Docket No. 50-263

OCT 27 1976

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Northern States Power Company
ATTN: Mr. L. O. Mayer, Manager
Nuclear Support Services
414 Nicollet Mall - 8th Floor
Minneapolis, Minnesota 55401

Gentlemen:

In response to your request dated October 1, 1976, the Commission has issued the enclosed Amendment No. 25 to Provisional Operating License No. DPR-22 for the Monticello Nuclear Generating Plant. The amendment consists of changes to the Technical Specifications to incorporate revised operability and testing requirements for shock suppressors (snubbers). During our review, we discussed with your staff various modifications to the changes proposed in your October 1, 1976 submittal. Your staff has agreed to these modifications and they have been incoporated.

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

Sincerely,

Original Signed by:
Dennis L. Ziemann

Dennis L. Ziemann, Chief
Operating Reactors Branch #2
Division of Operating Reactors

Enclosures:
1. Amendment No. 25 to
   License No. DPR-22
2. Safety Evaluation
3. Notice

cc w/enclosures:
See next page

OFFICE	DOR:ORB #2	DOR:ORB #2	OELD	DOR:ORB #2		
SURNAME	RPSnaider:ah	RMDiggs	S H Lewis	DLZiemann		
DATE	10/18/76	10/18/76	10/26/76	10/27/76		

Form AEC-318 (Rev. 9-53) AECM 0240 ☆ U. S. GOVERNMENT PRINTING OFFICE: 1974-526-166

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filing dtd. 10/1/76:
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ATTN: Secretary & Executive Officer
University Campus
Minneapolis, Minnesota 55440

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DATE ➤						

NORTHERN STATES POWER COMPANY

DOCKET NO. 50-263

MONTICELLO NUCLEAR GENERATING PLANT

AMENDMENT TO PROVISIONAL OPERATING LICENSE

Amendment No. 25
License No. DPR-22

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

   A. The application for amendment by Northern States Power Company (the licensee) dated October 1, 1976, 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.

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2. Accordingly, the license is amended by changes to the Technical Specifications as indicated in the attachment to this license amendment.

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

FOR THE NUCLEAR REGULATORY COMMISSION

Original Signed by:
Dennis L. Ziemann

Dennis L. Ziemann, Chief
Operating Reactors Branch #2
Division of Operating Reactors

Attachment:
Changes to the Technical
Specifications

Date of Issuance: [illegible] 1978

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ATTACHMENT TO LICENSE AMENDMENT NO. 25

PROVISIONAL OPERATING LICENSE NO. DPR-22

DOCKET NO. 50-263

Replace the following pages of the Technical Specifications contained in Appendix A of the above-indicated license with the attached pages bearing the same numbers, except as otherwise indicated. The changed areas on the revised pages are reflected by a marginal line.

Remove	Insert
121	121
121A	121A
121B	121B
121C	121C
121D	--
121E	--
138	138
138A	138A

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H. Shock Suppressors (Snubbers)

1. During all modes of operation, except Cold Shutdown and Refueling Shutdown, all snubbers listed in Table 3.6.1 shall be operable except as noted in 3.6.H.2 through 3.6.H.4 below.

2. From and after the time that a snubber is determined to be inoperable, continued reactor operation is permissible only during the succeeding 72 hours unless the snubber is sooner made operable or replaced.

3. If the requirements of 3.6.H.1 and 3.6.H.2 cannot be met, an orderly shutdown shall be initiated and the reactor shall be in a cold shutdown condition within 36 hours.

4. If a snubber listed in Table 3.6.1 is determined to be inoperable while the reactor is in the shutdown or refueling mode, the snubber shall be made operable or replaced prior to reactor startup.

3. The diffuser to lower plenum differential pressure reading on an individual jet pump is 10% or more, less than the mean of all jet pump differential pressures.

