

Mano K. Nazar
Site Vice President
Prairie Island Nuclear Generating Plant
Nuclear Management Company, LLC
1717 Wakonade Dr. East • Welch MN 55089

November 16, 2002

10 CFR Part 50 Section 50.55a

U S Nuclear Regulatory Commission Attn: Document Control Desk Washington, DC 20555

PRAIRIE ISLAND NUCLEAR GENERATING PLANT

Docket No. 50-306 License No. DPR-60

Request for Relief No. 9 for the Unit 2 Third 10-year Interval Inservice Inspection Program

On November 15, 1994 we submitted for review our third 10-year Inservice Inspection Examination Plan for Unit 2 and, on April 19, 1995, relief request revisions associated with that plan. The NRC issued its evaluation of the Third 10-year Interval Program Plan on February 22, 1996.

The purpose of this letter is to submit a relief request for "limited examinations" associated with that plan. Attached is Unit 2 Relief Request No. 9, Revision 0 which addresses those limited examinations. We are requesting relief pursuant to 10 CFR Part 50, Section 50.55a(g)(5)(iii) due to the impracticality of obtaining "100%" examination coverage for the affected items.

By letter dated March 21, 1997, we committed to submitting relief requests for "limited" examinations following each refueling outage inspection (whereas the regulation only requires that the relief requests be submitted within 12 months following the end of the inspection interval). We recently identified that we missed one, for the limited examinations encountered in the Spring 2000 Unit 2 refueling outage. Our review has determined that we submitted the requests following each of the other refueling outages since 1997. The attached relief request is for that Spring 2000 outage. We apologize for any inconvenience our failure to previously submit that relief request may have caused.

Rolf

USNRC November 16, 2002 Page 2

In this letter we have made no new Nuclear Regulatory Commission commitments. Please contact Jack Leveille (651-388-1121, Ext. 4142) if you have any questions related to this letter.

Mano K. Nazar

Site Vice President

Prairie Island Nuclear Generating Plant

c: Regional Administrator - Region III, NRC Senior Resident Inspector, NRC NRR Project Manager, NRC Chief Boiler Inspector, State of MN P. Fisher, Hartford Insurance

Enclosure: ISI Relief Request No. 9 (Rev. 0), Prairie Island Unit 2, Third Interval and its attachments

NUCLEAR MANAGEMENT COMPANY PRAIRIE ISLAND UNIT 2, 3RD INTERVAL

INSERVICE INSPECTION EXAMINATION PLAN

ISI Relief Request No. 9 (Rev. 0)

Limited Examination

SYSTEM: Various Category: Various

Class: 1 and 2 Item: Various

Impractical Examination Requirements:

ASME Section XI (1989 no addenda) Code requires full examination of inservice inspection (ISI) components per Table IWB-2500-1, and IWC-2500-1. Reg. Guide 1.147, Rev. 12 endorses Code Case N-460, "Alternative Examination Coverage for Class 1 and Class 2 Welds." This Code Case allows greater than 90% examination coverage of a weld to meet the "essentially 100%" requirement.

NRC Information Notice 98-42 "Implementation of 10 CFR 50.55a(g) Inservice Inspection requirements" Dec. 1, 1998, states, "The NRC has adopted and further refined the definition of 'essentially 100 percent' to mean 'greater than 90 percent' in 10 CFR 50.55a(g)(6)(ii)(A)(2) for required examination coverage of reactor pressure vessel welds. This standard has been applied to all examination of welds or other areas required by ASME Section XI.

The Prairie Island construction permit was issued in 1967. This facility was designed and constructed with limited accessibility due to component configurations and/or physical barriers for which 100% coverage is not achievable on some ISI components required to be examined for the Third Ten Year Interval.

Basis for Relief:

The following 10 CFR 50.55a paragraphs apply to the inservice inspection of components in accordance with the ASME Section XI code:

50.55a(g)(1): For a boiling or pressurized water-cooled nuclear power facility whose construction permit was issued prior to January 1, 1971, components (including supports) must meet the requirements of paragraphs (g) (4) and (5) of this section to the extent practical.

50.55a(g)(4): Throughout the service life of a boiling or pressurized water-cooled nuclear power facility, components (including supports) which are classified as ASME Code Class 1, Class 2, and Class 3 must meet the requirements, except design and access provisions and pre-service examination requirements, set forth in Section XI of editions of the ASME Boiler and Pressure Vessel Code ... to the extent practical within the limitations of design, geometry and materials of construction of the components.

