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January 18, 2002
Docket Nos. 50-321
50-366

HL-6173

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

Edwin I. Hatch Nuclear Plant
Third 10-Year Interval Inservice Inspection Program,
Submittal of Relief Request RR-36

Ladies and Gentlemen:

Recently, Southern Nuclear Operating Company (SNC) was advised by the Electric Power Research Institute (EPRI) staff that prior to performing ultrasonic examination of Class 1 Reactor Coolant System (RCS) weld overlays (ref. NRC GL 88-01), relief from the ASME Section XI, Appendix VIII, Supplement 11 requirements is necessary. ASME Section XI, Appendix VIII, requirements are mandated and supplemented by 10 CFR 50.55a(b)(2)(xiv), (xv) and (xvi). Appendix VIII of ASME Section XI, 1995 Edition with 1996 Addenda, is specified in the CFR. The Plant Hatch Inservice Inspection (ISI) Program complies with the 1989 Edition of ASME Section XI, and supplemented as required to incorporate ASME Section XI, Appendix VIII.

During the last Performance Demonstration Initiative (PDI) meeting, attendees were informed that anyone planning to examine weld overlays would be required to submit a request for relief to either:

- (a) Adopt Code Case N-654 with some modifications, or
- (b) Use the PDI Program in lieu of the ASME Section XI, Appendix VIII, Supplement 11 requirements.

EPRI representatives at the meeting indicated that a sample request for relief would be provided by January 2, 2002, to allow consistency within the industry. EPRI worked cooperatively with NRC staff member, Don Naujock, to develop the sample request for relief using option (b) above, since Code Case N-654 will not be issued in sufficient time for utilities with spring 2002 outages.

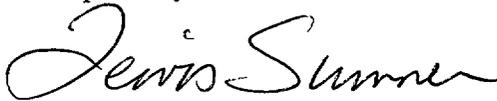
SNC utilized the sample EPRI request for relief and developed ISI Program Relief Request RR 36, which is formatted to meet the SNC standard format; however, the technical content is equivalent to the EPRI sample. Enclosed with RR-36 is a comparison of the differences between ASME Section XI, Appendix VIII, Supplement 11; ASME Section XI Code Case N-654; and the PDI Program for weld overlay examinations. This additional information is provided to assist the NRC in reviewing SNC Relief Request RR-36.

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A refueling outage and associated ISI are scheduled during the spring of 2002. At the present time, no weld overlay examinations are scheduled during this outage. However, SNC is committed to being proactive with contingency plans, and thus, is submitting Relief Request RR-36 for NRC review and approval.

Should you have any questions in this regard, please contact this office.

Respectfully submitted,



H. L. Sumner, Jr.

IFL/eb

Attachment: Request for Relief No. RR-36

cc: Southern Nuclear Operating Company
Mr. P. H. Wells, Nuclear Plant General Manager
SNC Document Management (R-Type A02.001)

U.S. Nuclear Regulatory Commission, Washington, D.C.
Mr. L. N. Olshan, Project Manager - Hatch

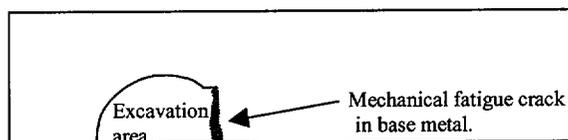
U.S. Nuclear Regulatory Commission, Region II
Mr. L. A. Reyes, Regional Administrator
Mr. J. T. Munday, Senior Resident Inspector - Hatch

ATTACHMENT

**SOUTHERN NUCLEAR OPERATING COMPANY
HATCH NUCLEAR PLANT, UNIT 1 & 2
THIRD 10-YEAR INTERVAL
REQUEST FOR RELIEF NO. RR-36**

**SOUTHERN NUCLEAR OPERATING COMPANY
HATCH NUCLEAR PLANT, UNIT 1 & 2
THIRD 10-YEAR INTERVAL
REQUEST FOR RELIEF NO. RR-36**

