

Ref. #10CFR50.55a(g)(5)(iii)

TXU Electric Comanche Peak Steam Electric Station

P.O. Box 1002 Glen Rose, TX 76043 Tel: 254 897 8920 Fax: 254 897 6652 Iterry1@txu.com C. Lance Terry

Senior Vice President & Principal Nuclear Officer

CPSES-200100347 Log # TXX-01024 File # 10010.1 905.2 (clo)

February 2, 2001

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

SUBJECT: COMANCHE PEAK STEAM ELECTRIC STATION (CPSES) - UNIT 2

**DOCKET NO. 50-446** 

RELIEF REQUESTS FOR UNIT 2 INSERVICE INSPECTION

**PROGRAM** 

(1986 EDITION OF ASME CODE, SECTION XI, NO ADDENDA; UNIT 2 INTERVAL DATES: AUGUST 3, 1993 - AUGUST 3, 2003,

FIRST INTERVAL)

REF: 1) TXU Electric Letter, logged TXX-95042, from Mr. C. L. Terry To the NRC dated March 6, 1995

2) TXU Electric Letter, logged TXX-98058 from Mr. C. L. Terry To the NRC dated March 5, 1998

This transmittal submits relief requests B-1 Revision 1, B-5 Revision 1 and C-5 (Attachments 1 through 3 respectively) for your approval.

Relief request B-1 Revision 0, was submitted by TXU Electric via Reference 1 and was approved via NRC letter NRR-9156 dated December 28, 1995. Relief request B-5 Revision 0, was submitted by TXU Electric via Reference 2 and was approved via NRC letter NRR-9731 dated February 3, 1999.

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TXU Electric P.O. Box 1002 Glen Rose, TX 76043

TXX-01024 Page 2 of 2

There are no new licensing based commitments in the communication. Should you have additional questions, please contact Obaid Bhatty at 254-897-5839.

Sincerely,

C. L. Terry

D. R. Woodlan

Docket Licensing Manager

OAB/oab

Attachments

cc: E. W. Merschoff, Region IV

J. I. Tapia, Region IV

D. H. Jaffe, NRR

Resident Inspectors, CPSES

G. Bynog, TDLR

## CPSES UNIT 2 RELIEF REQUEST B-1 REVISION 1

A. Item for which relief is requested:

TCX-1-1300-1 TCX-1-1300-2 Reactor Vessel Closure Head Head to Flange and Ring to Disc Welds

B. Item Code Class:

1

C. Examination requirement from which relief is requested:

The requirement for volumetric examination of 100% of the weld lengths as described in Table IWB-2500-1. Examination Category B-A, Item Nos. B1.40 and B1.21.

D. Basis for relief:

Interferences from the reactor head flange, shroud and lifting lugs preclude the complete ultrasonic examination of the volume required by Figures IWB-2500-3 and IWB-2500-5 as applicable.

Approximately 15% of the examination volume of weld TCX-1-1300-1 and 17% of the examination volume of weld TCX-1-1300-2 did not receive the full code required coverage during the first period examinations.

Approximately 15% of the examination volume of weld TCX-1-1300-1 and 17% of the examination volume of weld TCX-1-1300-2 did not receive the full code required coverage during the second period examinations.

Best effort examinations were performed. Full circumferential scan coverage was obtained for both welds. Axial scan coverage was achieved in one beam path direction with two different beam angles for 99% of the examination volume of TCX-1-1300-1 and for 97% of the examination volume of TCX-1-1300-2.

See pages 3 through 9 for weld locations and surface configurations.

Attachment 1 to TXX-01024 Page 2 of 10

# CPSES UNIT 2 RELIEF REQUEST B-1 REVISION 1 (continued)

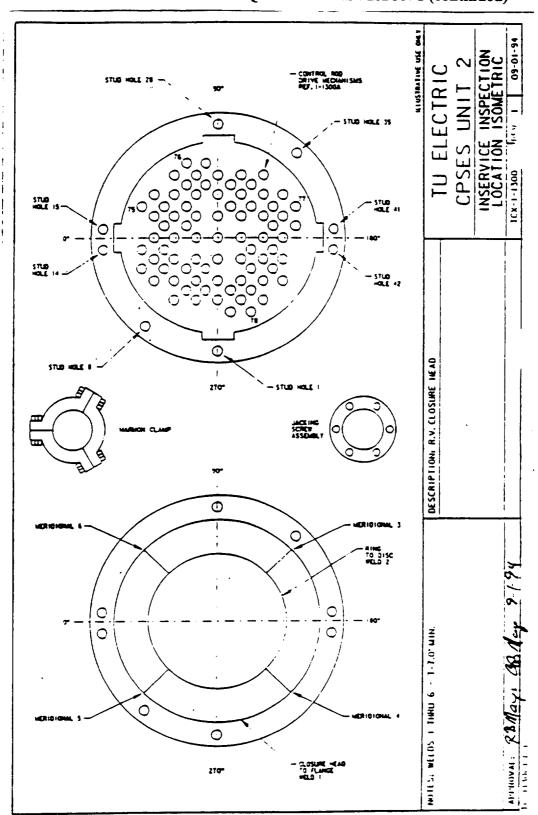
There were no recordable indications identified by the best effort volumetric examination or by the required surface examination performed on TCX-1-1300-1.

	of by the required surface examination performed on TCX-1-1500-1.
E.	Alternate examinations:
	None

