

## 5.5 Programs and Manuals

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### 5.5.9 Steam Generator (SG) Tube Surveillance Program (continued)

- j) Tube Repair refers to a process that reestablishes tube serviceability. Acceptable tube repairs will be performed by the following processes:
- 1) Laser welded sleeving as described in Westinghouse Technical Report WCAP-14596-P, "Laser Welded Elevated Tube Sheet Sleeves For Westinghouse Model F Steam Generators." March 1996 (W Proprietary)
  - 2) Electrosleeving as described in Framatome Technical Report BAW - 10219P, Revision 4, 12/00, "Electrosleeving Qualifications for PWR Recirculating Steam Generator Tube Repair" and as supplemented by the information provided by ULNRC-04558, dated November 7, 2001. The plugging or repair limit for the pressure boundary portion of Electrosleeves is determined to be 20% through wall of the nominal sleeve wall thickness (as determined by NDE). The 20% plugging or repair limit will apply to inner diameter pits in Regions B and C, however all sleeves with detected ID flaw indications will be removed from service upon detection.  
  
Electrosleeves will not be installed in the outermost periphery tubes of the steam generator bundles where potentially locked tubes would cause high axial loads.
- k) Degraded Sleeve means a sleeve containing imperfections greater than 0% but less than 20% of the nominal wall thickness caused by degradation.

2. The steam generator status shall be determined after completing the corresponding actions (plug or repair by sleeving all tubes exceeding the plugging or repair limit and all tubes containing through-wall cracks) required by Tables 5.5.9-2 and 5.5.9-3.

#### Reports

The contents and frequency of reports concerning the steam generator tube surveillance program shall be in accordance with Specification 5.6.10.

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