50.55a(g)(5)(iv): Where an examination requirement by the code or addenda is determined to be impractical by the licensee and is not included in the revised inservice inspection program as permitted by paragraph (g)(4) of this section, the basis for this determination must be demonstrated to the satisfaction of the Commission ...

Prairie Island was designed and most components constructed and installed prior to development of ASME XI, therefore design for accessibility and inspection coverage is not, in many cases, sufficient to permit satisfying the current Code requirements. Limitations to inspections are primarily due to obstructions, interferences, and weld joint configurations.

A summary of the limited examinations are described below and included in Table RR-9.

<u>Part A</u>: Category B-B, "Pressure retaining Welds in Vessels other than Reactor Vessels."

Chemical and Volume Control (VC) Weld (W-2), Cap-Integral Tube-sheet: Volumetric coverage limited, due to cap to tube-sheet configuration, to 48.75% for UT examination. See Attachment 1, ISI drawing 2-ISI-34 and Attachment 7, Examination Report Number 2000U138.

<u>Part B:</u> Category B-F, "Pressure retaining dissimilar Metal Welds in Vessels Nozzles."

Reactor Coolant (RC) Weld (W-1) Nozzle to Safe-End: Volumetric coverage limited, due to nozzle-to-safe-end configuration, to 62.5% for UT examination. See Attachment 2, ISO drawing 2-ISI-30A and Attachment 8, Examination Report Number 2000U119.

Part C: Category B-J, "Pressure Retaining Welds in Piping"

Reactor Coolant (RC) Weld (W-13) Nozzle to Pipe: Volumetric coverage limited, due to nozzle to pipe configuration, to 53.75%. See Attachment 3, ISO drawing 2-ISI-5 and Attachment 9, Examination Report Number 2000U125.

Part D: Category C-A, "Pressure retaining Welds in Pressure Vessels"

Steam Generator #21 (SG) Weld (W-E) Shell to transition Cone: Volumetric coverage limited, due to ring support at weld junction, to 11.4%. See Attachment 4, ISO drawing 2-ISI-37A and Attachment 10, Examination Report Number 2000U131.

<u>Part E</u>: Category C-C "Integral attachments for Vessels, Piping, Pumps and Valves"

Safety Injection Pump 22 Supports A (H-1), B (H-2), C (H-3), D (H-4): Surface examination (MT) coverage limited to 83.0% due to inaccessibility of the bottom

of support because of concrete pad interference. See Attachment 5, ISO drawing 2-ISI-60B and Attachments 11 - 14 (Examination Report Numbers 2000M087, 2000M088, 2000M086 and 2000M089).

Residual Heat Exchanger 21, Support A (H-1), and Support B (H-2): Surface examination (PT) coverage limited to 85.2% due to the configuration of the support and concrete pedestal. See Attachment 6, ISO drawing 2-ISI-69A and Attachments 15 & 16 (Exam Report Numbers 2000P054 & 2000P056).

Additional Means of Establishing Pressure Boundary Integrity:

System pressure tests and associated visual inspections (VT-2) required by Section XI are performed at the required frequency to ensure the piping system is capable of maintaining pressure boundary integrity. The B-B category weld was visually examined during a pressure test in 1997, Attachment 26, List of Section XI VT-2 Examinations. The other pressure retaining welds with limited exams were visually examined during pressure tests in 2000, Attachment 27, List of Section XI VT-2 Examinations.

System integrity is monitored during normal plant operation by many direct and indirect methods, e.g., containment radiation monitoring, containment air monitoring, containment sump monitoring, containment temperature monitoring, system walk downs, surveillance testing, etc.

In addition to the UT volumetric examination with limitations for the listed B-F Category weld, the required surface examination (PT) was completed, Attachment 17, Examination Report Number 2000P023.

In addition to the UT volumetric examination with limitations for the listed B-J Category weld, the required surface examination (PT) was completed, Attachment 18, Examination Report Number 2000P037.

In addition to the surface examinations (MT or PT) with limitations of all listed C-C Category integrally attached welds, VT-3 visual examinations were performed, Attachments 19 - 24 (Examination Report Numbers 2000V393, 2000V394, 2000V388, 2000V389, 2000V314, and 2000V313).

Alternate Examination:

Limitations to the required examination coverage have been noted on the applicable ISI examination reports and included in the 2000 ISI Outage Summary Report. NMC will continue to document examination limitations.