F. Anticipated impact on the overall level of plant quality and safety:

None

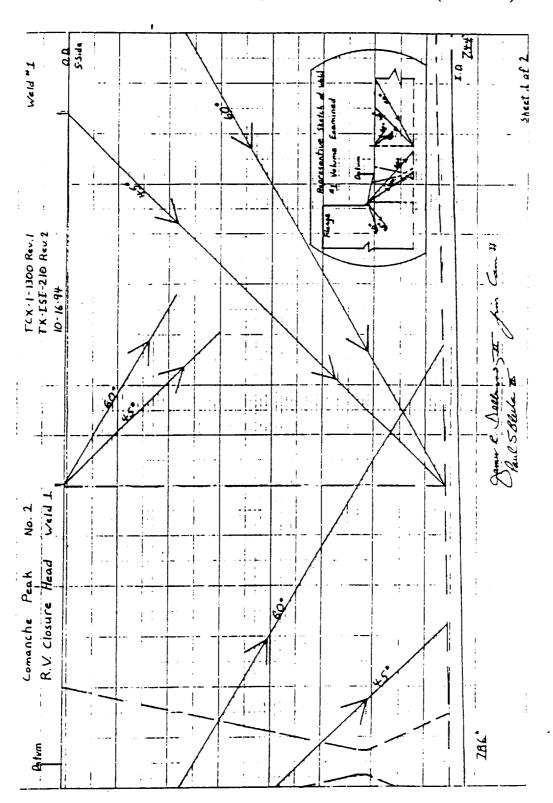
CPSES UNIT 2 - RELIEF REQUEST B-1 REVISION 1 (continued)



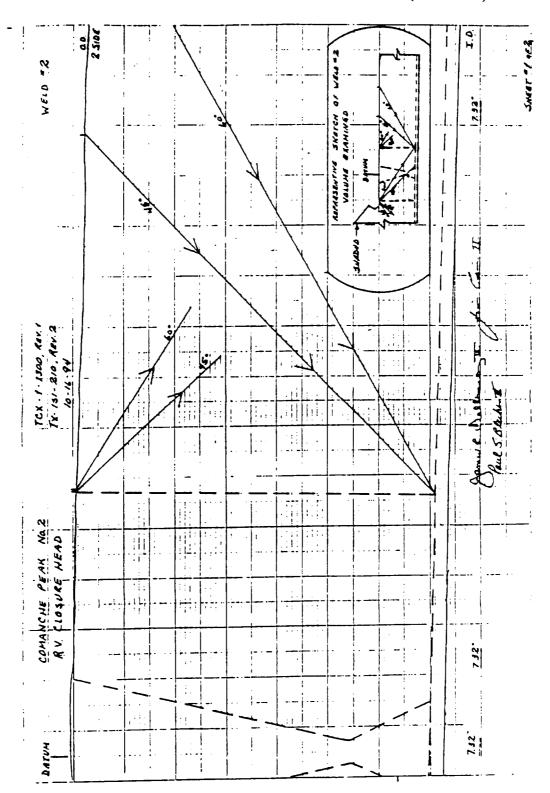
### CPSES UNIT 2 - RELIEF REQUEST B-1 REVISION 1 (continued)

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			SPECTION S			
		LIMIT	ATION TO E	CAMINATION		
PLANT	COMANCHE PEAK		UNIT_ <u>N</u>	<u>ю. 2 </u> SKETCH <u>т</u>	CX-1-1300 REV.	1
SYST.	COMP. R. V. CLOSU	OASH 3P		PROCEDURE _T	X-ISH210 REV. 2	
EXAM	INEFLORE & ALLO	my Peul St	Welet for	DATE 1	0-18-94	
	$\overline{}$			ANII Re	viewed fet	10/31/44
RELATED	ото: ut <u>X</u>	PT	MT	vt	DEIT. NO	1,2&6
PROVIDE	GENERAL REPORTATION TO	DESCRIE APPROXIM	LATE SEEL, LOCATION	AND TYPE OF LINETAT	ION.	
WELD	<b>3 #</b> 1 .					
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WELD	) <b>#</b> 2					
	17% OF REQUIRED EX 97% EXAMINED WITH 45'-11% NOT EXAM 60'-17% NOT EXAM	H THE 45° AND (		_		
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CPSES UNIT 2 - RELIEF REQUEST B-1 REVISION 1 (continued)



**CPSES UNIT 2 - RELIEF REQUEST B-1 REVISION 1 (continued)** 



#### CPSES UNIT 2 - RELIEF REQUEST B-1 REVISION 1 (continued) REPORT NO. UT-00-028 WESTINGHOUSE NUCLEAR SERVICES DIVISION PAGE LIMITATION TO EXAMINATION Comanche Peak UNIT SKETCH TCX-1-1300 SYST/COMP REACTOR COOLANT PROCEDURE TX-ISI-210 Rev. 4 FC N/A **EXAMINER** LEVEL II DATE 10/8/2000 **EXAMINER** LEVEL N/A DATE COMPONENT ID TCX-1-1300-1 TCX-1-1300-2 **RELATED TO** PROVIDE SUFFICIENT INFORMATION TO DESCRIBE SIZE, LOCATION AND TYPE OF LIMITATION. COMMENTS/SKETCH/DETAILS TCX-1-1300-1: 15% of required volume not examined. 99% examined with 45° and 60° in at least one direction. 8% of required volume not examined with 45° and 15% of required volume not examined with 60°. TCX-1-1300-2: 17% of required volume not examined. 97% examined with 45° and 60° in at least one direction. 11% of required volume not examined with 45° and 17% of required volume not examined with 60°. SEE WELD PROFILE SHEETS. F & OLIGH 30 3 SHROUD

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## WESTINGHOUSE NUCLEAR SERVICES DIVISION INSPECTION SERVICES

REPORT NO. **BS-00003**PAGE 1 OF 1

#### BEAM SPREAD

	7		O.	ANIO NEAD				
PLANT	Comanche Peak		· · · · · · · · · · · · · · · · · · ·	UNIT 2	SKETCH	N/A		-
SYST/COMP	RC				PROCEDURE	TX-ISI-210	Rev. 4	FC N/A
EXAMINER	Erickson, Scott	Scott R. Ex	eichon	LEVEL II	DATE		10/8/2000	FC N/A
EXAMINER	N/A			LEVEL N/A	DATE			
TRANSDUCE	R S/N	009Y45	ANGLE	45°	CAL. BLOCK		TBX-29	
	SIZE	.5"x1"	FREQUENCY	2.25 MHz	THICKNESS		8.6	
COMMENTS/S	KETCH/DETAILS			IMAGE R	EDUCED 7.			
TU ELECTRIC RE	VIEW/DATE	10-9-00	TU ELECTRIC LEVEL III REV	~ 10/13/00	ANII REVIEW/D.		10/13/14	<i>f</i>

