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Mr. J. A. Hancock
Director, Nuclear Operations
Florida Power Corporation
P. O. Box 14042, Mail Stop C-4
St. Petersburg, Florida 33733

Dear Mr. Hancock:

The Commission has issued the enclosed Amendment No. 33 to Facility Operating License No. DPR-72 for the Crystal River Unit No. 3 Nuclear Generating Plant. The amendment consists of changes to the Technical Specifications in response to your submittal dated February 15, 1980.

This amendment revises the Appendix A Technical Specification requirements for inspection of steam generator tubes in areas which are distinguished by unique operating conditions and/or physical construction. Some portions of your proposed Technical Specifications have been modified to meet our requirements. These modifications have been discussed with and agreed to by your staff.

Copies of our Safety Evaluation and the Notice of Issuance are also enclosed.

Sincerely,

Original signed by
Robert W. Reid

Robert W. Reid, Chief
Operating Reactors Branch #4
Division of Licensing

Enclosures:
1. Amendment No. 33
2. Safety Evaluation
3. Notice

cc w/enclosures: See next page

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UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D.C. 20555

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September 17, 1980

Docket No. 50-302

Docketing and Service Section
Office of the Secretary of the Commission

SUBJECT: CRYSTAL RIVER UNIT NO. 3

Two signed originals of the Federal Register Notice identified below are enclosed for your transmittal to the Office of the Federal Register for publication. Additional conformed copies (12) of the Notice are enclosed for your use.

☐ Notice of Receipt of Application for Construction Permit(s) and Operating License(s).

☐ Notice of Receipt of Partial Application for Construction Permit(s) and Facility License(s): Time for Submission of Views on Antitrust Matters.

☐ Notice of Availability of Applicant's Environmental Report.

☐ Notice of Proposed Issuance of Amendment to Facility Operating License.

☐ Notice of Receipt of Application for Facility License(s); Notice of Availability of Applicant's Environmental Report; and Notice of Consideration of Issuance of Facility License(s) and Notice of Opportunity for Hearing.

☐ Notice of Availability of NRC Draft/Final Environmental Statement.

☐ Notice of Limited Work Authorization.

☐ Notice of Availability of Safety Evaluation Report.

☐ Notice of Issuance of Construction Permit(s).

☒ Notice of Issuance of Facility Operating License(s) or Amendment(s).

☒ Other: Amendment No. 33
Refereneed documents have been provided PDR

Division of Licensing, ORB#4
Office of Nuclear Reactor Regulation

Enclosure:
As Stated

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NRC FORM 102 (1-76)

UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

September 17, 1980

Docket No. 50-302

Mr. J. A. Hancock
Director, Nuclear Operations
Florida Power Corporation
P. O. Box 14042, Mail Stop C-4
St. Petersburg, Florida 33733

Dear Mr. Hancock:

The Commission has issued the enclosed Amendment No. 33 to Facility Operating License No. DPR-72 for the Crystal River Unit No. 3 Nuclear Generating Plant. The amendment consists of changes to the Technical Specifications in response to your submittal dated February 15, 1980.

This amendment revises the Appendix A Technical Specification requirements for inspection of steam generator tubes in areas which are distinguished by unique operating conditions and/or physical construction. Some portions of your proposed Technical Specifications have been modified to meet our requirements. These modifications have been discussed with and agreed to by your staff.

Copies of our Safety Evaluation and the Notice of Issuance are also enclosed.

Sincerely,

Robert W. Reid, Chief
Operating Reactors Branch #4
Division of Licensing

Enclosures:
1. Amendment No. 33
2. Safety Evaluation
3. Notice

cc w/enclosures: See next page

Florida Power Corporation

cc w/enclosure(s):

Mr. S. A. Brandimore
Vice President and General Counsel
P. O. Box 14042
St. Petersburg, Florida 33733

Mr. Wilbur Langely, Chairman
Board of County Commissioners
Citrus County
Iverness, Florida 36250

U. S. Environmental Protection Agency
Region IV Office
ATTN: EIS COORDINATOR
345 Courtland Street, N.E.
Atlanta, Georgia 30308