- I. System/Component for Which Relief is Requested: Class 1, Pressure Retaining Welds in Piping, subject to ASME Section XI, Appendix VIII, Supplement 11, examination (weld overlay examinations).
- II. Code Requirement: The Code requirements for which relief is requested are all contained within ASME Section XI, Appendix VIII, Supplement 11. For example, paragraph 1.1(d)(1), requires that all base metal flaws be cracks. Paragraph 1.1(e)(1) requires that at least 20% but less than 40% of the flaws shall be oriented within $\pm 20^\circ$ of the pipe axial direction. Paragraph 1.1(e)(1) also requires that the rules of IWA-3300 shall be used to determine whether closely spaced flaws should be treated as single or multiple flaws. Paragraph 1.1(e)(2)(a)(1) requires that a base grading unit shall include at least 3 in. of the length of the overlaid weld. Paragraph 1.1(e)(2)(b)(1) requires that a overlay grading unit shall include the overlay material and the base metal-to-overlay interface of at least 6 sq. in. The overlay grading unit shall be rectangular, with minimum dimensions of 2 in. Paragraph 3.2(b) requires that all extensions of base metal cracking into the overlay material by at least 0.1 in. are reported as being intrusions into the overlay material.
- III. Code Requirement for Which Relief is Requested: Relief is requested to use the enclosed Performance Demonstration Initiative (PDI) Program for implementation of Appendix VIII, Supplement 11 requirements.
- IV. Basis for Relief: Paragraph 1.1(d)(1), requires that all base metal flaws be cracks. As illustrated below, implanting a crack requires excavation of the base material on at least one side of the flaw. While this may be satisfactory for ferritic materials, it does not produce a useable axial flaw in austenitic materials because the sound beam, which normally passes only through base material, must now travel through weld material on at least one side, producing an unrealistic flaw response. To resolve this issue, the PDI program revised this paragraph to allow use of alternative flaw mechanisms under controlled conditions. For example, alternative flaws shall be limited to when implantation of cracks precludes obtaining an effective ultrasonic response, flaws shall be semielliptical with a tip width of less than or equal to 0.002 inches, and at least 70 percent of the flaws in the detection and sizing test shall be cracks and the remainder shall be alternative flaws.



Relief is requested to allow closer spacing of flaws provided they didn't interfere with detection or discrimination. The existing specimens used to date for qualification to the Tri-party (NRC/BWROG/EPRI) agreement have a flaw population density greater than allowed

RELIEF REQUEST RR-36 (cont.)

by the current Code requirements. These samples have been used successfully for all previous qualifications under the Tri-party agreement program. To facilitate their use and provide continuity from the Tri-party agreement program to Supplement 11, the PDI Program has merged the Tri-party test specimens into their weld overlay program. For example: the requirement for using IWA-3300 for proximity flaw evaluation in paragraph 1.1(e)(1) was excluded, instead indications will be sized based on their individual merits; paragraph 1.1(d)(1) includes the statement that intentional overlay fabrication flaws shall not interfere with ultrasonic detection or characterization of the base metal flaws; paragraph 1.1(e)(2)(a)(1) was modified to require that a base metal grading unit include at least 1 in. of the length of the overlaid weld, rather than 3 inches; paragraph 1.1(e)(2)(a)(3) was modified to require sufficient unflawed overlaid weld and base metal to exist on all sides of the grading unit to preclude interfering reflections from adjacent flaws, rather than the 1 inch requirement of Supplement 11; paragraph 1.1(e)(2)(b)(1) was modified to define an overlay fabrication grading unit as including the overlay material and the base metal-to-overlay interface for a length of at least 1 in, rather than the 6 sq. in. requirement of Supplement 11; and paragraph 1.1(e)(2)(b)(2) states that overlay fabrication grading units designed to be unflawed shall be separated by unflawed overlay material and unflawed base metal-to-overlay interface for at least 1 in. at both ends, rather than around its entire perimeter.

Additionally, the requirement for axially oriented overlay fabrication flaws in paragraph 1.1(e)(1) was excluded from the PDI Program as an improbable scenario. Weld overlays are typically applied using automated gas tungsten arc welding techniques with the filler metal being applied in a circumferential direction. Because resultant fabrication induced discontinuities would also be expected to have major dimensions oriented in the circumferential direction axial overlay fabrication flaws are unrealistic.