H. Shock Suppressors (Snubbers)

The following surveillance requirements apply to all hydraulic snubbers listed in Table 3.6.1:

1. All hydraulic snubbers whose seal material has been demonstrated by operating experience, lab testing, or analysis to be compatible with the operating environment shall be visually inspected. This inspection shall include, but not necessarily be limited to, inspection of the hydraulic fluid reservoir, fluid connections, and linkage connections to the piping and anchor to verify snubber operability in accordance with the following schedule:

No. of Snubbers Found Inoperable During Inspection or During Inspection Interval	Next Required Inspection Interval
0	18 months ± 25%
1	12 months ± 25%
2	6 months ± 25%
3,4	124 days ± 25%
5,6,7	62 days ± 25%
≥ 8	31 days ± 25%

3.0 LIMITING CONDITIONS FOR OPERATION	4.0 SURVEILLANCE REQUIREMENTS
5. Snubbers may be added to safety related systems without prior License Amendment to Table 3.6.1 provided that a revision to Table 3.6.1 is included with the next license amendment request.	The required inspection interval shall not be lengthened more than one step at a time. Snubbers may be categorized in two groups, "accessible" or "inaccessible" based on their accessibility for inspection during reactor operation. These two groups may be inspected independently according to the above schedule. 2. All hydraulic snubbers whose seal materials are other than ethylene propylene or other material that has been demonstrated to be compatible with the operating environment shall be visually inspected for operability every 31 days. 3. Once each refueling cycle, a representative sample of 10 hydraulic snubbers or approximately 10% of the hydraulic snubbers, whichever is less, shall be functionally tested for operability including verification of proper piston movement, lock up, and bleed. For each unit and subsequent unit found inoperable, an additional 10% or ten hydraulic snubbers shall be so tested until no more failures are found or all units have been tested. Snubbers designated in Table 3.6.1 as being especially difficult to remove or located in High Radiation Areas during shutdown are exempt from this requirement. 4. Snubbers may be reclassified as being in or out of High Radiation Areas during shutdown in Table 3.6.1 based on the most recent radiation survey provided that a revision to Table 3.6.1 is included with the next license amendment request.

TABLE 3.6.1 (Page 1 of 2)
SAFETY RELATED SNUBBERS

SNUBBER NO.	SYSTEM	LOCATION	ELEVATION	AZIMUTH (AIRLOCK 0 REF)	HIGH RADIA-TION AREA	DIFFICULT TO REMOVE	ACCESSIBLE -A INACCESSIBLE-I
PS1-H2	MAIN STEAM	DRYWELL	953	071			I
PS1-H3	MAIN STEAM	DRYWELL	950	148			I
PS2-H2	MAIN STEAM	DRYWELL	950	120			I
PS3-H2	MAIN STEAM	DRYWELL	950	240			I
PS4-H3	MAIN STEAM	DRYWELL	950	212			I
RV24-H3	SAFETY-RELIEF	DRYWELL	950	110			I
RV24-H4	SAFETY-RELIEF	DRYWELL	935	100			I
RV24-H4A	SAFETY-RELIEF	DRYWELL	935	100			I
RV24-H5	SAFETY-RELIEF	DRYWELL	935	110			I
RV24A-H4A	SAFETY-RELIEF	DRYWELL	947	048		X	I
RV24A-H7	SAFETY-RELIEF	DRYWELL	953	115			I
RV24A-H8	SAFETY-RELIEF	DRYWELL	939	032			I
RV25-H1	SAFETY-RELIEF	DRYWELL	953	180			I
RV25-H1A	SAFETY-RELIEF	DRYWELL	953	180	X		I
RV25-H2	SAFETY-RELIEF	DRYWELL	948	190		X	I
RV25-H2A	SAFETY-RELIEF	DRYWELL	948	190		X	I
RV25-H3	SAFETY-RELIEF	DRYWELL	934	180	X		I
RV25A-H2	SAFETY-RELIEF	DRYWELL	945	120	X	X	I
RV25A-H2A	SAFETY-RELIEF	DRYWELL	945	120	X	X	I
RV25A-H7	SAFETY-RELIEF	DRYWELL	953	135			I
RV26-H1	SAFETY-RELIEF	DRYWELL	953	200	X		I
RV26-H1A	SAFETY-RELIEF	DRYWELL	953	200			I
RV26-H2	SAFETY-RELIEF	DRYWELL	947	200		X	I
RV26-H2A	SAFETY-RELIEF	DRYWELL	947	200			I
RV26A-H2	SAFETY-RELIEF	DRYWELL	940	250			I
RV26A-H2A	SAFETY-RELIEF	DRYWELL	935	250			I
RV27-H1	SAFETY-RELIEF	DRYWELL	950	320			I
RV27-H1A	SAFETY-RELIEF	DRYWELL	950	230			I
RV27-H5	SAFETY-RELIEF	DRYWELL	945	270			I
RV27-H6	SAFETY-RELIEF	DRYWELL	945	270			I
RV27A-H2A	SAFETY-RELIEF	DRYWELL	953	290			I
RV27A-H3	SAFETY-RELIEF	DRYWELL	953	290			I
RV27A-H9	SAFETY-RELIEF	DRYWELL	938	290			I
SS-1	MAIN STEAM	DRYWELL	953	279	X		I
SS-1AR	RECIRCULATION	DRYWELL	922	315	X	X	I
SS-1BR	RECIRCULATION	DRYWELL	922	135	X	X	I
SS-11	FEEDWATER	DRYWELL	952	302			I
SS-12	FEEDWATER	DRYWELL	952	058			I
SS-13	FEEDWATER	DRYWELL	952	258			I
SS-14	FEEDWATER	DRYWELL	952	096			I
SS-17A	RHR	DRYWELL	964	072	X		I
SS-17B	RHR	DRYWELL	964	072	X		I
SS-18A	RHR	DRYWELL	964	288			I
SS-18B	RHR	DRYWELL	964	288			I
SS-19	RHR	DRYWELL	964	341			I
SS-2	MAIN STEAM	DRYWELL	953	081	X		I
SS-2AR	RECIRCULATION	DRYWELL	927	302	X	X	I

