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Docket No. 50-250

APR 3 - 1973

Florida Power & Light Company
 ATTN: Dr. James Coughlin
 P. O. Box 3100
 Miami, Florida 33101

Change No. 4
 License No. DPR-31

Gentlemen:

Your letter dated March 30, 1973, proposed eight revisions to the Technical Specifications attached as Appendix A to Facility Operating License No. DPR-31. These changes are intended to correct and clarify the surveillance requirements for several primary system components and to designate, for Unit 4, substitute tendons for inspection because those originally selected have proven inaccessible.

We have reviewed these changes and have determined that they are appropriate and should be made. In particular, the changes relating to primary system inspection reflect our guidance that the in-service inspection program follows Section XI of the ASME Code as closely as practicable. In this regard, we would like to be kept informed of the progress of your study of alternative methods for inspecting the pressurizer welds.

We conclude that the changes do not involve significant hazard considerations not described or implicit in the Final Safety Analysis Report and there is reasonable assurance that the health and safety of the public will not be endangered. Accordingly, pursuant to Section 50.59 of 10 CFR Part 50, the Technical Specifications of Facility Operating License No. DPR-31 are hereby changed as set forth in revised pages which are enclosed.

Sincerely,

/s/

cc: Jack Newman
 bcc: J. R. Buchanan, ORNL
 Thomas B. Abernathy, DTIE

R. C. DeYoung, Assistant Director
 for Pressurized Water Reactors
 Directorate of Licensing

Enclosure:
 As stated

LB

OFFICE ▶	PWR-2 <i>[Signature]</i>	TR <i>[Signature]</i>	PWR-2 <i>[Signature]</i>	AD/PWRs <i>[Signature]</i>	RO: AD/ CONST. & OPERATION
SURNAME ▶	PScheck:nlg	SPawicki	KKniel	RCDeYoung	RHE: SAK 4/3/73
DATE ▶	4/3/73	4/3/73	4/3/73	4/3/73	4/3/73



Docket No. 50-250

UNITED STATES
ATOMIC ENERGY COMMISSION
WASHINGTON, D.C. 20545

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APR 8 - 1973

Florida Power & Light Company
ATTN: Dr. James Coughlin
P. O. Box 3100
Miami, Florida 33101

Change No. 4
License No. DPR-31

Gentlemen:

Your letter dated March 30, 1973, proposed eight revisions to the Technical Specifications attached as Appendix A to Facility Operating License No. DPR-31. These changes are intended to correct and clarify the surveillance requirements for several primary system components and to designate, for Unit 4, substitute tendons for inspection because those originally selected have proven inaccessible.

We have reviewed these changes and have determined that they are appropriate and should be made. In particular, the changes relating to primary system inspection reflect our guidance that the in-service inspection program follows Section XI of the ASME Code as closely as practicable. In this regard, we would like to be kept informed of the progress of your study of alternative methods for inspecting the pressurizer welds.

We conclude that the changes do not involve significant hazard considerations not described or implicit in the Final Safety Analysis Report and there is reasonable assurance that the health and safety of the public will not be endangered. Accordingly, pursuant to Section 50.59 of 10 CFR Part 50, the Technical Specifications of Facility Operating License No. DPR-31 are hereby changed as set forth in revised pages which are enclosed.

Sincerely,

A handwritten signature in dark ink, appearing to read "R. C. DeYoung", is written over the typed name.