The requirement in paragraph 3.2(b) for reporting all extensions of cracking into the overlay is omitted from the PDI Program because it is redundant to the RMS calculations performed in paragraph 3.2(c) and it's presence adds confusion and ambiguity to depth sizing as required by paragraph 3.2(c). This also makes the weld overlay program consistent with the Supplement 2 depth sizing criteria.

PDI has submitted these changes as a Code Case and they have been approved, but the Code Case will not be published until later in 2002. A detailed comparison matrix between Supplement 11, the proposed ASME Section XI Code Case N-654, and the PDI Program is enclosed as supporting documentation. The first column identifies the current requirements in the 95 Edition and 96 Addenda of Supplement 11, while the second (middle) column identifies the changes made by the Code Case.

There are however some additional changes that were inadvertently omitted from the Code Case. The most important change is paragraph 1.1(a)(1) where the phrase "and base metal on both sides", was inadvertently included in the description of a base metal grading unit. The PDI program intentionally excludes this requirement because some of the qualification samples include flaws on both sides of the weld. To avoid confusion several instances of the term "cracks" or "cracking" were changed to the term "flaws" because of the use of

RELIEF REQUEST RR-36 (cont.)

alternative flaw mechanisms. Additionally, to avoid confusion, the overlay thickness tolerance contained in paragraph 1.1(b) last sentence, was reworded and the phrase “and the remainder shall be alternative flaws” was added to the next to last sentence in paragraph 1.1(d)(1). These changes are identified by **bold** print in the third column of the enclosure.

- V. Alternate Examination: In lieu of the requirements of ASME Section XI, 1995 Edition, 1996 Addenda, Appendix VIII, Supplement 11, the PDI Program shall be used.
- VI. Justification for Granting Relief: Pursuant to 10 CFR 50.55a(a)(3)(i), SNC requests approval to use the PDI program, as described above, in lieu of the ASME Section XI, Appendix VIII, Supplement 11 requirements. Compliance with the PDI program will provide an adequate level of quality and safety for examination of the affected welds (i.e., weld overlay repairs). The PDI and the NRC have worked closely to reach agreement on the criteria related to the subject examination requirements and both agree that the PDI program is an acceptable alternative to Appendix VIII, Supplement 11.
- VII. Implementation Schedule: The relief request is applicable for the Third 10-Year ISI Interval.
- VIII. Relief Request Status: Submitted to NRC for review and approval.

See the Enclosure for additional information.

RELIEF REQUEST RR-36 - ENCLOSURE

<p align="center">SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY</p>	<p align="center">PROPOSED CODE CASE N-654 (Provided for Information Only)</p>	<p align="center">PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements</p>
<p>1.0 SPECIMEN REQUIREMENTS</p>		
<p>Qualification test specimens shall meet the requirements listed herein, unless a set of specimens is designed to accommodate specific limitations stated in the scope of the examination procedure (e.g., pipe size, weld joint configuration, access limitations). The same specimens may be used to demonstrate both detection and sizing qualification.</p>	<p align="center">No Change</p>	<p align="center">No Change</p>
<p>1.1 General. The specimen set shall conform to the following requirements.</p>	<p align="center">No Change</p>	<p align="center">No Change</p>
<p>(a) Specimens shall have sufficient volume to minimize spurious reflections that may interfere with the interpretation process.</p>	<p align="center">No Change</p>	<p align="center">No Change</p>
<p>(b) The specimen set shall consist of at least three specimens having different nominal pipe diameters and overlay thicknesses. They shall include the minimum and maximum nominal pipe diameters for which the examination procedure is applicable. Pipe diameters within a range of 0.9 to 1.5 times a nominal diameter shall be considered equivalent. If the procedure is applicable to pipe diameters of 24 in. or larger, the specimen set must include at least one specimen 24 in. or larger but need not include the maximum diameter. The specimen set must include at least one specimen with overlay thickness within -0.1 in. to +0.25 in. of the</p>	<p align="center">No Change</p>	<p>(b) The specimen set shall consist of at least three specimens having different nominal pipe diameters and overlay thicknesses. They shall include the minimum and maximum nominal pipe diameters for which the examination procedure is applicable. Pipe diameters within a range of 0.9 to 1.5 times a nominal diameter shall be considered equivalent. If the procedure is applicable to pipe diameters of 24 in. or larger, the specimen set must include at least one specimen 24 in. or larger but need not include the maximum diameter. The specimen set shall include specimens with overlay thickness within +0.1 in. of the minimum</p>

