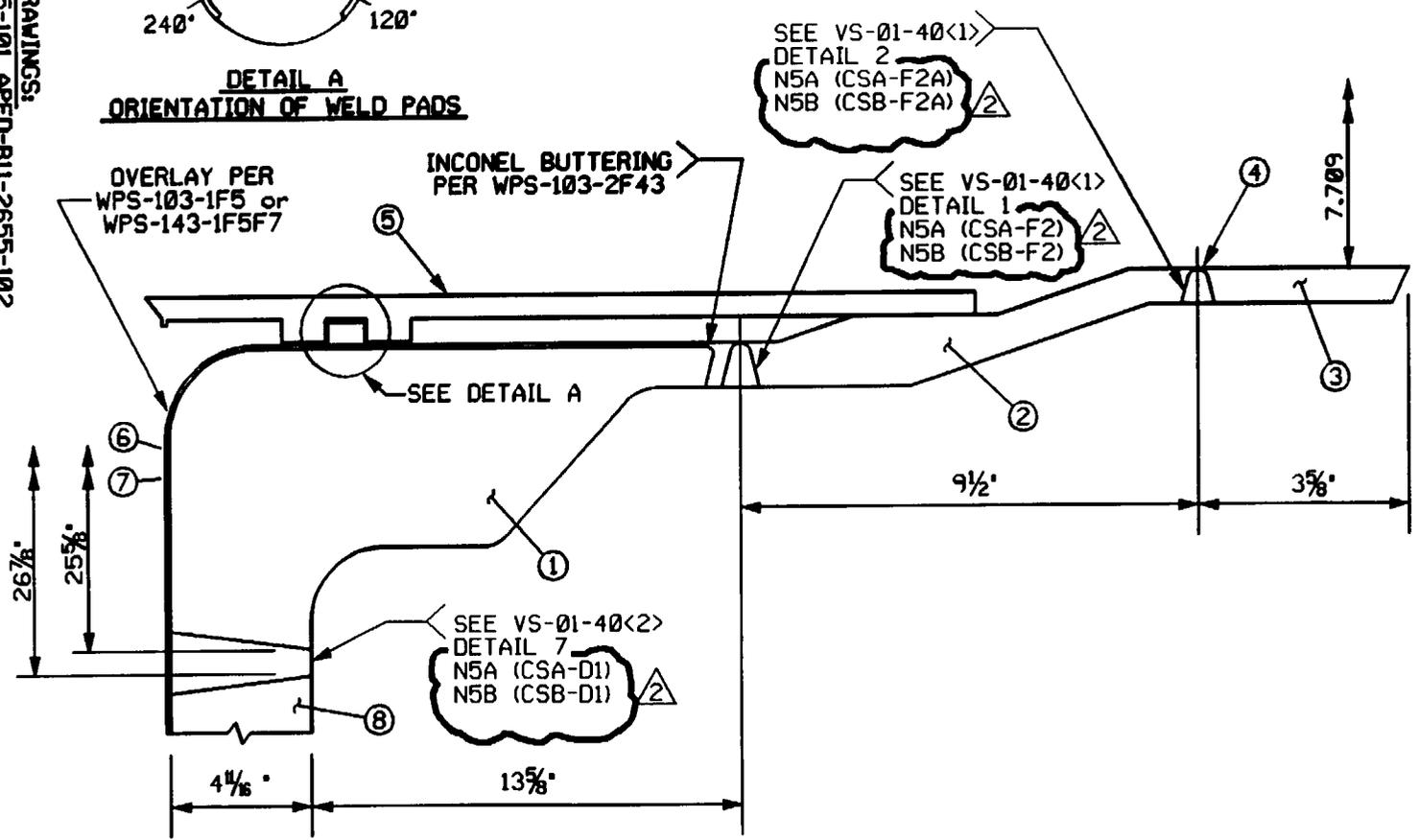
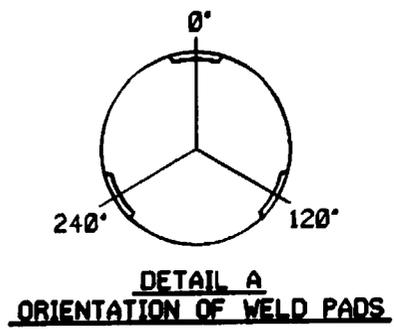
Reviewed By: <u><i>DW Healy</i></u>	Level: <u>II</u>	Date: <u>11/4/99</u>	Reviewed By: <u><i>NA</i></u>	Title: _____	Date: _____
Reviewed By: <u><i>Paul ...</i></u>	Level: <u>III</u>	Date: <u>11/2/99</u>	Reviewed By: <u><i>[Signature]</i></u>	Title: <u>ANCI</u>	Date: <u>11/2/99</u>