TABLE 3.6.1 (Page 2 of 2)
SAFETY RELATED SNUBBERS

SNUBBER NO.	SYSTEM	LOCATION	ELEVATION	AZIMUTH (AIRLOCK 0 REF)	HIGH RADIATION AREA	DIFFICULT TO REMOVE	ACCESSIBLE -A INACCESSIBLE-I
SS-2BR	RECIRCULATION	DRYWELL	927	122		X	I
SS-20	RHR	DRYWELL	964	019	X		I
SS-3	MAIN STEAM	DRYWELL	950	212			I
SS-3AR	RECIRCULATION	DRYWELL	927	328		X	I
SS-3BR	RECIRCULATION	DRYWELL	927	148		X	I
SS-4	MAIN STEAM	DRYWELL	950	148			I
SS-4AR(A)	RECIRCULATION	DRYWELL	934	302			I
SS-4AR(B)	RECIRCULATION	DRYWELL	934	323			I
SS-4BR(A)	RECIRCULATION	DRYWELL	934	120			I
SS-4BR(B)	RECIRCULATION	DRYWELL	934	149			I
SS-40	HPCI	MAIN STEAM CHASE					I
SS-5AR	RECIRCULATION	DRYWELL	941	315		X	I
SS-5BR	RECIRCULATION	DRYWELL	941	135		X	I
SS-6AR	RECIRCULATION	DRYWELL	953	261	X		I
SS-6BR	RECIRCULATION	DRYWELL	953	099	X		I
SS-7	MAIN STEAM	DRYWELL	953	240	X		I
SS-7AR	RECIRCULATION	DRYWELL	953	323			I
SS-7BR	RECIRCULATION	DRYWELL	953	032			I
SS-8	MAIN STEAM	DRYWELL	953	120	X		I
SS-8AR	RECIRCULATION	DRYWELL	927	270		X	I
SS-8BR	RECIRCULATION	DRYWELL	927	090		X	I
SS-21	RHR	TORUS FL LV - S WALL					A
SS-22	RHR	TORUS FL LV - S WALL					A
SS-23	RHR	B RHR ROOM FL LV					A
SS-24	RHR	A RHR ROOM FL LV					A
SS-25	RHR	TORUS CATWK-SE WALL					A
SS-26	CORE SPRAY	B RHR ROOM FL LVL					A
SS-27	CORE SPRAY	B RHR ROOM FL LVL					A
SS-28A	CORE SPRAY	A RHR ROOM FL LVL					A
SS-28B	CORE SPRAY	A RHR ROOM FL LVL					A
SS-29	RHR	OVER N2 ANALYZER	954			X	A
SS-30	RHR	OVER N2 ANALYZER	954			X	A
SS-31	RHR	TORUS CATWK					A
SS-32A	RHR	A RHR ROOM - BY HX	916			X	A
SS-32B	RHR	A RHR ROOM - BY HX	916			X	A
SS-33	RHR	ABOVE TORUS					A
SS-34	RHR	ABOVE TORUS					A
SS-35	HPCI	HPCI ROOM - N WALL	912			X	A
SS-36A	HPCI	HPCI ROOM - FL LVL					A
SS-36B	HPCI	HPCI ROOM - FL LVL					A
SS-37	HPCI	HPCI ROOM - W WALL	905			X	A
SS-38A	RCIC	RCIC ROOM - W WALL	906			X	A
SS-38B	RCIC	RCIC ROOM - W WALL	906			X	A
SS-41	CORE SPRAY	ABOVE TORUS CATWK	927				A
SS-42	HPCI	ABOVE TORUS RING HDR	906				A