Director, Technical Assessment
Division
Office of Radiation Programs
(AW-459)
U. S. Environmental Protection Agency
Crystal Mall #2
Arlington, Virginia 20460

Crystal River Public Library
Crystal River, Florida 32629

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Mr. Tom Stetka, Resident Inspector
U.S. Nuclear Regulatory Commission
P. O. Box 2082
Crystal River, Florida 32629

cc w/enclosure(s) & incoming dtd.:
2/15/80

Bureau of Intergovernmental Relations
660 Apalachee Parkway
Tallahassee, Florida 32304

UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

FLORIDA POWER CORPORATION
CITY OF ALACHUA
CITY OF BUSHNELL
CITY OF GAINESVILLE
CITY OF KISSIMMEE
CITY OF LEESBURG
CITY OF NEW SMYRNA BEACH AND UTILITIES COMMISSION, CITY OF NEW SMYRNA BEACH
CITY OF OCALA
ORLANDO UTILITIES COMMISSION AND CITY OF ORLANDO
SEBRING UTILITIES COMMISSION
SEMINOLE ELECTRIC COOPERATIVE, INC.
CITY OF TALLAHASSEE

DOCKET NO. 50-302

CRYSTAL RIVER UNIT 3 NUCLEAR GENERATING PLANT

AMENDMENT TO FACILITY OPERATING LICENSE

Amendment No. 33
License No. DPR-72

1. The Nuclear Regulatory Commission (the Commission) has found that:

   A. The application for amendment by Florida Power Corporation, et al (the licensees) dated February 15, 1980, complies with the standards and requirements of the Atomic Energy Act of 1954, as amended (the Act) and the Commission's rules and regulations set forth in 10 CFR Chapter I;

   B. The facility will operate in conformity with the application, the provisions of the Act, and the rules and regulations of the Commission;

   C. There is reasonable assurance (i) that the activities authorized by this amendment can be conducted without endangering the health and safety of the public, and (ii) that such activities will be conducted in compliance with the Commission's regulations;

   D. The issuance of this amendment will not be inimical to the common defense and security or to the health and safety of the public; and

   E. The issuance of this amendment is in accordance with 10 CFR Part 51 of the Commission's regulations and all applicable requirements have been satisfied.

2. Accordingly, the license is amended by changes to the Technical Specifications as indicated in the attachment to this license amendment, and paragraph 2.C.(2) of Facility Operating License No. DPR-72 is hereby amended to read as follows:

   (2) Technical Specifications

   The Technical Specifications contained in Appendices A and B, as revised through Amendment No. 33, are hereby incorporated in the license. Florida Power Corporation shall operate the facility in accordance with the Technical Specifications.

3. This license amendment is effective as of the date of its issuance.

FOR THE NUCLEAR REGULATORY COMMISSION

Robert W. Reid, Chief
Operating Reactors Branch #4
Division of Licensing

Attachment:
Changes to the Technical
Specifications

Date of Issuance: September 17, 1980

ATTACHMENT TO LICENSE AMENDMENT NO. 33

FACILITY OPERATING LICENSE NO. DPR-72

DOCKET NO. 50-302

Replace the following pages of the Appendix "A" Technical Specifications with the enclosed pages. The revised pages are identified by Amendment number and contain vertical lines indicating the area of change. The corresponding overleaf pages are also provided to maintain document completeness.

Remove Pages	Insert Pages
3/4 4-7 through 3/4 4-10	3/4 4-7 through 3/4 4-10
	3/4 4-12a (new page)
B 3/4 4-3	B 3/4 4-3

SURVEILLANCE REQUIREMENTS (Continued)

b. The first inservice inspection (subsequent to the preservice inspection) of each steam generator shall include:

1. All nonplugged tubes that previously had detectable wall penetrations (>20%), and

2. Tubes in those areas where experience has indicated potential problems.

c. The second and third inservice inspections may be less than a full tube inspection by concentrating (selecting at least 50% of the tubes to be inspected) the inspection on those areas of the tube sheet array and on those portions of the tubes where tubes with imperfections were previously found.

d. Tubes in specific limited areas which are distinguished by unique operating conditions and/or physical construction may be excluded from random samples if all such tubes in the specific area of a steam generator are inspected with the inspection result classification and the corresponding action required as specified in Table 4.4-6. No credit will be taken for these tubes in meeting minimum sample size requirements. Degraded or defective tubes found in these areas will not be considered in determining the inspection results category as long as the mode of degradation is unique to that area and not random in nature.