CPSES UNIT 2 -

RELIEF REQUEST B-1 REVISION 1 (continued)

			WESTINGHOUSE N INSPE	NUCLEAR SERVICES		ON .		REPORT NO.	BS-00004
			В	EAM SPREAD				PAGE 1	OF1
PLANT	Comanche Peal			UNIT	22	SKETCH	N/A		
SYST/COMP	RC					PROCEDURE	TX-ISI-210	) Re	v. 4 FC N/A
EXAMINER	Erickson, Scott	Scott R.	Exection	LEVEL _		DATE		10/8/2000	
EXAMINER	N/A			LEVEL _	N/A	DATE			
TRANSDUCE	R S/N	009Y81	ANGLE	60°	<u>_</u>	CAL. BLOCK	-	TBX-29	
	SIZE	.5"x1"	FREQUENCY	2.25 MHz	<del></del>	THICKNESS		8.6	
COMMENTS/SI	KETCH/DETAILS							··-	<del>-</del>

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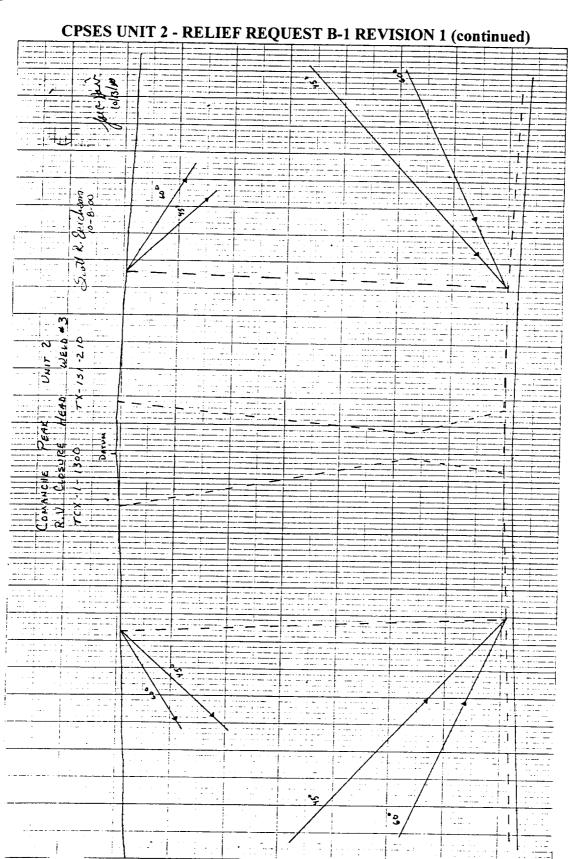
ANII REVIEW / DATE

J. Ragan 10/13/00

IMAGE REDUCED
50%

Joe C. Hair 10/13/41

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## CPSES UNIT 2 RELIEF REQUEST B-5 Revision 1

#### A. Item for which relief is requested:

TCX-1-3100-2-1, TCX-1-3100-1-1 Steam generator tubesheet-to-channel head welds

#### B. Item Code Class:

1

#### C. Examination requirement from which relief is requested:

The requirement for volumetric examination of 100% of the steam generator tubesheet-to-channel head weld as described in Table IWB-2500-1, Examination Category B-B, Item No. B2.40.

Note: The CPSES ISI Plan requires different steam generators to be examined during each inspection period. A relief request revision is processed to document the specific limitations encountered during the examination of each of the steam generators.

#### D. Basis for relief:

Interferences from the steam generator tubesheet flange (or support collar) configuration and from welded insulation support pads preclude the complete ultrasonic examination of the volume required by Fig. IWB-2500-6.

Approximately 31% of the examination volume of weld TCX-1-3100-2-1 did not receive the full code required coverage. See pages 2 through 5 for weld location and examination area configurations.

Approximately 31% of the examination volume of weld TCX-1-3100-1-1 did not receive the full code required examination coverage. Refer to pages 6 through 10 for weld location and examination area configurations.

Attachment 2 to TXX-01024 Page 2 of 11

# CPSES UNIT 2 RELIEF REQUEST B-5 Revision 1 (continued)

There were no recordable indications identified by the volumetric examination performed on the accessible portions of the weld.

F	Substitute examinations:			

F. Anticipated impact on the overall level of plant quality and safety:

None

None

CPSES UNIT 2 - RELIEF REQUEST B-5 Revision 1 (continued)

CISES UNIT 2 - RELIEF REQUEST B-5 REVISION 1 (	TU ELECTRIC  CPSES UNIT 2  INSERVICE INSPECTION LOCATION ISOMETRIC  ICX-1-3100   REV. 1   09-01-94
Since Parity 18500	DESCRIPTION, STEAM GENERATORS 1, 2, 3 & CTUBES 10E) 5.375A-50B (HE ADS 10E) 5.375A-516 (BOL THG) 1.875* DIA./16.11* LENGTH
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Silak Opciales Pila 	78May 1661
	NOTES: APPROVAL:

#### CPSES UNIT 2 - RELIEF REQUEST B-5 Revision 1 (continued)

WESTINGHOUSE NUCLEAR SERVICES DIVISION
LIMITATION TO EXAMINATION
PLANT COMANCHE PEAK UNIT 2 SKETCH TCX-1-3100 REV 1
SYST/COMP. STEAM GENERATOR 2 PROCEDURE TX-ISI-210 REV 4
EXAMINER MAN Allan Paul Stelle Roy Ani DATE 11-18-87
· · · · · · · · · · · · · · · · · · ·
RELATED TO: UT X PT MIT VT EDENT. NO. 2-1
PROVIDE GENERAL IMPORMATION TO DESCRIBE APPROXIMATE SIZE, LOCATION AND TYPE OF LIMITATION.
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SUPPORT COLLAR
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+ 342"   + 351"   + 128"   + 40.
+ 34" + 34" + 155" 1- 48"
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FOUR 24" X 24" SUPPORT PADS RESTRICTES ALL SCAN FOR 22% SEVENTEEN 2.5" X 2.5" WELDED PADS APPROXIMATELY 7" FROM THE CENTERLINE LIMITS 60" SCAN SUPPORT COLLAR LIMITS 60" SCAN