NUCLEAR MANAGEMENT COMPANY PRAIRIE ISLAND UNIT 2, 3RD INTERVAL

INSERVICE INSPECTION EXAMINATION PLAN

In-service inspections at Prairie Island Unit 2 have been performed to the maximum extent practical. When examination limitations are encountered, M&MR procedure ISI-LTS-1, "Limitations to NDE," is applied. ISI-LTS-1 (Attachment 25) is used when an ASME Section XI Code required examination results in less than 90% coverage of the required examination volume or area. It requires a review of the procedures to obtain maximum coverage and documentation of the limitation. The procedure also considers whether an alternative method could be used to obtain improved examination coverage required by the Code. This procedure was used for all the items identified above to determine that the maximum examination coverage was achieved.

Limitations to inspections are primarily due to obstructions, interferences, and weld joint configurations. NMC will continue to utilize the most current examination techniques available for future examinations.

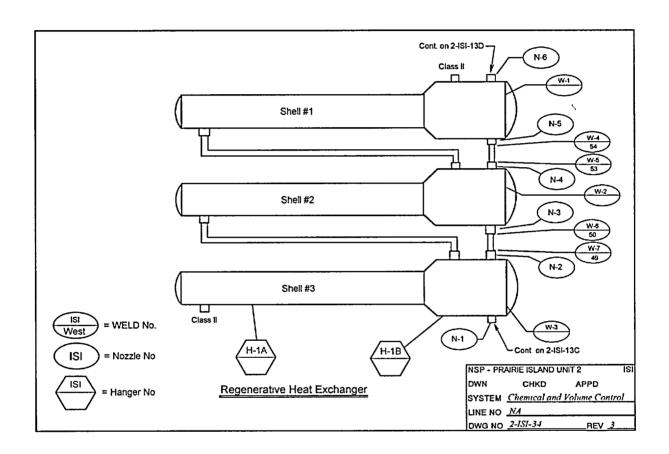
Table RR-9
Limited Examinations - Prairie Island Unit 2 – 2000 Refueling Outage

Category	Item No.	SYSTEM	/ ISO	ুComp ID∦ Summary.#	Description	Method	% Coverage	REPORT	Limitation .
B-B	B2.51	Volume Control	2-ISI-34	W-2 501536	Cap-Integral Tube-sheet	Volumetric UT	48.75%	2000U138	Limited due to cap to tube- sheet configuration.
B-F	B5.40	Reactor Coolant	2-ISI-30A	W-1 501405	Nozzle-Safe End	Volumetric UT	62.5%	2000U119	Limited due to nozzle to safe end configuration.
B-J	B9.31	Reactor Coolant	2-ISI-5	W-13 501935	Nozzle to Pipe	Volumetric UT	53.75%		Limited due to nozzle to pipe configuration.
C-A	C1.10	Steam Generator #21	2-ISI-37A	W-E 502624	Shell to Transition Cone	Volumetric UT	11.4%	2000U131	Limited due to Ring Support at Weld junction.
C-C	C3.30	Safety Injection Pump 22	2-ISI-60B	H-1 501377	Support A	Surface MT	83.0%	2000M087	Bottom of support inaccessible due to concrete pad.
C-C	C3.30	Safety Injection Pump 22	2-ISI-60B	H-2 501385	Support B	Surface MT	83.0%	2000M088	Bottom of support inaccessible due to concrete pad.
C-C	C3.30	Safety Injection Pump 22	2-ISI-60B	H-3 501390	Support C	Surface MT	83.0%	2000M086	Bottom of support inaccessible due to concrete pad.
C-C	C3.30	Safety Injection Pump 22	2-ISI-60B	H-4 501396	Support D	Surface MT	83.0%	2000M089	Bottom of support inaccessible due to concrete pad.