The results of each sample inspection shall be classified into one of the following three categories:

Category	Inspection Results
C-1	Less than 5% of the total tubes inspected are degraded tubes and none of the inspected tubes are defective.
C-2	One or more tubes, but not more than 1% of the total tubes inspected are defective, or between 5% and 10% of the total tubes inspected are degraded tubes.
C-3	More than 10% of the total tubes inspected are degraded tubes or more than 1% of the inspected tubes are defective.

Note: In all inspections, previously degraded tubes must exhibit significant (>10%) further wall penetrations to be included in the above percentage calculations.

4.4.5.3 Inspection Frequencies - The above-required inservice inspections of steam generator tubes shall be performed at the following frequencies:

a. The first inservice inspection shall be performed after 6 Effective Full Power Months, but within 24 calendar months of initial criticality. Subsequent inservice inspections shall be performed at intervals of not less than 12 nor more than 24 calendar months after the previous inspection. If two consecutive inspections following service under all volatile treatment (AVT) conditions, not including the preservice inspection, result in all inspection results falling into the C-1 category, or if two consecutive inspections demonstrate that previously observed degradation has not continued and no additional degradation has occurred, the inspection interval may be extended to a maximum of once per 40 months.

b. If the inservice inspection of a steam generator, conducted in accordance with Table 4.4-2 and/or Table 4.4-6 requires a third sample inspection whose results fall in Category C-3, the inspection frequency shall be reduced to at least once per 20 months. The reduction in inspection frequency shall apply until a subsequent inspection demonstrates that a third sample inspection is not required.

c. Additional unscheduled inservice inspections shall be performed on each steam generator in accordance with the first sample inspection specified in Table 4.4-2 and/or Table 4.4-6 during the shutdown subsequent to any of the following conditions:

1. Primary-to-secondary tube leaks (not including leaks originating from tube-to-tube sheet welds) in excess of the limits of Specification 3.4.6.2,

2. A seismic occurrence greater than the Operating Basis Earthquake,

3. A loss-of-coolant accident requiring actuation of the engineered safeguards, or

4. A main steam line or feedwater line break.

4.4.5.4 Acceptance Criteria

a. As used in this Specification:

1. Imperfection means an exception to the dimensions, finish or contour of a tube from that required by fabrication drawings

or specifications. Eddy-current testing indications below 20% of the nominal tube wall thickness, if detectable, may be considered as imperfections.

2. Degradation means a service-induced cracking, wastage, wear, or general corrosion occurring on either inside or outside of a tube.

3. Degraded Tube means a tube containing imperfections $\geq$20% of the nominal wall thickness caused by degradation.

4. % Degradation means the percentage of the tube wall thickness affected or removed by degradation.

5. Defect means an imperfection of such severity that it exceeds the plugging limit. A tube containing a defect is defective. Any tube which does not permit the passage of the eddy-current inspection probe shall be deemed a defective tube.

6. Plugging Limit means the imperfection depth at or beyond which the tube shall be removed from service because it may become unserviceable prior to the next inspection and is equal to 40% of the nominal tube wall thickness.

7. Unserviceable describes the condition of a tube if it leaks or contains a defect large enough to affect its structural integrity in the event of an Operating Basis Earthquake, a loss-of-coolant accident, or a steam line or feedwater line break as specified in 4.4.5.3.c, above.

8. Tube Inspection means an inspection of the steam generator tube from the point of entry completely to the point of exit.

b. The steam generator shall be determined OPERABLE after completing the corresponding actions (plug all tubes exceeding the plugging limit and all tubes containing through-wall cracks) required by Table 4.4-2 (and Table 4.4-6, if the provisions of Specification 4.4.5.2.d are utilized).

4.4.5.5 Reports

a. Following each inservice inspection of steam generator tubes, the number of tubes plugged in each steam generator shall be reported to the Commission within 15 days.