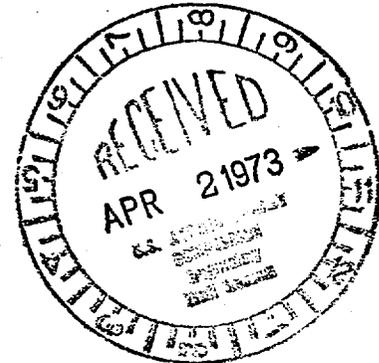
R. C. DeYoung, Assistant Director
for Pressurized Water Reactors
Directorate of Licensing

Enclosure:
As stated



March 30, 1973

Mr. R. C. DeYoung, Assistant Director
for Pressurized Water Reactors
Directorate of Licensing
U. S. Atomic Energy Commission
Washington, D. C. 20545



Dear Mr. DeYoung:

Re: Turkey Point Units 3 and 4
Docket Nos. 50-250 and 50-251
Proposed Changes in Technical Specifications

In accordance with 10 CFR 50.59, Florida Power & Light Company herewith submits twenty-two (22) copies of proposed changes in the Technical Specifications for the subject facility to correct and clarify the surveillance requirements as listed below:

1. Sheet 3 of Table 4.2-1
Added clarifying footnote and changed Item No. 2.7.
2. Sheet 4 of Table 4.2-1
Clarified Item No. 3.1 remarks by changing "lower" to "channel".
3. Sheet 6 of Table 4.2-1
Modified Item No. 5.6.
4. Page 4.4-4
Changed numbers of Unit 4 vertical tendons to be inspected due to access restrictions.
5. Page B4.2-5
Clarified Item No. 2.1.
6. Page B4.2-6
Modified Item No. 2.7.
7. Page B4.2-7
Deleted top line and added word "channel" in Item No. 3.1.

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TABLE 4.2-1 (cont'd)

Item No.	Examination Category	Components and Parts To Be Examined	Method	Extent of Examination (Percent in 10 Year Interval)	Extent of Examination (Percent in 5 Year Interval)	Remarks
2.1	B	<u>Pressurizer</u> Longitudinal and circumferential welds †		See Remarks	See Remarks	In accordance with Section XI of the 1970 ASME Code
2.2	D	Nozzle-to-vessel welds		See Remarks	See Remarks	Instrument and sample nozzles are included in Item 2.4
2.3	E-1	Heater connections		See Remarks	See Remarks	These connections are considered in Item 2.4
2.4	E-2	Heater connections and instrument and sample nozzles	Visual	See Remarks	See Remarks	Visual inspections for leakage will be performed on nozzles at each re-fueling.
2.5	G-1	Pressure retaining bolting		Not Applicable	Not Applicable	
2.6	G-2	Pressure retaining bolting	Visual	100%	33%	
2.7	H	Integrally welded vessel supports † (skirt weld)		See Remarks	See Remarks	Same as 2.1
2.8	I-2	Vessel cladding	Visual	1 Patch	0 Patches	

† No known technique presently exists to examine these welds (Refer to Code Foreword page f).

TABLE 4.2-1 (cont'd)

<u>Item No.</u>	<u>Examination Category</u>	<u>Components and Parts To Be Examined</u>	<u>Method</u>	<u>Extent of Examination (Percent in 10 Year Interval)</u>	<u>Extent of Examination (Percent in 5 Year Interval)</u>	<u>Remarks</u>
3.1	B	<u>Heat Exchangers (Class A) and Steam Generators</u> Longitudinal and circumferential welds, including tube-sheet-to-head or shell welds on the primary side	Volumetric	5% See Remarks	0% See Remarks	The inspection is limited to the circumferential weld attaching the tube sheet to the channel head.
3.2	D	Nozzle-to-vessel head welds and nozzle-to-head inside radiused section		See Remarks	See Remarks	The primary nozzles are cast with the head. No inspections are planned.
3.3	F	Nozzle to safe-end welds	Visual, Surface and volumetric	25%	8%	
3.4	G-1	Pressure-retaining bolting		Not Applicable	Not Applicable	
3.5	G-2	Pressure-retaining bolting	Visual	100%	33%	
3.6	H	Integrally-welded vessel supports		Not Applicable	Not Applicable	
3.7	I-2	Vessel cladding	Visual	1 Patch	0 Patches	One (1) patch (36 square inches) in each primary side will be examined during the ten-year interval.

