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Docket No. 50-220

JUL 20 1982

Mr. Donald P. Dise
 Vice President-Engineering
 c/o Miss Catherine R. Seibert
 Niagara Mohawk Power Corporation
 300 Erie Boulevard - West
 Syracuse, New York 13202

Dear Mr. Dise:

Subject: Furnace Sensitized Stainless Steel Safe-Ends

Re: Nine Mile Point Nuclear Station, Unit No. 1

On June 18, 1982 we forwarded Amendment No. 49 to Facility Operating License No. DPR-63 for the Nine Mile Point Nuclear Station, Unit No.1. In essence, the amendment approved your safe-end replacement program subject to various license conditions. This letter addresses one of those conditions; i.e., NRC review of your final welding procedures.

On June 23, 1982 members of the staff visited the Nine Mile site to assess the acceptability of replacement safe-end materials as well as your final welding procedures. The following documents were reviewed: (1) "Document package for recirculation safe-end, PR #821194 Rev. 1, PO #70878, Serial #35812 thru 35812", and (2) "The Great Atlantic and Pacific Pipe Welding & Construction Company, Inc." Welding technique sheet - Ref. W.P.S. No. 8:43.5-00X2. In addition, the following information was provided: (1) The replacement safe-ends will be made of type 316 austenitic stainless steel containing .02% carbon maximum and .10% nitrogen maximum, a material expected to have minimal propensity to sensitization and hence, to intergranular stress corrosion cracking (IGSCC), and (2) A low heat input welding procedure will be used to join the replacement safe-ends to the existing nozzles.

Based on our review, we conclude that you have provided reasonable assurance that the austenitic stainless steel replacement safe-ends will be in a metallurgical condition which minimizes the susceptibility of IGSCC. Therefore, by this letter the subject welding activities are approved and you are authorized to proceed with the welding of the replacement safe-ends.

Sincerely,

ORIGINAL SIGNED BY

Domenic B. Vassallo, Chief
 Operating Reactors Branch #2
 Division of Licensing

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Mr. Donald P. Dise

cc:

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