SURVEILLANCE REQUIREMENTS (Continued)

b. The complete results of the steam generator tube inservice inspection shall be submitted to the Commission in a Special Report pursuant to Specification 6.9.2 within 12 months following the completion of the inspection. This Special Report shall include:

1. Number and extent of tubes inspected.

2. Location and percent of wall-thickness penetration for each indication of an imperfection.

3. Identification of tubes plugged.

c. Results of steam generator tube inspections which fall into Category C-3 and require prompt notification of the Commission shall be reported pursuant to Specification 6.9.1 prior to resumption of plant operation. The written followup of this report shall provide a description of investigations conducted to determine cause of the tube degradation and corrective measures taken to prevent recurrence.

4.4.5.6 The steam generator shall be demonstrated OPERABLE by verifying steam generator level to be within limits at least once per 12 hours.

TABLE 4.4-6

SPECIFIC LIMITED AREA INSPECTION

1ST SAMPLE INSPECTION OF A "SPECIFIC LIMITED AREA"			2ND SAMPLE INSPECTION OF A "SPECIFIC LIMITED AREA"	
Sample Size	Result	Action Required	Result	Action Required
100% of Area in both S.G.'s	C-1	None	N/A	N/A
	C-2	Plug defective tubes	N/A	N/A
	C-3	Plug defective tubes	N/A	N/A
100% of Area in one S.G.	C-1	None	N/A	N/A
	C-2	Plug defective tubes and inspect 100% of corresponding area in other S.G.	C-1	None
			C-2	Plug defective tubes
			C-3	Plug defective tubes
	C-3	Plug defective tubes and inspect 100% of corresponding area in other S.G.	C-1	None
			C-2	Plug defective tubes
			C-3	Plug defective tubes

imposed during normal operation and by postulated accidents. Operating plants have demonstrated that primary-to-secondary leakage of 1 GPM can be detected by monitoring the secondary coolant. Leakage in excess of this limit will require plant shutdown and an unscheduled inspection, during which the leaking tubes will be located and plugged.

Operational experience has shown that tube defects can be the result of unique operating conditions and/or physical arrangements in specific limited areas of the steam generators (for example, tubes adjacent to the open inspection lane or tubes whose 15th tube support plate hole is not broached but drilled). A full inspection of all of the tubes in such specific limited areas will provide complete assurance that degraded or defective tubes in these areas are detected. Because no credit is taken for these distinctive tubes in the constitution of the first sample or its results, the requirements for the first sample are unchanged. This requirement is essentially equivalent to and meets the intent of the requirements set forth in Regulatory Guide 1.83, "Inservice Inspection of Pressurized Water Reactor Steam Generator Tubes", Rev. 1, July 1975, and does not reduce the margin of safety provided by those requirements.

Wastage-type defects are unlikely with proper chemistry treatment of the secondary coolant. However, even if a defect should develop in service, it will be found during scheduled inservice steam generator tube examinations. Plugging will be required for all tubes with imperfections exceeding the plugging limit of 40% of the tube nominal wall thickness. Steam generator tube inspections of operating plants have demonstrated the capability to reliably detect degradation that has penetrated 20% of the original tube wall thickness.

Whenever the results of any steam generator tubing inservice inspection fall into Category C-3, these results will be promptly reported to the Commission pursuant to Specification 6.9.1 prior to resumption of plant operation. Such cases will be considered by the Commission on a case-by-case basis and may result in a requirement for analysis, laboratory examinations, tests, additional eddy-current inspection, and revision of the Technical Specifications, if necessary.

The steam generator water level limits are consistent with the initial conditions assumptions in the FSAR.

3/4.4.6 REACTOR COOLANT SYSTEM LEAKAGE

3/4.4.6.1 LEAKAGE DETECTION SYSTEMS

The RCS leakage detection systems required by this specification are provided to detect and monitor leakage from the Reactor Coolant Pressure Boundary. These detection systems are consistent with the recommendations of Regulatory Guide 1.45, "Reactor Coolant Pressure Boundary Leakage Detection Systems", May 1973.

3/4.4.6.2 OPERATIONAL LEAKAGE

PRESSURE BOUNDARY LEAKAGE of any magnitude is unacceptable since it may be indicative of an impending gross failure of the pressure boundary. Therefore, the presence of any PRESSURE BOUNDARY LEAKAGE requires the unit to be promptly placed in COLD SHUTDOWN.