0" - 22% NOT EXAMINED

45" - 22% NOT EXAMINED

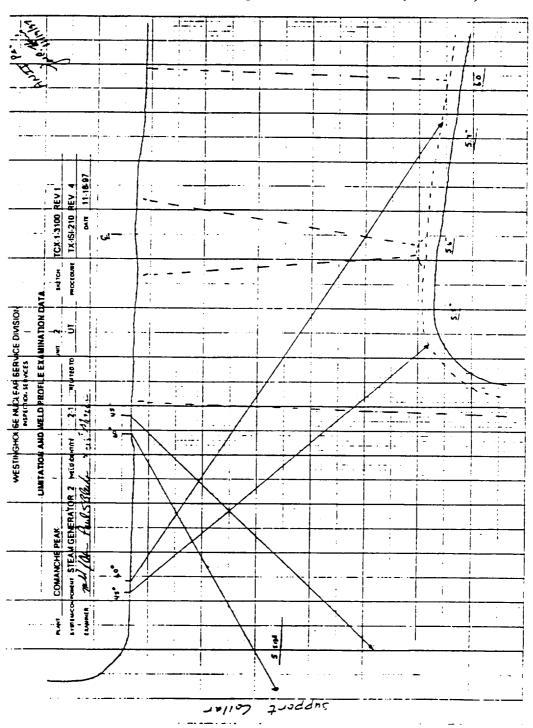
60" - 31% NOT EXAMINED

31% OF REQUIRED EXAMINATION VOLUME NOT EXAMINED

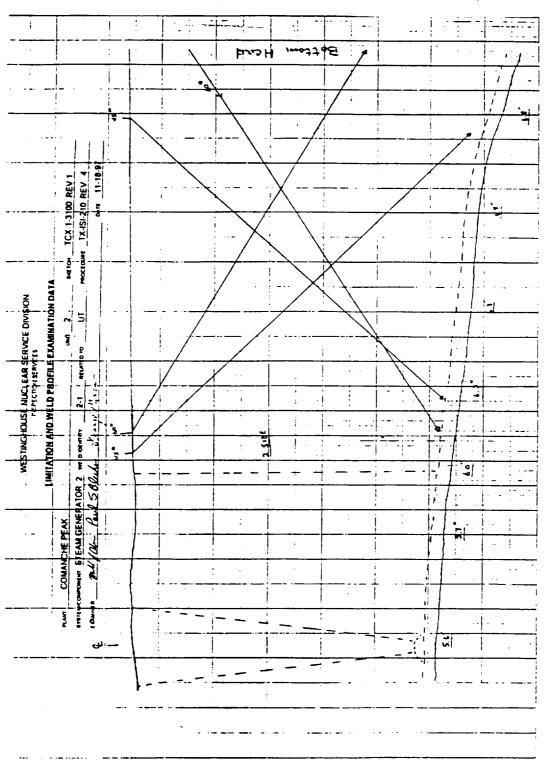
SEE LIMITATION AND WELD PROFILE EXAMINATION DATA SHEET

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CPSES UNIT 2 - RELIEF REQUEST B-5 Revision 1 (continued)



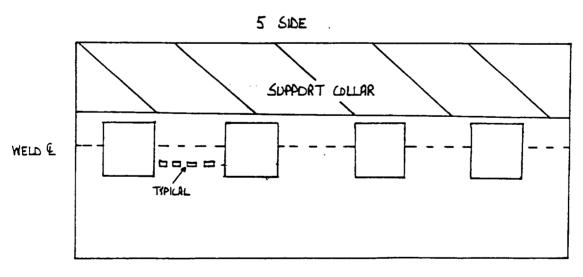
CPSES UNIT 2 - RELIEF REQUEST B-5 Revision 1 (continued)



#### CPSES UNIT 2 - RELIEF REQUEST B-5 Revision 1 (continued)

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PLANT	Comanche Peak		UNIT	_2	SKETCH	TCX-1-3100		
SYST/COMP	REACTOR COOLANT		_		PROCEDURE	TX-ISI-210	Rev. 4	FC N/A
EXAMINER	Mixon, W. Andrew	u c	LEVEL		DATE	10	0/5/2000	
EXAMINER	Holasek, Wade Vale	Hasek	LEVEL		DATE	10	0/5/2000	
COMPONENT	ID TCX-1-3100-1-1			****				
RELATED TO	· MT	PT	• UT		· <b>v</b> T			
PROVIDE SUF	FICIENT INFORMATION TO	DESCRIBE SIZE, LOCATION	ON AND TY	PE OF	LIMITATION.			
COMMENTS/S	KETCH/DETAILS							

Four 24"X 24" Support pads restricts all scan for 22%. Seventeen 2.5"X 2.5" welded pads approx. 7" from CL limits 60° scan. 0° -22% not examined. 45° -22% not examined. 31% of required exam volume not examined.



2 SIDE

TU ELECTRIC REVIEW / DATE	TU ELECTRIC LEVEL III REVIEW / DATE	ANII REVIEW / DATE
Paul & Granday 10-4-00	J. Ragan 10/12/00	las C. Hair 10/12/00

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## WESTINGHOUSE NUCLEAR SERVICES DIVISION INSPECTION SERVICES

REPORT NO. BS-00001 PAGE 1 OF 1

#### **BEAM SPREAD**

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LANT	Comanche Peak			UNIT _	2	SKETCH	N/A		
YST/COMP	N/A			_		PROCEDURE		Pay 4	EC N/4
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EXAMINER		7) A	CEIVON	LEVEL _		DATE		10/4/2000	
	Musgrave, Larry		grave	LEVEL _		DATE		10/4/2000	
TRANSDUCE		009Y81	ANGLE	60°	<del></del>	CAL. BLOCK		TBX-28	
	SIZE	.5"x1"	FREQUENCY	2.25 MHz		THICKNESS		5.45	
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Joe C. Hair 10/13/09