Bases Continued 3.6 and 4.6:

A nozzle-riser system failure could also generate the coincident failure of a jet pump body; however, the converse is not true. The lack of any substantial stress in the jet pump body makes failure impossible without an initial nozzle-riser system failure.

H. Shock Suppressors (Snubbers)

Snubbers are designed to prevent unrestrained pipe motion under dynamic loads as might occur during an earthquake or severe transient, while allowing normal thermal motion during startup and shutdown. The consequence of an inoperable snubber is an increase in the probability of structural damage to piping as a result of a seismic or other event initiating dynamic loads. It is therefore required that all snubbers required to protect the primary coolant system or any other safety system or component be operable during reactor operation.

Because the snubber protection is required only during low probability events, a period of 72 hours is allowed for repairs or replacements. In case a shutdown is required, the allowance of 36 hours to reach a cold shutdown condition will permit an orderly shutdown consistent with standard operating procedures. Since plant startup should not commence with knowingly defective safety related equipment, Specification 3.6.H.4 prohibits startup with inoperable snubbers.

All safety related hydraulic snubbers are visually inspected for overall integrity and operability. The inspection will include verification of proper orientation, adequate hydraulic fluid level and proper attachment of snubber to piping and structures.

The inspection frequency is based upon maintaining a constant level of snubber protection. Thus the required inspection interval varies inversely with the observed snubber failures. The number of inoperable snubbers found during a required inspection determines the time interval for the next required inspection. Inspections performed before that interval has elapsed may be used as a new reference point to determine the next inspection. However, the results of such early inspections performed before the original required time interval has elapsed (nominal time less 25%) may not be used to lengthen the required inspection interval. Any inspection whose results require a shorter inspection interval will override the previous schedule.

Experience at operating facilities has shown that the required surveillance program should assure an acceptable level of snubber performance provided that the seal materials are compatible with the operating environment.

Snubbers containing seal material which has not been demonstrated by operating experience, lab tests or analysis to be compatible with the operating environment should be inspected more frequently (every month) until material compatibility is confirmed or an appropriate changeout is completed.

H. Shock Suppressors (Snubbers) (contd.)

Examination of defective snubbers at reactor facilities and material tests performed at several laboratories has shown that millable gum polyurethane deteriorates rapidly under the temperature and moisture conditions present in many snubber locations. Although molded polyurethane exhibits greater resistance to these conditions, it also may be unsuitable for application in the higher temperature environments. Data are not currently available to precisely define an upper temperature limit for the molded polyurethane. Lab tests and in-plant experience indicate that seal materials are available, primarily ethylene propylene compounds, which should give satisfactory performance under the most severe conditions expected in reactor installations.

To further increase the assurance of snubber reliability, functional tests should be performed once each refueling cycle. These tests will include stroking of the snubbers to verify proper piston movement, lock-up and bleed. Ten percent or ten snubbers, whichever is less, represents an adequate sample for such tests. Observed failures on these samples should require testing of additional units. Snubbers in High Radiation Areas or those especially difficult to remove need not be selected for functional tests provided operability was previously verified. Snubbers are considered especially difficult to remove if they (1) have a rated capacity greater than 50,000 lb, (2) are located greater than 5 feet above the adjacent platform, or (3) located greater than 3 feet below the adjacent platform.

SAFETY EVALUATION BY THE OFFICE OF NUCLEAR REACTOR REGULATION

SUPPORTING AMENDMENT NO. 25 TO PROVISIONAL OPERATING LICENSE NO. DPR-22

NORTHERN STATES POWER COMPANY

MONTICELLO NUCLEAR GENERATING PLANT

DOCKET NO. 50-263

INTRODUCTION

During the summer of 1973, inspections at two reactor facilities revealed a high incidence of inoperable hydraulic shock suppressors (snubbers) manufactured by Bergen Paterson Pipesupport Corporation. As a result of those findings, the Office of Inspection and Enforcement required each operating reactor licensee to immediately inspect all Bergen Paterson snubbers utilized on safety systems and to reinspect them 45 to 90 days after the initial inspection. Snubbers supplied by other manufacturers were to be inspected on a lower priority basis.