Industry experience has shown that, while a limited amount of leakage is expected from the RCS, the UNIDENTIFIED LEAKAGE portion of this can be reduced to a threshold value of less than 1 GPM. This threshold value is sufficiently low to ensure early detection of additional leakage.

The total steam generator tube leakage limit of 1 GPM for all steam generators ensures that the dosage contribution from tube leakage will be limited to a small fraction of Part 100 limits in the event of either a steam generator tube rupture or steam line break. The 1 GPM limit is consistent with the assumptions used in the analysis of these accidents.

The 10 GPM IDENTIFIED LEAKAGE limitation provides allowance for a limited amount of leakage from known sources whose presence will not interfere with the detection of UNIDENTIFIED LEAKAGE by the leakage detection systems.

The CONTROLLED LEAKAGE limit of 10 GPM restricts operation with a total RCS leakage from all RC pump seals in excess of 10 GPM.

UNITED STATES
NUCLEAR REGULATORY COMMISSION
WASHINGTON, D. C. 20555

SAFETY EVALUATION BY THE OFFICE OF NUCLEAR REACTOR REGULATION

SUPPORTING AMENDMENT NO. 33 TO FACILITY OPERATING LICENSE NO. DPR-72

FLORIDA POWER CORPORATION, ET AL

CRYSTAL RIVER UNIT NO. 3 NUCLEAR GENERATING PLANT

DOCKET NO. 50-302

Introduction

By letter dated February 15, 1980, the Florida Power Corporation (the licensee) requested an amendment to Facility Operating License No. DPR-72 for Crystal River Unit No. 3 Nuclear Generating Plant.

The amendment would revise the Technical Specification requirements for inspection of steam generator tubes in areas which are distinguished by unique operating conditions and/or physical construction.

Discussion

Operating experience to date with Babcock and Wilcox (B&W) designed steam generators indicates that tube degradation is most likely to occur in localized areas adjacent to the tube inspection lane. It is believed that degradation preferentially occurs in this area because of the local combination of flow conditions and fluid properties. The current Technical Specifications for steam generator tubes require that 50% of the first sample of tubes selected for inspection (3% of the total number of tubes in all steam generators) be from these areas. The licensee's proposed modification is to define one or more areas in the steam generators where operating experience has indicated that degradation is most likely, and to optionally perform an inspection of all the tubes in these areas. If the first sample inspection were to consist of 100% of the tubes in defined areas in only one steam generator and the results fell into either the C-2 or C-3 Category, then the second sample inspection would consist of 100% of the corresponding area in the other steam generator. If both steam generators are inspected, 100% of defined areas from both steam generators would be included in the first sample inspection. In any case, defective tubes will be plugged. The criteria for the second and third sample inspections for the general steam generator group would be based on the results of the general tube group inspection, independent of the defined group inspection results when the defined group would be 100% inspected. According to the licensee's proposal, the number of tubes inspected in the defined potential problem area(s) would not reduce the number of tubes examined in the associated general inspection; but at the same time, degraded or defective tubes identified in defined potential problem areas would not be used in determining the results category for the general inspection and vice versa, so long as the mode of degradation is unique to that area of the steam generator and not random in nature.

Evaluation

The licensee is proposing that the tubes in the steam generators be classified into two groups: (1) a group of tubes in well-defined areas where operating exper-

ience has indicated that tube degradation is most likely (the defined group) and (2) the remaining tubes in the steam generators. The licensee is also proposing that, at their option, these groups may be subject to different inspection requirements. Specifically, the licensee may or may not elect to perform an inspection of every tube in the defined group in both steam generators. If they elect to perform such an inspection, the balance of the steam generator tubes will be subject to the normal inspection requirements with no reduction of sample size. At the same time, degraded or defective tubes identified within the defined area will only be used to establish the results category for that area, not for the overall population of tubes, as long as the mode of degradation is unique to that area and not random in nature. We have added a statement in the Technical Specifications to clarify the above requirements with respect to mode of degradation and randomness. The licensee has agreed to this revision.