2	8/8/95	REVISED PER DURF-0011	DA	GD	SS	SS
1	2-09-94	DRAFTED FOR VESSEL INSPECTION PROGRAM	MS	DF	GP	SS
NO.	DATE	REVISION	DRAWN	CHECKD.	ENGR.	VER.

NO.	DESCRIPTION	BILL OF MATL.	PROCED.
1	FORGING	SA508 CLASS 2	
2	SAFE END FORGING	SB-166	
3	SAFE END EXT. FORGING	SA338 CLASS F8	
4	INSERT	INCONEL 02	
5	THERMAL SLEEVE	SA336 CLASS F8	
6	1ST CLAD LAYER	309L	
7	2ND & 3RD CLAD LAYER	308L	
8	SHELL PLATE #3	SA533 CLASS 1 GR.B	

IES:
Inservice Inspection Program
Reactor Pressure Vessel Sketch

REFERENCE DRAWINGS:
APED-B11-2655-101, APED-B11-2655-102



DWG. NO. VS-01-14
CORE SPRAY NOZZLE
MK N5A/B

REV. 2

NO.	DESCRIPTION	BILL OF MATL.	PROCED.
1	FORGING	SA508 CLASS 2	
2	SAFE END FORGING	SA508 CLASS 1	
3	1ST CLAD LAYER	309	
4	2ND & 3RD CLAD LAYER	308L	
5	SHELL PLATE #4	SA533 CLASS 1 GR.B	

DA	GD	SS	SS
MS	DF	CP	SS
DR	TR	CHKD.	EMR.
VER.			

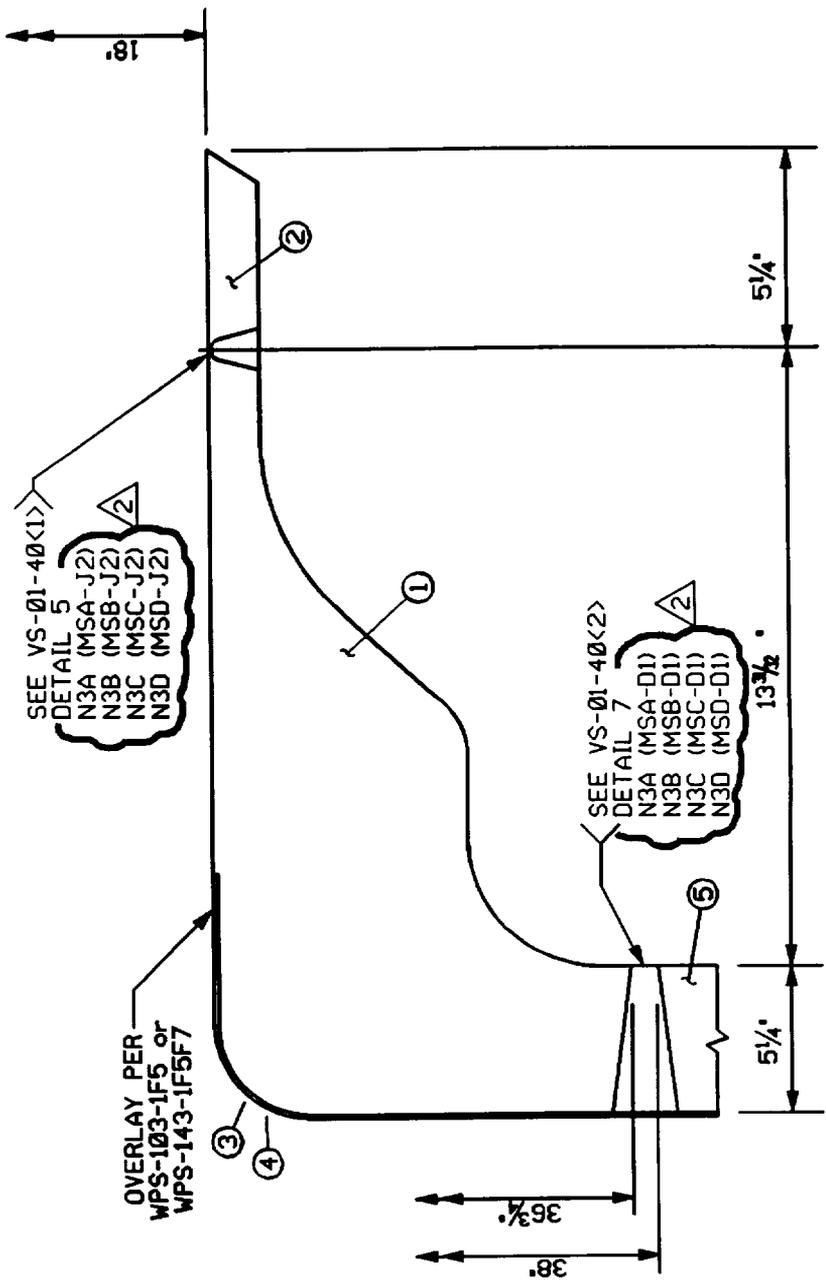
REVISION PER DURF-0011
 DRAFTED FOR VESSEL INSPECTION PROGRAM
 WPS-103-1F5 or WPS-143-1F5F7
 REVISION