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SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
maximum nominal overlay thickness for which the procedure is applicable.		nominal overlay thickness and within - 0.25 in. of the maximum nominal overlay thickness for which the procedure is applicable.
(c) The surface condition of at least two specimens shall approximate the roughest surface condition for which the examination procedure is applicable.	No Change	No Change
<i>(d) Flaw Conditions</i>		
<p>(1) <i>Base metal flaws.</i> All flaws must be cracks in or near the butt weld heat-affected zone, open to the inside surface, and extending at least 75% through the base metal wall. Flaws may extend 100% through the base metal and into the overlay material; in this case, intentional overlay fabrication flaws shall not interfere with ultrasonic detection or characterization of the cracking. Specimens containing IGSCC shall be used when available.</p>	<p>(1) Base metal flaws. All flaws must be in or near the butt weld heat-affected zone, open to the inside surface, and extending at least 75% through the base metal wall. Intentional overlay fabrication flaws shall not interfere with ultrasonic detection or characterization of the cracking. Specimens containing IGSCC shall be used when available. At least 70 percent of the flaws in the detection and sizing tests shall be cracks. Alternative flaw mechanisms, if used, shall provide crack-like reflective characteristics and shall be limited by the following:</p> <p>(a) Flaws shall be limited to when implantation of cracks precludes obtaining a realistic ultrasonic response.</p> <p>(b) Flaws shall be semielliptical with a tip width of less than or equal to 0.002 inches.</p>	<p>(1) Base metal flaws. All flaws must be in or near the butt weld heat-affected zone, open to the inside surface, and extending at least 75% through the base metal wall. Intentional overlay fabrication flaws shall not interfere with ultrasonic detection or characterization of the base metal flaws. Specimens containing IGSCC shall be used when available. At least 70 percent of the flaws in the detection and sizing tests shall be cracks and the remainder shall be alternative flaws. Alternative flaw mechanisms, if used, shall provide crack-like reflective characteristics and shall be limited by the following:</p> <p>(a) Flaws shall be limited to when implantation of cracks precludes obtaining an effective ultrasonic response.</p> <p>(b) Flaws shall be semielliptical with a tip width of less than or equal to 0.002 inches.</p>

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<p align="center">SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY</p>	<p align="center">PROPOSED CODE CASE N-654 (Provided for Information Only)</p>	<p align="center">PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements</p>
<p>(2) <i>Overlay fabrication flaws.</i> At least 40% of the flaws shall be non-crack fabrication flaws (e.g., sidewall lack of fusion or laminar lack of bond) in the overlay or the pipe-to-overlay interface. At least 20% of the flaws shall be cracks. The balance of the flaws shall be of either type.</p>	<p align="center">No Change</p>	<p align="center">No Change</p>
<p><i>(e) Detection Specimens</i></p>		
<p>(1) At least 20% but less than 40% of the flaws shall be oriented within $\pm 20^\circ$ of the pipe axial direction. The remainder shall be oriented circumferentially. Flaws shall not be open to any surface to which the candidate has physical or visual access. The rules of IWA-3300 shall be used to determine whether closely spaced flaws should be treated as single or multiple flaws.</p>	<p>(1) At least 20% but less than 40% of the base metal flaws shall be oriented within $\pm 20^\circ$ of the pipe axial direction. The remainder shall be oriented circumferentially. Flaws shall not be open to any surface to which the candidate has physical or visual access.</p>	<p>(1) At least 20% but less than 40% of the base metal flaws shall be oriented within $\pm 20^\circ$ deg. of the pipe axial direction. The remainder shall be oriented circumferentially. Flaws shall not be open to any surface to which the candidate has physical or visual access.</p>
<p>(2) Specimens shall be divided into base and over-layer grading units. Each specimen shall contain one or both types of grading units.</p>	<p>(2) Specimens shall be divided into base metal and overlay fabrication grading units. Each specimen shall contain one or both types of grading units. Flaws shall not interfere with ultrasonic detection or characterization of other flaws.</p>	<p>(2) Specimens shall be divided into base metal and overlay fabrication grading units. Each specimen shall contain one or both types of grading units. Flaws shall not interfere with ultrasonic detection or characterization of other flaws.</p>
<p><i>(a)(1)</i> A base grading unit shall include at least 3 in. of the length of the overlaid weld. The base grading unit includes the outer 25% of the overlaid weld and base metal on both sides. The base grading unit shall not include the inner 75% of the overlaid weld and base metal overlay</p>	<p><i>(a)(1)</i> A base metal grading unit shall include at least 1 in. of the length of the overlaid weld. The base metal grading unit includes the outer 25% of the overlaid weld and base metal on both sides. The base metal grading unit shall not include the inner 75% of the overlaid weld and base</p>	<p><i>(a)(1)</i> A base metal grading unit shall include at least 1 in. of the length of the overlaid weld. The base metal grading unit includes the outer 25% of the overlaid weld. The base metal grading unit shall not include the inner 75% of the overlaid weld and base metal overlay</p>