TABLE 4.2-1 (cont'd)

<u>Item No.</u>	<u>Examination Category</u>	<u>Components and Parts To Be Examined</u>	<u>Method</u>	<u>Extent of Examination (Percent in 10 Year Interval)</u>	<u>Extent of Examination (Percent in 5 Year Interval)</u>	<u>Remarks</u>
5.2	L-2	Pump casings	Visual	See Remarks	See Remarks	Examination will be made only when pump internals are removed for other reasons.
5.3	F	Nozzle-to-safe-end welds		Not Applicable	Not Applicable	
5.4	G-1	Pressure-retaining bolting	Visual and Volumetric	100%	33%	Bolting will be inspected only when pump is disassembled for other reasons.
5.5	G-2	Pressure-retaining bolting	Visual	See Remarks	See Remarks	Bolting will be inspected only when pump is disassembled for other reasons.
5.6	K-1	Integrally-welded supports	Visual and Surface	25%		Same as 5.1
5.7	K-2	Supports and hangers	Visual	100%	33%	
6.1	M-1	<u>Valve Pressure Boundary</u> Valve-body welds		Not Applicable	Not Applicable	
6.2	M-2	Valve bodies	Visual	See Remarks	See Remarks	Exception taken for valves which are not accessible or which are not disassembled for maintenance purposes during the inspection interval.
6.3	F	Valve-to-safe-end welds		Not Applicable	Not Applicable	
6.4	G-1	Pressure-retaining bolting		Not Applicable	Not Applicable	

4.4.6 TENDON SURVEILLANCE

Lift-off

Lift-off readings will be taken for the following nine (9) tendons available for inspection:

<u>Unit 3</u>	<u>Unit 4</u>
Horizontal 62H18,42H70,64H50	13H15,51H50,35H70
Vertical 23V1,45V7,61V1	12V29,34V29,56V29
Dome 1D27,2D28,3D28	1D28,2D28,3D28

Wire Inspection

One horizontal, one vertical and one dome tendon will be relaxed and one wire will be removed from each as a sample. (At subsequent inspections different tendons will be used for the sample). Wires will be visually inspected for corrosion and pitting. Tensile tests will be performed on three (3) samples cut from each wire (one from each end and one from the middle) of a length equal to the maximum length acceptable for the test apparatus to be used.

After samples are taken, tendons will be re-tensioned and final lift-off readings will be taken.

Test Frequency

Lift-off readings and wire inspection will take place at the end of the first, third and every fifth year thereafter from the date of the structural integrity test. Tendon surveillance may be conducted during reactor operation.

Item 1.11 (Category G-2) - Closure Studs, Nuts, Washers, Bushings
and Ligaments Between Threaded Stud Holes

There are no pressure retaining bolts less than 2 inches on the vessel.

Item 1.12 (Category H) - Integrally Welded Vessel Supports

There are vessel support pads welded to each of the three inlet nozzles on the vessel. In accordance with Category H of Table IS-251 of the Code, the area to be examined should be the weld connection between the nozzle and the vessel shell. This examination is covered by Item 1.4 above.

Item 1.13 and 1.14 (Category I-1) - Vessel Cladding

Portions of the cladding in the closure head and reactor vessel are accessible for visual and surface examinations. The examinations scheduled to be performed are shown in Table 4.2-1.

Item 1.15 (Category N) - Interior Surfaces and Internals and Integrally
Welded Internal Supports

The internal surfaces and internal components of the reactor vessel will be inspected in accordance with Section XI of the Code.

PRESSURIZER

Item 2.1 (Category B) - Longitudinal and Circumferential Welds

Longitudinal and circumferential welds on the pressurizer cannot be volumetrically examined from the OD. The baseline inspection is the shop inspection and methods for future inspection are under study.