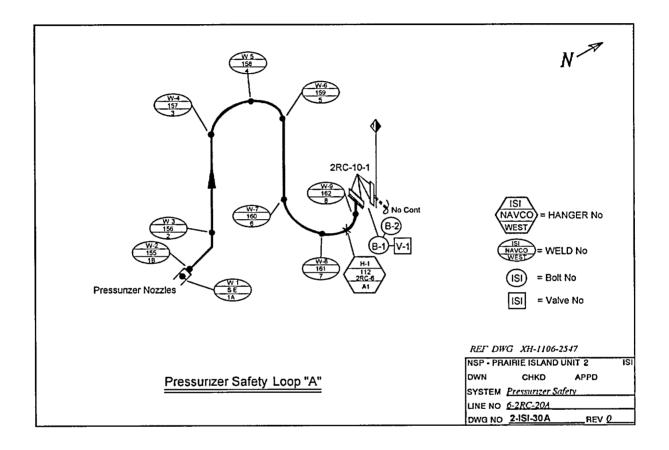
Table RR-9 Limited Examinations - Prairie Island Unit 2 – 2000 Refueling Outage

		SYSTEM		Comp ID Summary #					Limitation
C-C	C3.10	Residual Heat Exchanger 21	2-ISI-69A	H-1 501412	Support A	Surface PT	85.2%	2000P054	Limited PT examination due to configuration of support and concrete pedestal.
C-C	C3.10	Residual Heat Exchanger 21	2-ISI-69A	H-2 501419	Support B	Surface PT	85.2%	2000P056	Limited PT examination due to configuration of support and concrete pedestal.