NO. DATE

REFERENCE DRAWING:
 APED-B11-2655-098

IES:
 Inservice Inspection Program
 Reactor Pressure Vessel Sketch

STEAM OUTLET
 NOZZLE MK N3A/D
 DWG. NO. VS-01-12
 REV. 2



2	8/8/95	REVISED PER DURF-0011	DA	GD	SS	SS
1	12-08-94	DRAFTED FOR VESSEL INSPECTION PROGRAM	MS	DF	GP	SS
NO.	DATE	REVISION	DWR	CHKD.	ENGR.	VER.

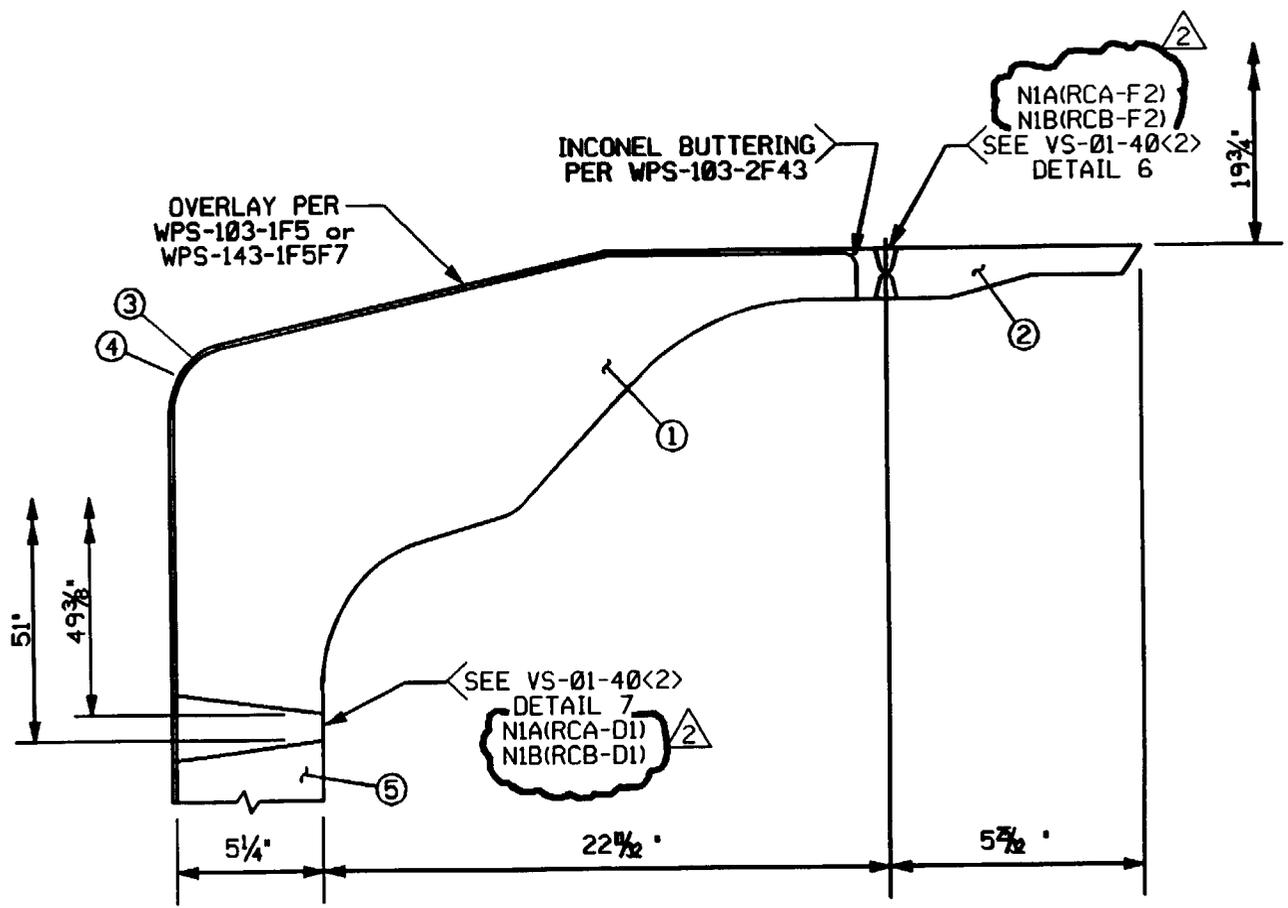
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2	SAFE END FORGING	SA336 CLASS F8	
3	1ST CLAD LAYER	309L	
4	2ND & 3RD CLAD LAYER	308L	
5	SHELL PLATE #1	SA533 CLASS 1 GR.B	