**CPSES UNIT 2 -**

**RELIEF REQUEST B-5 Revision 1 (continued)** 

## WESTINGHOUSE NUCLEAR SERVICES DIVISION INSPECTION SERVICES

 REPORT NO.
 BS-00002

 PAGE
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 OF
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#### **BEAM SPREAD**

PLANT	Comanche Peak	***		UNIT	2	SKETCH	N/A		
SYST/COMP	N/A					PROCEDURE	TX-ISI-210	Rev. 4	FC N/A
EXAMINER	Erickson, Scott	. //	Erichoon	LEVEL _	!!			10/4/2000	- <u></u>
EXAMINER	Musgrave, Larry	Larry M. Musqu	ave	LEVEL	11	DATE		10/4/2000	
TRANSDUCE	R S/N	009Y45	ANGLE	45*		CAL. BLOCK		TBX-28	<del></del>
	SIZE	.5"x1"	FREQUENCY	2.25 MHz		THICKNESS		5.45	
COMMENTS/SI	KETCH/DETAILS								
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CPSES UNIT 2 - RELIEF REQUEST B-5 Revision 1 (continued)

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## CPSES UNIT 2 RELIEF REQUEST C-5

#### A. Item for which relief is requested:

TCX-2-2577-12 pipe to valve TCX-2-2577-20 pipe to valve TCX-2-2578-35 pipe to nozzle

#### B. Item(s) Code Class:

2

#### C. Examination requirement from which relief is requested:

ASME Section XI 1986 edition, no addenda.

The requirement for volumetric examination of 100% of the weld length as described in Table IWB-2500-1, Examination Category C-F-1, Item No. C5.11.

#### D. Basis for relief:

The specific examination area geometry of the pipe to valve welds for TCX-2-2577-12 and B20 and the pipe to nozzle weld for TCX-2-2579-35 precludes the complete ultrasonic examination of the volume required by Figure IWC-2500-7. Approximately 10% of the exam volume for each weld of TCX-2-2577-12, TCX-2-2577-20, and TCX-2-2578-35 did not receive the full code required coverage.

Best effort examinations consisting of two separate base metal angle shear and longitudinal waves were performed. Full circumferential scan coverage was obtained for both welds. Axial scan coverage was achieved in at least 1 beam path direction with two beam angles (45 and 70 degrees) for the entire exam volume of both welds. (Refer to pages 2 through 7).

There were no recordable indications identified by the best effort volumetric exam or by the required surface exam performed.

Attachment 3 to TXX-01024 Page 2 of 8

E. Alternate examinations:

None

F. Anticipated impact on the overall level of plant quality and safety:

None

PDI		Calibra	ation E	ata Sheet
Plant/Unit CPSES / Company WesDyne Comp/System Cont. Spr Procedure No. TX-ISI-30 Rev/Chng. No. 0 / 0 Cal. Block No. TBX-48 Cal. Block Temp. 73° Comp Therm S/N TU-2250	e ay 2 2 p. Temp. <u>79°</u>	Date Sheet # Page 1 Cal. Checks Initial Calib. Initial Calib. Date	of 1 Time 0725 ate 9-26-00 N/A	
Size 16"/30 Sch.  Ferritic X  Each Maj. or CRT Div. = 0.2	O.375 "T"  Austenitic  2"  Circ. Both X  d X	Intermediate Final Calib, Final Calib, Da Coup Type: Ultrac	olant gel II	Search Unit #1  Manufacture: KBA Serial No.: 009R22 / 2.25Mhz  Search Unit #2  Manufacture: KBA Serial No.: 009R22 / 2.25Mhz
Examination Area/Weld	R	ecordable edications  No Geom  X NO	Exam	Size: 0.250" Shape: Round Size. 0.250" Shape: Round Exam Angle: 45°S Model: Comp. Exam Angle: 70°S Model: Comp. Measured Angle: 70°S Model: Comp. Wedge Style: Non Integral Search Unit Cable Search Unit Cable
Remarks/Reasons for incon			35.0 dB	Type:         RG-174         Type:         RG-174           Length:         6'         No         0           Instrument Settings         Instrument Settings           Make/Model:         Sonic 136         Make/Model:           Serial No:         SAP 101313
Exam Sensitivity for 70° is calibration sens. to reduce I as per procedure.  Examiners:	48.0 dB it was	reduced to a l	~20% FSH 	Serial No:         SAP 101313         Serial No:         SAP 101313           Delay:         0.247"         Range:         2.00"         Delay:         0.433"         Range:         2.00"           M'tl Cal/Vel:         0.121"/μs         Pulser:         222ns         M'tl Cal/Vel:         0.121"/μs         Pulser:         222ns           Damping:         500 Ω         Reject:         OFF         Damping:         500         Reject:         OFF           Rep. Rate:         4K         Freq:         2.25Mhz         Filter:         1         Mode:         P.E.           Filter:         1         Mode:         P.E.         Reference Sensitivity (Sens.)         P.E.           Axial:         32.0 dB         Circ:         34.2 dB         Axial:         54.2 dB
Reviewers: Leg M.	Leve Further Evaluat	el <u>N/A</u> Date	09-26-00 R N/A Yes No X	Axial: 32.0 dB Circ: 34.2 dB Axial: 54.2 dB Circ: NA  SDH Sensitivity: N/A  SDH Sensitivity: N/A
TU Electric Review / Date  Resul N Paragraphics	10/14/60	<b>\</b>	aga.	10/13/on ANII Review/Date ANII witnessed Exm

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	Westinghouse Nucle Inspection	ear Service Divi	noision
· · · · · · · · · · · · · · · · · · ·	PROFILE OF THE EXA	MINATION V	OLUME
PlantCOMANCHE	PEAK Unit	<u>2</u> \$	ketch <u>TCX - 2 - 2577 REV. 0</u>
System/CompCONTAINA	MENT SPRAY	P	rocedure TX-ISI-206 REV. 1 F.E. 1 \$2
Weld Identification 12	Date	7-3-91 E	Examiner Abel Level II
VALVE. 2 SIDE		12" .333" LOCATIO	346" 346"  J.D.  346" 346"