Since a long term solution to eliminate recurring failures was not immediately available, the Division of Reactor Licensing sent a letter dated October 1, 1973, to operating facilities (including Monticello) utilizing Bergen Paterson snubbers specifying continuing surveillance requirements and requesting a submittal of proposed Technical Specifications for a snubber surveillance program. On August 15, 1975, Northern States Power Company proposed Technical Specifications for hydraulic snubbers at Monticello. On September 15, 1975, those proposed specifications, as modified, were issued as Amendment No. 12 to Provisional Operating License No. DPR-22. Subsequently, we found that certain modifications to these specifications were necessary. These modifications were discussed with NSP's staff and by letter dated October 1, 1976, NSP proposed modifications to the Monticello Nuclear Generating Plant Technical Specifications.

DISCUSSION

The proposed modifications would:

1. Delete the requirement that the initial snubber inspection be performed within 6 months of the issuance of Amendment No. 12 which was issued on September 15, 1975.

2. Delete the requirement to disassemble two snubbers from a relatively severe environment during each refueling outage.

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EVALUATION

We have completed our review of the proposed changes to the Monticello Technical Specifications. The results of our review of each change follows:

Specification 4.6.H.3 of the Monticello Technical Specifications, issued on September 15, 1975, requires that an initial inspection be performed within 6 months of the date of issuance of that specification. This one time requirement has been satisfied and is no longer appropriate to retain in the specifications. The staff concludes that this specification should be deleted.

The second proposed change deletes the requirement to disassemble two hydraulic shock suppressors from a relatively severe environment during each refueling outage. Based upon the operating experience gained since our initial requirement that two hydraulic shock suppressors be disassembled and inspected at each refueling outage, we have concluded that there is reasonable assurance that degradation of snubber performance will be accompanied by visually discernible evidence of an unacceptable level of performance such as hydraulic fluid leakage at the fluid connections or by an abnormally large decrease in the quantity of hydraulic fluid retained in the hydraulic fluid reservoirs between visual inspections. We have also concluded that the previously required internal inspection of hydraulic shock suppressors, while not providing a greater level of assurance of operability than the required visual inspections, was contributing to the subsequent failure of the inspected snubber because of the added handling and wear on the seals and close internal tolerance of the hydraulic shock suppressors. For these reasons, we conclude that deletion of the requirement for internal hydraulic shock suppressor inspection is acceptable.

ENVIRONMENTAL CONSIDERATION

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 appraisal need not be prepared in connection with the issuance of this amendment.

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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.

Date: OCT 2 [illegible] 1976

OFFICE ➤						
SURNAME ➤						
DATE ➤						

UNITED STATES NUCLEAR REGULATORY COMMISSION

DOCKET NO. 50-263

NORTHERN STATES POWER COMPANY

NOTICE OF ISSUANCE OF AMENDMENT TO PROVISIONAL OPERATING LICENSE

The U. S. Nuclear Regulatory Commission (the Commission) has issued Amendment No. 25 to Provisional Operating License No. DPR-22, issued to Northern States Power Company (the licensee), which revised Technical Specifications for operation of the Monticello Nuclear Generating Plant (the facility) located in Wright County, Minnesota. The amendment is effective as of its date of issuance.

The amendment modified the existing Monticello Technical Specifications to (1) delete the requirement that the initial inspection be performed within 6 months of issuance of Amendment No. 12 which was issued on September 15, 1975, and (2) delete the requirement to disassemble two snubbers during each refueling outage.

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.

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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 October 1, 1976, (2) Amendment No. 25 to License No. DPR-22, 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 Environmental Conservation Library, Minneapolis Public Library, 300 Nicollet Mall, Minneapolis, Minnesota 55401. 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 Operating Reactors.

Dated at Bethesda, Maryland, this 27th day of October, 1976.

FOR THE NUCLEAR REGULATORY COMMISSION

Original Signed by:
Dennis L. Ziemann

Dennis L. Ziemann, Chief
Operating Reactors Branch #2
Division of Operating Reactors

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SURNAME ➤						
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