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Do not include proprietary materials.

DATE OF MEETING

10/24/2001

The attached document(s), which was/were handed out in this meeting, is/are to be placed in the public domain as soon as possible. The minutes of the meeting will be issued in the near future. Following are administrative details regarding this meeting:

| | |
|--|---|
| Docket Number(s) | 50-261 |
| Plant/Facility Name | H. B. Robinson Steam Electric Plant, Unit 2 |
| TAC Number(s) (if available) | MB2654 |
| Reference Meeting Notice | Dated October 19, 2001 |
| Purpose of Meeting (copy from meeting notice) | To discuss Robinson's response to NRC Bulletin 2001-01, "Circumferential Cracking of Reactor Pressure Vessel Head Penetration Nozzles" |

NAME OF PERSON WHO ISSUED MEETING NOTICE

Kahtan N. Jabbour

TITLE

Senior Project Manager

OFFICE

NRR

DIVISION

Division of Licensing Project Management

BRANCH

Project Directorate II-2

Distribution of this form and attachments:

Docket File/Central File

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DFOI

NRC Bulletin 2001-01 NRC Meeting

Robinson Nuclear Plant

October 24, 2001



CP&L

A Progress Energy Company

Agenda

- Introduction
- Background
- Analytical Basis for Qualification
- Future Inspections
- Closing Remarks

Introduction

Background

| Key Design Parameters | |
|--|------------------------|
| NSSS Designer | Westinghouse |
| Head Fabricator | Combustion Engineering |
| Nozzle Material Supplier | Huntington |
| Number of Vessel Head Penetrations | 69 |
| Design Diametrical Nozzle Interference Fit | 0.0 – 3.0 mils |
| Remaining EFPYs to Oconee 3 | ~3.0 EFPYs |

Background

- Qualified Examination of Vessel Head Penetrations (VHPs)
 - ▶ Completed April 2001 during Refueling Outage 20
 - ▶ Bare metal visual examination
 - ◆ VT-2 qualified inspectors
 - ▼ Inspectors briefed on Oconee leakage indicators
 - ◆ No evidence of VHP leakage

Background

- Qualified Examination (continued)
 - ▶ Analyses provide high confidence of leakage path to vessel head surface
 - ◆ Finite element analyses provide analytical basis for leakage path
 - ◆ Records provide strong assurance of manufacture and assembly of Robinson VHPs in accordance with design

Analytical Basis for Qualification

- Two Vendor-Performed Finite Element Analyses of Robinson VHPs
 - ▶ Structural Integrity Associates, Inc.
 - ▶ Dominion Engineering, Inc.

Analytical Basis for Qualification

- Structural Integrity Associates Analysis Concluded
 - ▶ Leakage path to vessel head surface exists for interference fits through 3 mils
 - ◆ 3 mils interference fit is the largest interference fit allowed by design

Analytical Basis for Qualification

- Dominion Engineering Analysis Concluded
 - ▶ Leakage path to vessel head surface exists for interference fits through 2.75 mils
 - ◆ Based on the very low contact force near the surface over a short contact length, leakage would be likely for interference fits of greater than 2.75 through 3 mils

Design Range of Interference Fits

| Design Range of Nozzle Sizes | Design Range of Hole Sizes | Maximum Design Interference Fit |
|------------------------------|----------------------------|---------------------------------|
| 4.000 | 3.997 | 0.003 |
| | 3.998 | 0.002 |
| | 3.999 | 0.001 |
| 3.999 | 3.997 | 0.002 |
| | 3.998 | 0.001 |
| | 3.999 | 0.000 |

Analytical Basis for Qualification

- Robinson VHPs Constructed in Accordance with Design Requirements
 - ▶ Manufacturing/Inspection records
 - ◆ Controlled under vendor/licensee quality assurance program & ASME Section III, 1965
 - ▼ Documentation of rejection/rework of dimensionally incorrect material
 - Example
 - ▼ Detailed documentation of lower vessel penetration non-conformances

Analytical Basis for Qualification

- Robinson VHPs Constructed in Accordance with Design Requirements (continued)
 - ▶ Assembly process records
 - ◆ Instructions to minimize interference fit
 - ▼ Match housings to penetrations for assurance of least possible interference fit
 - ◆ Limitations of shrinkage method
 - ▼ Method could produce only ~ 4 mils shrinkage
 - ▼ Method designed to assure ~ 3 mils gap for assembly
 - ◆ Result – given instructions to match housings to penetrations to minimize interference, interference fits likely clustered at or below 2 mils

Analytical Basis for Qualification

- Robinson VHPs Constructed in Accordance with Design Requirements (continued)
 - ▶ Comparison with similar reactor vessel heads
 - ◆ Evaluation of 3 similar vintage reactor vessel heads (230 VHPs)
 - ▼ No undersized holes
 - ◆ Two additional later vintage reactor vessel heads (156 VHPs) with dimensions of nozzles and holes
 - ▼ Interference fits of 3 mils or less

Conclusion

- Qualified Examination of Vessel Head Penetrations was Performed
 - ▶ Visual examination (VT-2) with no identified leakage
 - ▶ Leakage path demonstrated through finite element analyses
 - ▶ Records support manufacture and assembly of Robinson VHPs in accordance with design

Future Inspections

- Refueling Outage 21 (October 2002)
 - ▶ Qualified visual examination
 - ▶ Non-destructive examination

Closing Remarks