PDI			(	Cal	ibra	tion D	Pata Sheet	
Plant/Unit	CPSES				heet #	PDI-2		
Company	WesDyr			Page	1	of1		
Comp/System	Cont. S							
Procedure No.	TX-ISI-3	302		Cal. Ct		Time		
Rev/Chng. No.	0/0		<del></del>	nitial C		1019		
Cal. Block No.	TBX-48				alib. Dat			
Cal. Block Temp.				nterme		N/A		
Therm S/N	TU-225			nterme		N/A		
Size 16*/30	_Sch	0.375		Final C		1422		
Ferritic	<u></u> .	X Austen	itic [	inal C	alib. Date	9-26-00	╼┚ ┖╼ <u>╾┺╼┺╼╾┺╼╾┺╼┺</u> ┷ <u>┸╌┸┯╌┖</u> ╌┚ <u>┡┈╏╴┠╶┎┎</u>	
Each Maj. or CRT			<del></del>				Search Unit #1 Search Unit #2	
Cal. Direction:	Axial		loth X	_	Coupl		Manufacture: KBA Manufacture: KBA	
Scan Area:	_i_ to W			Гуре:	Ultrage		Serial No.: 009R22 / 2.25Mhz Serial No.: 009R22 / 2.25MHz	
	II to W	eld	t	Batch:	97425		Size: 0.250" Shape: Round Size. 0.250" Shape: Round	
							Exam Angle: 45°S Model: Comp. Exam Angle: 70°S Model: Comp.	
			1	ecorda			Measured Angle: 45°S Measured Angle: 70°S	
	- 001-1-1	Access		ndicati		Exam	Wedge Style: Non Integral Wedge Style: Non Integral	
Examination Are	a/vveid	1100	Yes	No	Geom	Sens.	Search Unit Cable Search Unit Cable	
TCX-2-2577-20		UPS	ļ	X	NO	44.0 dB	Type: RG-174 Type: RG-174	
			1			]	Length: 6' No 0 Length: 6' No 0	
							Instrument Settings Instrument Settings	
							Make/Model: Sonic 136 Make/Model: Sonic 136	
Remarks/Reaso	ns for inc	complete S	can(s)	Pine to	Valve	1	Serial No: SAP 101313 Serial No: SAP 101313	
10% Not Examin			(-/				Delay: 0.247" Range: 2.00" Delay: 0.433" Range: 2.00"	
							M'tl Cal/Vel: 0.121"/µs Pulser: 222ns M'tl Cal/Vel: 0.121"/µs Pulser: 222ns	_
Exam Sensitivi	tv for 70°	is 48 0 dF	l it was	reduc	ed to a le	wel helow		
calibration sens.	to reduc	e ID roll t	n a leve	el hetw	een 5%~	20% ESH		
as per procedure			- a 10 (		0011 0 70	20701 011	1 10d. 2.201	nz
Examiners:			Lev	el	Date	<del></del>		
Dans t	2 10/1	לאהא	LOV		Date	09-24-00	Reference Sensitivity (Sens.) Reference Sensitivity (Sens.)	
	سسر					00 24 00	— Axial: <u>32,0 dB</u> Circ: <u>34,2 dB</u> Axial: <u>54,2 dB</u> Circ: <u>NA</u>	
N/A		/	Lev	el N/A	\ Date	N/A	Axial: <u>32.0 dB</u> Circ: <u>34.2 dB</u> Axial: <u>54.2 dB</u> Circ: <u>NA</u>	
Reviewers:	fr_	Furthe			<del></del>	Yes No X	SDH Sensitivity: N/A SDH Sensitivity: N/A	
TU Electric Review / I	Tate Tate				NI I Electric	Level III Revie	out/Date	
1				1	Constitution	CEASI III LEAIS	A THE PARTY OF THE	
In Basal	ina	10/12/0	טי		ナ, 人	< agai	~ 10/13/00 fle (. Hair 10/14/6p	
, 100	1				()	_ U	1 100	

We	estinghouse Nuclear Services Inspection Services	e Division
PROFIL	E OF THE EXAMINATION	ON VOLUME
Plant COMANCHE PEAK	Unit 2	Sketch
		Procedure <u>TX-TSI-206 Rev 1 Fe 1                               </u>
Weld Identification 20	Date 7-2-91	Examiner Aller Aller Level II
	BATUM	
:	25/05	SEIDE ID.
	.400" <u>384</u> " .333"	.333 <sup>#</sup> .337 <sup>**</sup>
•		CATION OF PROFILE