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
material, or base metal-to-overlay interface.	metal overlay material, or base metal-to-overlay interface.	material, or base metal-to-overlay interface.
(a)(2) When base metal cracking penetrates into the overlay material, the base grading unit shall include the overlay metal within 1 in. of the crack location. This portion of the overlay material shall not be used as part of any overlay grading unit.	(a)(2) When base metal cracking penetrates into the overlay material, the base metal grading unit shall not be used as part of any overlay fabrication grading unit.	<u>(a)(2) When base metal flaws penetrate into the overlay material, the base metal grading unit shall not be used as part of any overlay fabrication grading unit.</u>
(a)(3) When a base grading unit is designed to be unflawed, at least 1 in. of unflawed overlaid weld and base metal shall exist on either side of the base grading unit. The segment of weld length used in one base grading unit shall not be used in another base grading unit. Base grading units need not be uniformly spaced around the specimen.	(a)(3) Sufficient unflawed overlaid weld and base metal shall exist on all sides of the grading unit to preclude interfering reflections from adjacent flaws.	(a)(3) Sufficient unflawed overlaid weld and base metal shall exist on all sides of the grading unit to preclude interfering reflections from adjacent flaws.
(b)(1) An overlay grading unit shall include the overlay material and the base metal-to-overlay interface of at least 6 sq. in. The overlay grading unit shall be rectangular, with minimum dimensions of 2 in.	(b)(1) An overlay fabrication grading unit shall include the overlay material and the base metal-to-overlay interface for a length of at least 1 in.	(b)(1) An overlay fabrication grading unit shall include the overlay material and the base metal-to-overlay interface for a length of at least 1 in.
(b)(2) An overlay grading unit designed to be unflawed shall be surrounded by unflawed overlay material and unflawed base metal-to-overlay interface for at least 1 in. around its entire perimeter. The specific area used in one overlay grading unit shall not be used in another overlay grading unit. Overlay grading units need not be spaced uniformly about the	(b)(2) Overlay fabrication grading units designed to be unflawed shall be separated by unflawed overlay material and unflawed base metal-to-overlay interface for at least 1 in. at both ends. Sufficient unflawed overlaid weld and base metal shall exist on both sides of the overlay fabrication grading unit to preclude interfering reflections from adjacent flaws. The	(b)(2) Overlay fabrication grading units designed to be unflawed shall be separated by unflawed overlay material and unflawed base metal-to-overlay interface for at least 1 in. at both ends. Sufficient unflawed overlaid weld and base metal shall exist on both sides of the overlay fabrication grading unit to preclude interfering reflections from adjacent flaws. The