IES:
Inservice Inspection Program
Reactor Pressure Vessel Sketch

REFERENCE DRAWING:
APED-811-2655-095

DWG. NO. VS-01-10
RECIRCULATION OUTLET
NOZZLE MK N1A/B

REV. 2



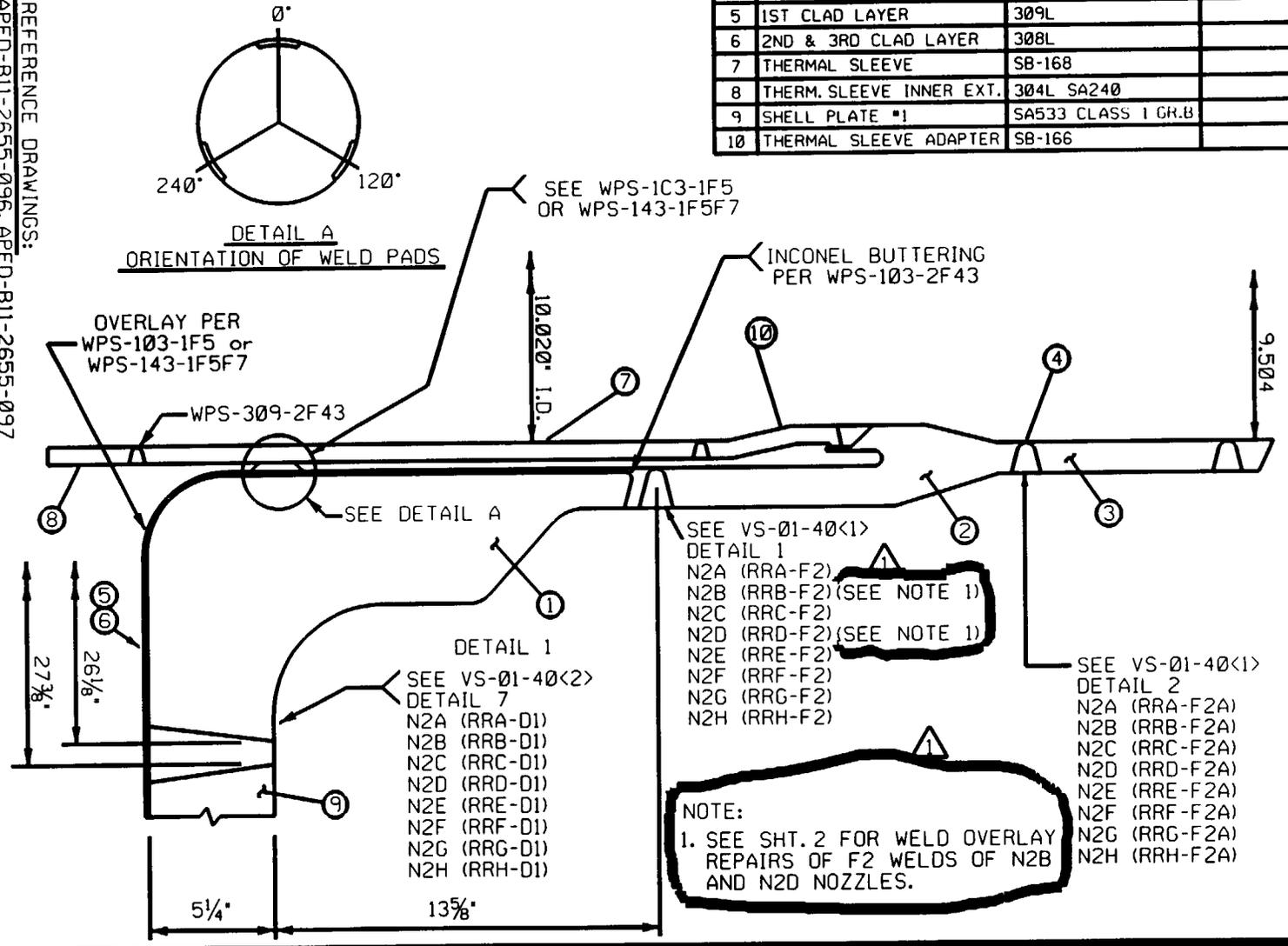
NO.	DATE	REVISION	DRFTR	CHK'D	ENGR	VER.
1	12/17/99	ISSUED PER DURF-U0133 FOR ECP-1627	JW	TAK	LAL	CEZ