## **Calibration Data Sheet**

Company	Plant/Unit	CPSES	/ Unit 2	ı	Date S	Sheet #	PDI-5	
Comp/System Cont. Spray Procedure No. TX-ISI-302 Cal. Checks Time Initial Calib. 1019 Initial Calib. 1019 Initial Calib. 1019 Initial Calib. 1019 Initial Calib. 1029 Cal. Block No. TBX-11 Cal. Block Temp. 73° Compt. Temp. 83° Therm S/N TU-2250 Star 12'40 Sch. 0.375'T' Final Calib. 1422 Final Calib.	Сотрапу	WesDy	ne			1		<del>╸┝┾┿╅┼┼┼┼┼</del> ┪╸┈ <del>┡┼┼┼┼┼┼┼</del> ┤
Procedure No.   TX-ISI-302   Cal. Checks   Time   Initial Calib.   1019   Cal. Block No.   0.70   Initial Calib.   1019   Cal. Block Temp.   73° Comp. Temp. 83°   Initial Calib.   1019   Initial C	Comp/System	Cont. S	pray		J		<del></del>	<del>╸</del> <del>┌┼┼┩┼┼┼┼┼┼</del> ┤ <del>┌┼┼┼┼╬┼┼┼</del> ┤ │
Rev/Chng. No.   0 / 0   10   10   10   10   10   10	Procedure No.				Cal. C	hecks	Time	<del>┑</del>
Cal. Block No. TBX-11 Cal. Block Nemp. 73° Comp. Temp. 83° Intermediate N/A Intermediate N/	Rev/Chng. No.	0/0	***********				<del></del>	<del>┑╶┝┾╄┪┼╂┼╃╃</del> ┩╸┈ <del>╏┼┼┼╬┼┼┼┼</del> ┼┼┼
Cal. Block Temp. 73° Comp. Temp. 83° Intermediate N/A Int		TBX-11		+				╗╸ <del>╒╶┊╒┋╒┋╒┋</del> ╒┋
Ferritic Each Maj. or CRT Div. = 0.2* / 0.1* Cal. Direction: Axial Circ. Both X Couplant Type: Ultragel II Batch: 97425 Size: 0.250* Shape: Round Size Model: Comp. Exam Angle: 45°S Wedge Style: Non Integral Search Unit Cable Type: RG-174  Length: 6* No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Mil Cal/Vel: 0.121*/µs Pulser: 222ns Mil Cal/Vel: 0.121*/µs Pulser: 225hbz Reference Sensitivity (Sens.)  Further Evaluation Required? Yes No X  TU Electric Review / Date  TU Electric Review / Date  TU Electric Review / Date  Type: Ultragel II Manufacture: KBA Serial No: 009R22 / 2.25Mhz Search Unit #1 Manufacture: KBA Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No: 009R22 / 2.25Mhz Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No: 009R22 / 2.25Mhz Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No:	Cal. Block Temp.	73° Cor	np. Temp.					<del>╶</del> ┧ ┝ <del>┑┪┪┪┪</del> ┪┪
Ferritic Each Maj. or CRT Div. = 0.2* / 0.1* Cal. Direction: Axial Circ. Both X Couplant Type: Ultragel II Batch: 97425 Size: 0.250* Shape: Round Size Model: Comp. Exam Angle: 45°S Wedge Style: Non Integral Search Unit Cable Type: RG-174  Length: 6* No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Mil Cal/Vel: 0.121*/µs Pulser: 222ns Mil Cal/Vel: 0.121*/µs Pulser: 225hbz Reference Sensitivity (Sens.)  Further Evaluation Required? Yes No X  TU Electric Review / Date  TU Electric Review / Date  TU Electric Review / Date  Type: Ultragel II Manufacture: KBA Serial No: 009R22 / 2.25Mhz Search Unit #1 Manufacture: KBA Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No: 009R22 / 2.25Mhz Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No: 009R22 / 2.25Mhz Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No:				<del></del> +				┥ <del>┍┩╃╃┩┩</del> ╃┼┼╃┪┈┝ <del>┼┦┦┩┩┩</del> ┪
Ferritic Each Maj. or CRT Div. = 0.2* / 0.1* Cal. Direction: Axial Circ. Both X Couplant Type: Ultragel II Batch: 97425 Size: 0.250* Shape: Round Size Model: Comp. Exam Angle: 45°S Wedge Style: Non Integral Search Unit Cable Type: RG-174  Length: 6* No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247* Range: 1.00* Mil Cal/Vel: 0.121*/µs Pulser: 222ns Mil Cal/Vel: 0.121*/µs Pulser: 225hbz Reference Sensitivity (Sens.)  Further Evaluation Required? Yes No X  TU Electric Review / Date  TU Electric Review / Date  TU Electric Review / Date  Type: Ultragel II Manufacture: KBA Serial No: 009R22 / 2.25Mhz Search Unit #1 Manufacture: KBA Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No: 009R22 / 2.25Mhz Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No: 009R22 / 2.25Mhz Serial No: 009R22 / 2.25Mhz Nanufacture: KBA Serial No:	Size 12"/40							┩ <u>┡╄╋╃╃╫╫</u>
Scan Area: I to Weld X II to Weld Batch: 97425 Serial No.: 009R22 / 2.25Mhz Size: 0.250" Shape: Round Size. 0.250" Shape:	Ferritic			-				<del>╡</del> ┡ <del>╍┋┩╌┋┋</del>
Scan Area: I to Weld X II to Weld Batch: 97425 Serial No.: 009R22 / 2.25Mhz Size: 0.250" Shape: Round Size. 0.250" Shape:				0	marc	Julib. Dai	C   5-24-00	<sup>-</sup>
Scan Area: I to Weld X II to Weld Batch: 97425 Serial No.: 009R22 / 2.25Mhz Size: 0.250" Shape: Round Size. 0.250" Shape:				oth X		Count	ant	Man feet Still WZ
Size   97425   Size   0.250"   Shape   Round   Size   0.250"   Shape   Round   Exam Angle   70°S   Model   Comp.   Measured Angle   70°S   Model   Comp.   Measured Angle   70°S   Model   Comp.   Measured Angle   70°S   M					Tyne:			- Wallaladalo, NDA
Recordable Indications   Exam Angle: 45°S   Model: Comp.   Measured Angle: 70°S   M					• •			01
TOX-2-2578-35 UPS X NO 44.0 dB Type: RG-174 Type: RG-174 Length: 6' No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247' Range: 1.00' Delay: 0.433' Range: 2.00' M'tl Cal/Vel: 0.121''/µs Pulser: 222ns Damping: 500 \( \Omega \) Reper procedure.  Examiners:  Level Date N/A Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  TU Electric Review / Date  Type: RG-174 Type: Refiler: 1 Make/Model: Sonic 136 Serial No: SAP 101313 Serial No: SAP 101313 Serial No: SAP 10313 Serial No: SAP 10		11 10 44	CIG		Jaicii.	97423	<del></del>	