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
specimen.	specific area used in one overlay fabrication grading unit shall not be used in another overlay fabrication grading unit. Overlay fabrication grading units need not be spaced uniformly about the specimen.	specific area used in one overlay fabrication grading unit shall not be used in another overlay fabrication grading unit. Overlay fabrication grading units need not be spaced uniformly about the specimen.
(b)(3) Detection sets shall be selected from Table VIII-S2-1. The minimum detection sample set is five flawed base grading units, ten unflawed base grading units, five flawed overlay grading units, and ten unflawed overlay grading units. For each type of grading unit, the set shall contain at least twice as many unflawed as flawed grading units.	(b)(3) Detection sets shall be selected from Table VIII-S2-1. The minimum detection sample set is five flawed base metal grading units, ten unflawed base metal grading units, five flawed overlay fabrication grading units, and ten unflawed overlay fabrication grading units. For each type of grading unit, the set shall contain at least twice as many unflawed as flawed grading units. For initial procedure qualification, detection sets shall include the equivalent of three personnel qualification sets. To qualify new values of essential variables, at least one personnel qualification set is required.	(b)(3) Detection sets shall be selected from Table VIII-S2-1. The minimum detection sample set is five flawed base metal grading units, ten unflawed base metal grading units, five flawed overlay fabrication grading units, and ten unflawed overlay fabrication grading units. For each type of grading unit, the set shall contain at least twice as many unflawed as flawed grading units. For initial procedure qualification, detection sets shall include the equivalent of three personnel qualification sets. To qualify new values of essential variables, at least one personnel qualification set is required.
<i>(f) Sizing Specimen</i>		
(1) The minimum number of flaws shall be ten. At least 30% of the flaws shall be overlay fabrication flaws. At least 40% of the flaws shall be cracks open to the inside surface.	(1) The minimum number of flaws shall be ten. At least 30% of the flaws shall be overlay fabrication flaws. At least 40% of the flaws shall be cracks open to the inside surface. For initial procedure qualification, sizing sets shall include the equivalent of three personnel qualification sets. To qualify new values of essential variables, at least one personnel qualification set is required.	(1) The minimum number of flaws shall be ten. At least 30% of the flaws shall be overlay fabrication flaws. At least 40% of the flaws shall be open to the inside surface. For initial procedure qualification, sizing sets shall include the equivalent of three personnel qualification sets. To qualify new values of essential variables, at least one personnel qualification set is required.

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
(2) At least 20% but less than 40% of the flaws shall be oriented axially. The remainder shall be oriented circumferentially. Flaws shall not be open to any surface to which the candidate has physical or visual access.	<p align="center">No Change</p>	<p align="center">No Change</p>
(3) Base metal cracking used for length sizing demonstrations shall be oriented circumferentially.	<p align="center">No Change</p>	(3) Base metal flaws used for length sizing demonstrations shall be oriented circumferentially.
(4) Depth sizing specimen sets shall include at least two distinct locations where cracking in the base metal extends into the overlay material by at least 0.1 in. in the through-wall direction.	<p align="center">No Change</p>	(4) Depth sizing specimen sets shall include at least two distinct locations where flaws in the base metal extend into the overlay material by at least 0.1 in. in the through-wall direction.

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
2.0 CONDUCT OF PERFORMANCE DEMONSTRATION		
The specimen inside surface and identification shall be concealed from the candidate. All examinations shall be completed prior to grading the results and presenting the results to the candidate. Divulgence of particular specimen results or candidate viewing of unmasked specimens after the performance demonstration is prohibited.	The specimen inside surface and identification shall be concealed from the candidate. All examinations shall be completed prior to grading the results and presenting the results to the candidate. Divulgence of particular specimen results or candidate viewing of unmasked specimens after the performance demonstration is prohibited. The overlay fabrication flaw test and the base metal flaw test may be performed separately.	The specimen inside surface and identification shall be concealed from the candidate. All examinations shall be completed prior to grading the results and presenting the results to the candidate. Divulgence of particular specimen results or candidate viewing of unmasked specimens after the performance demonstration is prohibited. The overlay fabrication flaw test and the base metal flaw test may be performed separately.
2.1 Detection Test.		
Flawed and unflawed grading units shall be randomly mixed. Although the boundaries of specific grading units shall not be revealed to the candidate, the candidate shall be made aware of the type or types of grading units (base or overlay) that are present for each specimen.	Flawed and unflawed grading units shall be randomly mixed. Although the boundaries of specific grading units shall not be revealed to the candidate, the candidate shall be made aware of the type or types of grading units (base metal or overlay fabrication) that are present for each specimen.	Flawed and unflawed grading units shall be randomly mixed. Although the boundaries of specific grading units shall not be revealed to the candidate, the candidate shall be made aware of the type or types of grading units (base metal or overlay fabrication) that are present for each specimen.
2.2 Length Sizing Test		
(a) The length sizing test may be conducted separately or in conjunction with the detection test.	No Change	No Change
(b) When the length sizing test is conducted in conjunction with the detection test and the detected flaws do not satisfy the requirements of 1.1(f), additional specimens shall be provided to the	No Change	No Change