NO.	DESCRIPTION	BILL OF MATL.	PROCED.
1	FORGING	SA508 CLASS 2	
2	SAFE END FORGING	SB-166	
3	SAFE END EXT. FORGING	SA336 CLASS F8 S.S.	
4	CONSUMABLE INSERT	INCONEL 82	
5	1ST CLAD LAYER	309L	
6	2ND & 3RD CLAD LAYER	308L	
7	THERMAL SLEEVE	SB-168	
8	THERM. SLEEVE INNER EXT.	304L SA240	
9	SHELL PLATE *1	SA533 CLASS 1 GR.B	
10	THERMAL SLEEVE ADAPTER	SB-166	

IES:
Inservice Inspection Program
Reactor Pressure Vessel Sketch

DWG. NO. VS-01-11<01>
RECIRCULATION INLET
NOZZLE MK N2A/H
REV. 1

REFERENCE DRAWINGS:
APED-B11-2655-096, APED-B11-2655-097



- SEE VS-01-40<1>
DETAIL 1
N2A (RRA-F2)
N2B (RRB-F2) (SEE NOTE 1)
N2C (RRC-F2)
N2D (RRD-F2) (SEE NOTE 1)
N2E (RRE-F2)
N2F (RRF-F2)
N2G (RRG-F2)
N2H (RRH-F2)

- SEE VS-01-40<1>
DETAIL 2
N2A (RRA-F2A)
N2B (RRB-F2A)
N2C (RRC-F2A)
N2D (RRD-F2A)
N2E (RRE-F2A)
N2F (RRF-F2A)
N2G (RRG-F2A)
N2H (RRH-F2A)

NOTE:
1. SEE SHT. 2 FOR WELD OVERLAY REPAIRS OF F2 WELDS OF N2B AND N2D NOZZLES.

2	8/8/95	REVISED PER DURF-0011	DA	GD	SS	SS
1	12-09-94	DRAFTED FOR VESSEL INSPECTION PROGRAM	MS	DF	GP	SS
NO.	DATE	REVISION	DRFTR.	CHKD.	ENGR.	VER.

NO.	DESCRIPTION	BILL OF MATL.	PROCED.
1	FORGING	SA508 CLASS 2	
2	SAFE END FORGING	SA336 CLASS F8	
3	INSERT	INCONEL 82	
4	1ST CLAD LAYER	309	
5	2ND & 3RD CLAD LAYER	308L	
6	SHELL PLATE #4	SA533 CLASS 1 GR.8	

IES:
Inservice Inspection Program
Reactor Pressure Vessel Sketch

REFERENCE DRAWING:
APED-811-2655-110

DWG. NO. VS-01-21
INSTRUMENTATION
NOZZLE MK N12A/B
REV. 2