Item 2.2 (Category D and E-2) - Nozzle-to-Vessel Welds

The nozzles on the pressurizer are cast with the upper and lower head, thus there are no Category D connections. The eight

instrument nozzles and one sample nozzle are rolled and seal welded and thus are Category E-2 connections. The four instrument nozzles and the sample nozzle in the lower head are located below the heater support plate and thus are inaccessible. These penetrations will be visually inspected for leakage as discussed in Item 2.4 below.

Item 2.3 (Category E-1) - Heater Connections

There are no Category E-1 heater connections.

Item 2.4 (A) (Category E-2) - Heater Well To Head

The external connections are accessible for a visual examination and will be inspected as discussed in Item 2.4 below.

Item 2.4 (B) (Category E-2) - Heater Connections

The pressurizer heater external connections are accessible for visual examination. These connections will be visually examined for leakage as defined by Specification 4.3.1. The instrument and sample nozzles of the pressurizer are included in this inspection.

Item 2.5 (Category G-1) - Pressure Retaining Bolting

The pressure retaining bolting on the pressurizer manway is less than 2 inches in diameter. Thus, this examination is not applicable to the pressurizer.

Item 2.6 (Category G-2) - Pressure Retaining Bolting

The pressurizer manway bolting will be inspected in accordance with Section XI of the ASME Code as shown in Table 4.2-1.

Item 2.7 (Category H) - Integrally Welded Vessel Supports

The skirt weld is in the same category as Item 2.1.

Item 2.8 (Category I-2) - Vessel Cladding

During the 10-year inspection interval, there will be a visual examination of one patch (36 square inches) of the vessel cladding.

STEAM GENERATOR

Item 3.1 (Category B) - Longitudinal and Circumferential Welds, Including Tubesheet-to-Head or Shell Welds on the Primary Side

The head for the steam generators is a one-piece casting. Thus, the only weld covered by this category is the tubesheet-to-channel head weld. It is believed that this weld can be examined from the OD of the steam generator by ultrasonic techniques. The examinations scheduled for this weld are shown in Table 4.2-1.

Item 3.2 (Category D) - Nozzle-to-Vessel Head Welds and Nozzle-to-Head Inside Radiused Section

The nozzles are cast with the head; therefore, no inspections are planned for this item.

Item 3.3 (Category F) - Nozzle to Safe-end Welds

The steam generator safe-ends are a buttered end preparation of the cast nozzle and are located between the nozzle and a cast elbow. Visual, volumetric and ultrasonic examination of these welds will be performed.

Item 3.4 (Category G-1) - Pressure-Retaining Bolting

There is no pressure-retaining bolting greater than two inches in diameter on the steam generator. Thus, this item does not apply to the steam generators.

Item 5.1 (Category L-1) - Pump Casing Welds

The reactor coolant pump casing is a weldment of four cast rings. At this time, there are no proven means of volumetrically inspecting the pump casing welds in service; therefore, no inspections are planned.

Item 5.2 (Category L-2) - Pump Casings

The internal pressure boundary surfaces of the reactor coolant pumps are not accessible during normal or refueling outages. If removal of the pump internals is required during the inspection interval, there will be a visual examination of the accessible pressure boundary surfaces.

Item 5.3 (Category F) - Nozzle-to-Safe-ends Welds

There are no nozzle-to-safe-end welds on the reactor coolant pumps.

Item 5.4 (Category G-1) - Pressure-Retaining Bolting

The reactor coolant pump main flange studs are greater than two (2) inches in diameter. These studs will be examined in accordance with the Code. The examinations scheduled are shown in Table 4.2-1.

Item 5.5 (Category G-2) - Pressure-Retaining Bolting

There is pressure retaining bolting less than two (2) inches in diameter, associated with the reactor coolant pump seals. Since this bolting is not normally accessible, examination of this bolting will be performed only when the pump is disassembled for maintenance purposes.

Item 5.6 (Category K-1) - Integrally-Welded Supports

The reactor coolant pump supports consist of a statically cast austenitic stainless steel foot of coarse grain structure welded to the cast casing. Visual and surface inspection will be performed.