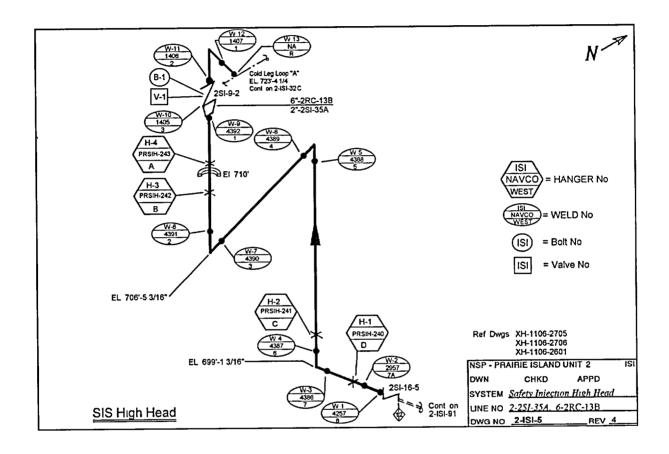
Attachment 1, ISO Drawing 2-ISI-34



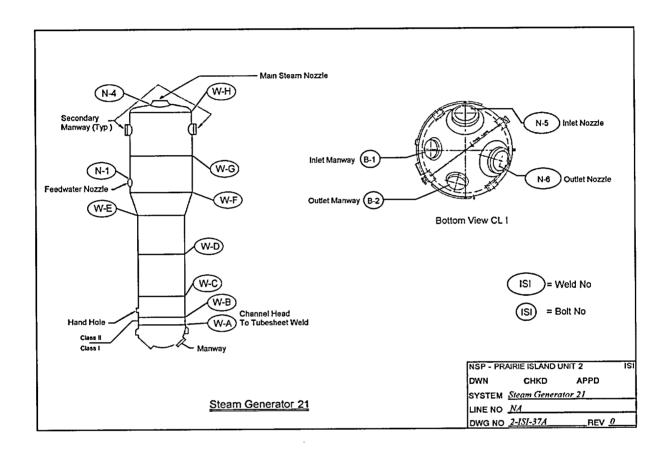
Attachment 2, ISO Drawing 2-ISI-30A



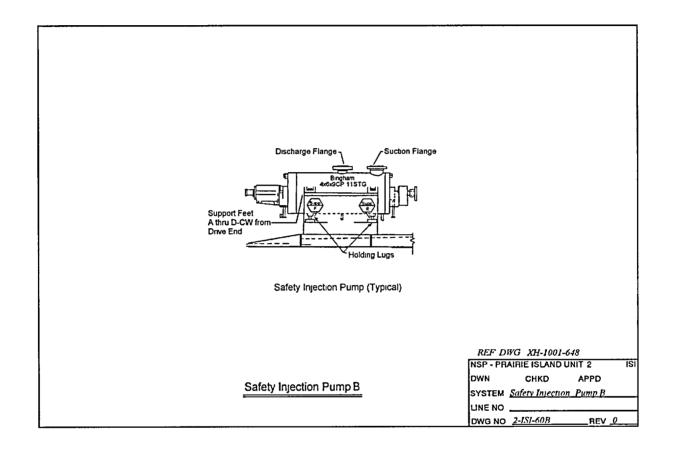
Attachment 3, ISO Drawing 2-ISI-5



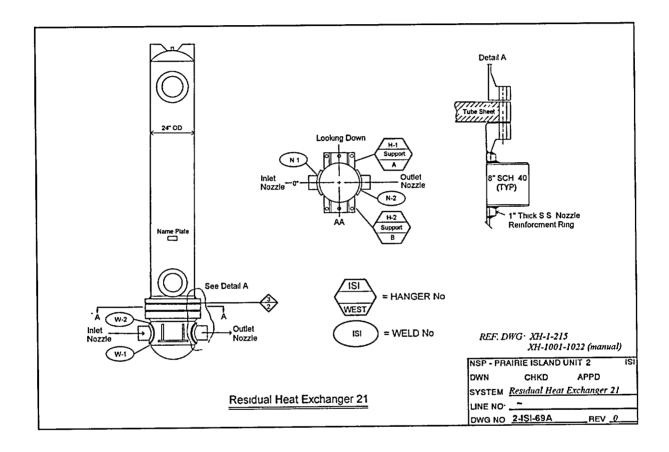
Attachment 4, ISO Drawing 2-ISI-37A



Attachment 5, ISO Drawing 2-ISI-60B



Attachment 6, ISO Drawing 2-ISI-69A



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Attachment 7, Page 1st 4



Limitation Record

Report No:

2000U138

Site/Unit: Summary No.:

NSP / 501536

Procedure: Procedure Revision/FC: ISI-UT-16

Examination For:

ISI

Work Order No:

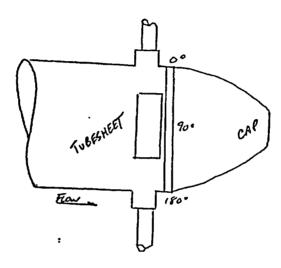
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Description of Limitation:

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Sketch of Limitation:

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Limitations removal requirements:

None

Radiation field: 200 mR / hr

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Examiner N/A	Level N/A	Signature /		Site Review Kinney, Charles R.	Signature Date
Other N/A	Level N/A	, Signature		ANII Review Heater, Stephen B.	Signature Date Study Status 5-17-00



Determination of Percent Coverage for UT Examinations - Pipe

Site/Unit:	NSP	,	Pl2		Procedure:	ICI UT 40		Report No:	2000	U138
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Attachment 7
Page 3 of 4



Supplemental Report

Report No.: 2000U138

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Examiner: Blechinger, Todd P. TPB

TPB Lon

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Reviewer: Halling, David A.

Level: N/A Site Review: Kinney, Charles R.
Level: N/A ANII Review: Heater, Stephen B.

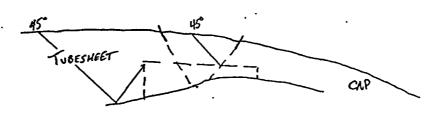
Date: 5/11/00 Date: 5/12/00

Other: N/A Level: N/A ANII Review Heater, Stephen B. Date: 5

Comments: Coverage Plot.

No additional coverage obtained with 60 degree shear exam.

Skelch or Photo: G:VDDEAL504P12RF020004P12 SUPPLEMENTALVP12 SUPPLEMENTAL UT:2000U1



Attachment 7 Page 4 of 4

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Level N/A

Signature

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Date ANII Review

Heater, Stephen B.

Attachment 8 Page 1 of 5

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NSP	
Site/Unit:	
Summary No.:	

Uitrasonic Indication Report

Procedure: (**ISI-UT-16** Procedure Revision/FC: 13

0000232

Report No.: 2000U119

Wmax

Search Unit Angle:

Examination For:

Wo Location: Top Dead Center Lo Location: Centerline of Weld

NSP

501405

ISI

Piping Welds O Ferritic Vessels > 2"T

Other

Work Order No.:

MP **Metal Path** Wmax Distance From Wo To S.U. At Maximum Response RBR Remaining Back Reflection WI Distance From Wo At Of Max (Forward) Distance From Datum W2 Distance From Wo At Of Max (Forward)

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SAMPLE	INDICATION

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Examiner Level | Date Reviewer Date Blechinger, Todd P. 5/3/2000 Halling, David A. Examiner Level # Date Site Review Klipela, Mathew F. 5/3/2000 Kinney, Charles R. Other Level N/A Date ANII Review N/A Heater, Stephen B.

Attachment 8 Page 2 of 5



Supplemental Report

Report No.: 2000U119

Page:

Summary No.: 501405

Examiner: Blechinger, Todd P. July . St.

Reviewer: Halling, David A.