If the licensee elects, however, not to inspect every tube in the defined group in both steam generators, the specifications would require that the normal inspection be performed. In this case, the specifications would require that at least 50% of the tubes inspected be in areas where experience has indicated potential problems. Accordingly, with either option, inspection of tubes in potential problem areas is emphasized. Under the provisions of the licensee's proposed revision, however, all of the tubes in these areas may be inspected. Therefore, we conclude that with the proposed revision the extent of the inspection of tubes in potential problem areas is not diminished and may be increased. In addition, we conclude that the extent of the inspection of the balance of the steam generator tubes is not reduced.

Based upon the foregoing evaluation, we conclude that the inclusion in the Technical Specifications of provisions for electively inspecting all tubes in defined areas does not reduce the effectiveness of the overall steam generator tube inspection program and is therefore acceptable.

Environmental Considerations

We have determined that the amendment does not authorize a change in effluent types or total amounts nor an increase in power level and will not result in any significant environmental impact. Having made this determination, we have further concluded that the amendment involves an action which is insignificant from the standpoint of environmental impact and, pursuant to 10 CFR §51.5(d)(4), that an environmental impact statement or negative declaration and environmental impact appraisal need not be prepared in connection with the issuance of this amendment.

Conclusion

We have concluded, based on the considerations discussed above, that: (1) because the amendment does not involve a significant increase in the probability or consequences of accidents previously considered and does not involve a significant decrease in a safety margin, the amendment does not involve a significant hazards consideration, (2) there is reasonable assurance that the health and safety of the public will not be endangered by operation in the proposed manner, and (3) such activities will be conducted in compliance with the Commission's regulations and the issuance of this amendment will not be inimical to the common defense and security or to the health and safety of the public.

Dated: September 17, 1980

UNITED STATES NUCLEAR REGULATORY COMMISSION

DOCKET NO. 50-302

FLORIDA POWER CORPORATION, ET AL

NOTICE OF ISSUANCE OF AMENDMENT TO FACILITY OPERATING LICENSE

The U. S. Nuclear Regulatory Commission (the Commission) has issued Amendment No. 33 to Facility Operating License No. DPR-72, issued to the Florida Power Corporation, City of Alachua, City of Bushnell, City of Gainesville, City of Kissimmee, City of Leesburg, City of New Smyrna Beach and Utilities Commission, City of New Smyrna Beach, City of Ocala, Orlando Utilities Commission and City of Orlando, Sebring Utilities Commission, Seminole Electric Cooperative, Inc., and the City of Tallahassee (the licensees) which revised the Technical Specifications for operation for the Crystal River Unit No. 3 Nuclear Generating Plant (the facility) located in Citrus County, Florida. The amendment is effective as of the date of issuance.

This amendment revises the Technical Specification requirements for inspection of steam generator tubes in areas which are distinguished by unique operating conditions and/or physical construction.

The application for the amendment complies with the standards and requirements of the Atomic Energy Act of 1954, as amended (the Act), and the Commission's rules and regulations. The Commission has made appropriate findings as required by the Act and the Commission's rules and regulations in 10 CFR Chapter I, which are set forth in the license amendment. Prior public notice of this amendment was not required since the amendment does not involve a significant hazards consideration.

The Commission has determined that the issuance of this amendment will not result in any significant environmental impact and that pursuant to 10 CFR §51.5(d)(4) an environmental impact statement or negative declaration and environmental impact appraisal need not be prepared in connection with issuance of this amendment.

For further details with respect to this action, see (1) the application for amendment dated February 15, 1980, (2) Amendment No. 33 to License No. DPR-72, and (3) the Commission's related Safety Evaluation. All of these items are available for public inspection at the Commission's Public Document Room, 1717 H Street, N. W., Washington, D. C. and at the Crystal River Public Library, Crystal River, Florida. A copy of items (2) and (3) may be obtained upon request addressed to the U. S. Nuclear Regulatory Commission, Washington, D. C. 20555, Attention: Director, Division of Licensing.

Dated at Bethesda, Maryland, this 17th day of September 1980.

FOR THE NUCLEAR REGULATORY COMMISSION

Robert W. Reid, Chief
Operating Reactors Branch #4
Division of Licensing