TOX-2-2578-35 UPS X NO 44.0 dB Type: RG-174 Type: RG-174 Length: 6' No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247' Range: 1.00' Delay: 0.433' Range: 2.00' M'tl Cal/Vel: 0.121''/µs Pulser: 222ns Damping: 500 \( \Omega \) Reper procedure.  Examiners:  Level Date N/A Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  TU Electric Review / Date  Type: RG-174 Type: Refiler: 1 Make/Model: Sonic 136 Serial No: SAP 101313 Serial No: SAP 101313 Serial No: SAP 10313 Serial No: SAP 10					00000	- L1-		
TOX-2-2578-35 UPS X NO 44.0 dB Type: RG-174 Type: RG-174 Length: 6' No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247' Range: 1.00' Delay: 0.433' Range: 2.00' M'tl Cal/Vel: 0.121''/µs Pulser: 222ns Damping: 500 \( \Omega \) Reper procedure.  Examiners:  Level Date N/A Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  TU Electric Review / Date  Type: RG-174 Type: Refiler: 1 Make/Model: Sonic 136 Serial No: SAP 101313 Serial No: SAP 101313 Serial No: SAP 10313 Serial No: SAP 10			Accord				F	
TOX-2-2578-35 UPS X NO 44.0 dB Type: RG-174 Type: RG-174 Length: 6' No 0 Instrument Settings Make/Model: Sonic 136 Serial No: SAP 101313 Delay: 0.247' Range: 1.00' Delay: 0.433' Range: 2.00' M'tl Cal/Vel: 0.121''/µs Pulser: 222ns Damping: 500 \( \Omega \) Reper procedure.  Examiners:  Level Date N/A Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  Reviewers:  Level N/A Date N/A  Level N/A Date N/A  TU Electric Review / Date  Type: RG-174 Type: Refiler: 1 Make/Model: Sonic 136 Serial No: SAP 101313 Serial No: SAP 101313 Serial No: SAP 10313 Serial No: SAP 10	Evernination Ass		Access		·		1	
Delay: 0.247"   Range: 1.00"   Delay: 0.433"   Range: 2.00"		a/vveid	1100	Yes				Search Unit Cable Search Unit Cable
Delay: 0.247"   Range: 1.00"   Delay: 0.433"   Range: 2.00"	TCX-2-25/0-35		UPS		X	NO	44.0 dB	Type: RG-174 Type: RG-174
Delay: 0.247"   Range: 1.00"   Delay: 0.433"   Range: 2.00"	<u> </u>			ļ				Length: 6' No 0 Length: 6' No 0
Delay: 0.247"   Range: 1.00"   Delay: 0.433"   Range: 2.00"								
Delay: 0.247"   Range: 1.00"   Delay: 0.433"   Range: 2.00"								
Delay: 0.247"   Range: 1.00"   Delay: 0.433"   Range: 2.00"	Remarks/Reaso	ns for inc	omplete S	can(s)	Pine t	o Valve	·	Control of the contro
Exam Sensitivity for 70° is 48.0 dB, it was reduced to a level below calibration sens. to reduce I.D. roll to a level between 5%~20% FSH as per procedure.  Examiners:  Level Date Filter: 1 Mode: P.E. Filter: 1 Mode: P.	10% Not Examin	ned.		(-)		- Tuito.		Oction 10: 0A1 10:313
Exam Sensitivity for 70° is 48.0 dB, it was reduced to a level below calibration sens. to reduce I.D. roll to a level between 5%~20% FSH as per procedure.  Examiners:  Level Date Filter: 1 Mode: P.E. Filter: 1 Mode: P.								1 valigo, 2.00
Reviewers: Level N/A Date N/A  SDH Sensitivity: N/A  TU Electric Review / Date  TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date ANII Review / Date Anii Review / Date Exam	Fyam Sansitivit	tu far 700	ic 49 0 dD	it was	rodua			D
Reviewers: Level N/A Date N/A  SDH Sensitivity: N/A  TU Electric Review / Date  TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date ANII Review / Date Anii Review / Date Exam	Calibration sens	to reduc	13 40.0 UD	, it was	leauc	eu to a le	evel below	1,0000,011
Reviewers: Level N/A Date N/A  SDH Sensitivity: N/A  TU Electric Review / Date  TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date ANII Review / Date Anii Review / Date Exam	as per procedure	10 10000 2	e i.D. foll t	U a IEVE	ai netw	/eeii 5%~	20% FSH	1 1 1 1 0 q. 2.23 will 2
Reviewers: Level N/A Date N/A  SDH Sensitivity: N/A  TU Electric Review / Date  TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date ANII Review / Date Anii Review / Date Exam		<del></del>			···-			
Reviewers: Level N/A Date N/A  SDH Sensitivity: N/A  TU Electric Review / Date  TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date ANII Review / Date Anii Review / Date Exam	A	- N.	1/	Lev		Date		Reference Sensitivity (Sens.)  Reference Sensitivity (Sens.)
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SDH Sensitivity: N/A  SDH Sensitivity: N/A  TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date Anii Review / Date Exam	$\bigcup_{N/A}$			Lev	el N/A	A Date	N/A	Axial: <u>32.6 dB</u> Circ: <u>34.8 dB</u> Axial: <u>56.4 dB</u> Circ: <u>NA</u>
TU Electric Review / Date  TU Electric Level III Review / Date  ANII Review / Date Ant witnessed Exam	Reviewers:	Sh	Furthe	— r Evalua	tion R			SDH Sensitivity: <u>N/A</u> SDH Sensitivity: <u>N/A</u>
ANII Review/Date And F witnessed exam	,	-						
O Am O A I I Witnessed Exam	TU Electric Review / D	Date				TU Electric	Level III Revie	ew / Date ANII Review / Date A
	O Dan R	0			(		7	Hart witnesses Exam

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## Westinghouse Nuclear Service Division Inspection Services

#### PROFILE OF THE EXAMINATION VOLUME

Plant COMANCHE	PEAK	Unit <u>No. 2</u>	Sketch 1CX-2-2578 REV. 0
System/CompCONT	AINMENT SPR	AV	Procedure 11-151-306 REV.   F.C. 1+2
Weld Identification	35	Date 6-5-92	Examiner <u>C. Hilliam Nemoch</u> Level II
PIPE SSIDE	1		Pump 2 stae
O.D		DAT	um die
	<u>039" as</u>	<u>0.40</u> " <u>0.35</u> "	<u>041"</u>
	270°		ocation of Profile