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
be sized shall be identified to the candidate. The candidate shall determine the length of the flaw in each region.		
(c) For a separate length sizing test, the regions of each specimen containing a flaw to be sized shall be identified to the candidate. The candidate shall determine the length of the flaw in each region.	No Change	No Change
(d) For flaws in base grading units, the candidate shall estimate the length of that part of the flaw that is in the outer 25% of the base wall thickness.	(d) For flaws in base metal grading units, the candidate shall estimate the length of that part of the flaw that is in the outer 25% of the base metal wall thickness.	(d) For flaws in base metal grading units, the candidate shall estimate the length of that part of the flaw that is in the outer 25% of the base metal wall thickness.
2.3 Depth Sizing Test.		
For the depth sizing test, 80% of the flaws shall be sized at a specific location on the surface of the specimen identified to the candidate. For the remaining flaws, the regions of each specimen containing a flaw to be sized shall be identified to the candidate. The candidate shall determine the maximum depth of the flaw in each region.	The candidate shall determine the depth of the flaw in each region.	The candidate shall determine the depth of the flaw in each region.

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
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3.0 ACCEPTANCE CRITERIA

3.1 Detection Acceptance Criteria.

Examination procedures, equipment, and personnel are qualified for detection when the results of the performance demonstration satisfy the acceptance criteria of Table VIII-S2-1 for both detection and false calls. The criteria shall be satisfied separately by the demonstration results for base grading units and for overlay grading units.	Examination procedures are qualified for detection when all flaws within the scope of the procedure are detected and the results of the performance demonstration satisfy the acceptance criteria of Table VIII-S2-1 for false calls. Examination equipment and personnel are qualified for detection when the results of the performance demonstration satisfy the acceptance criteria of Table VIII-S2-1 for both detection and false calls. The criteria shall be satisfied separately by the demonstration results for base metal grading units and for overlay fabrication grading units.	Examination procedures are qualified for detection when all flaws within the scope of the procedure are detected and the results of the performance demonstration satisfy the acceptance criteria of Table VIII-S2-1 for false calls. Examination equipment and personnel are qualified for detection when the results of the performance demonstration satisfy the acceptance criteria of Table VIII-S2-1 for both detection and false calls. The criteria shall be satisfied separately by the demonstration results for base metal grading units and for overlay fabrication grading units.
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3.2 Sizing Acceptance Criteria.

Examination procedures, equipment, and personnel are qualified for sizing when the results of the performance demonstration satisfy the following criteria.	No Change	No Change
(a) The RMS error of the flaw length measurements, as compared to the true flaw lengths, is less than or equal to 0.75 inch. The length of base metal cracking is measured at the 75% through-base-metal position.	No Change	(a) The RMS error of the flaw length measurements, as compared to the true flaw lengths, is less than or equal to 0.75 inch. The length of base metal flaws is measured at the 75% through-base-metal position.
(b) All extensions of base metal cracking into the overlay material by at least 0.1 in. are reported as being intrusions into the	This requirement is omitted.	This requirement is omitted.

RELIEF REQUEST RR-36 - ENCLOSURE

SUPPLEMENT 11 QUALIFICATION REQUIREMENTS FOR FULL STRUCTURAL OVERLAY	PROPOSED CODE CASE N-654 (Provided for Information Only)	PDI PROGRAM: Proposed Alternative to Supplement 11 Requirements
overlay material. (c) The RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in.	(b) The RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in.	(b) The RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in.