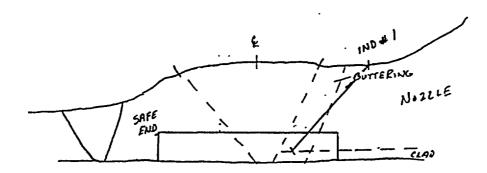
Examiner: Klipela, Mathew F. Other: N/A

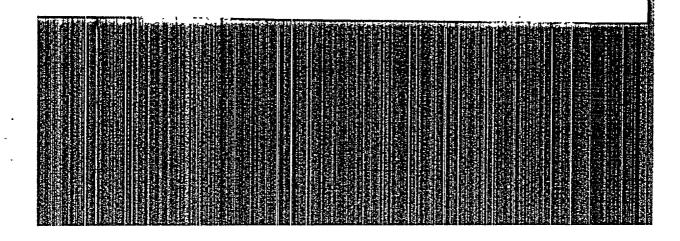
Level: N/A

Site Review: Kinney, Charles R. ANII Review: Heater, Stephen B.

Comments: Indication #1 - Clad Interface Geometry

Sketch or Photo: G.NDDEAL50PI2RF02000PI2 SUPPLEMENTAL VTI2000U1

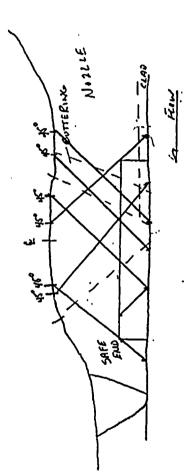




10 20000119 ŏ Report No.: 0000232 **Limitation Record** · Procedure: Procedure Revision/FC: Work Order No: P12 501405 NSP Description of Limitation Site/Unit: Summary No.: Examination For:

Coverage Plot

G.VDDEALSOPIZRFO2000PIZ SUPPLEMENTALPIZ SUPPLEMENTAL UT/2000U1 Sketch of Limitation:



Limitations removal requirements:

None

Radiation field. 25 mR / hr

Examiner	Level 11	Signature A	Date Reviewer	Signature , pate
Blechinger, Todd P.	Todd P. /	1 2 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	6/3/2000 Halling, David A.	1 DA. H. B. B. 5/140
Examiner	Level II	Signature	Date Site Review	Signature
Klipela, Mathew F.	hew F. /	the fortheth	6/3/2000 Kinney, Charles R.	1 (My Granding) 5/14/0
Other	Level N/A	. Signature	Date ANII Review	Signature Date
N/A	1		Heater, Stephen B.	1 Charles That I 3.160



Determination of Percent Coverage for UT Examinations - Pipe

								Report No.:	200	0U11	9
Site/Unit:	NSP /	P12		rocedure.		ISI-UT-16		Page:	5	of	5
ummary No:		1405	Procedure Rev	vision/FC:	13			•		-	
nination For:		ISI	Work C	Order No.:		0000232					
45 don											
45 deg	400.000	O/ Lameth V	5 2 000	9/	• •	. 400 –		****	_	_	-
Scan 1 _	100.000	_ % Length X _	62.000	_ % volume o	t length	100 = <u> </u>	52.000	% total fo	or Scan	7	
Scan 2	100.000	% Length X _	46.000	% volume o	f length	/100 =	46.000	% total fo	or Scan	2	
Scan 3	100.000	_ % Length X	76.000	% volume o	f length	1100 =	76.000	% total fo	or Scan	3	
Scan 4	100.000	_ % Length X _	76.000	% volume o	f length i	100 = _	76.000	% total fo	or Scan	4	
Ad	id totals and	divide by # sca	ns = 62.500	% total fo	r 45 dea	1					
• 10		aivido by b soc		_	. 40 008						
											1
Other deg -		(to be used for a	umnlemental ec	ane)							
		w is for coverage	••	-	e 45 dec	scans					
7770 00111 10 1											
Scan 1	0.000	% Length X		% volume	of length	/100=_		% total	for Scar	ı 1	
Scan 2	0.000	% Length X		% volume	of length	/100 = _		% total	for Scar	12	
Scan 3	0.000	% Length X		_ % volume	of length	/100 = _		% total	for Scar	13	
Scan 4	0.000	% Length X		% volume	of length	/100 = _		% total	for Scar	14	
Percent con	nplete cover	age									
Add totals to	r each econ r	equired and divid	ia hw # of econe	to determine							
		complete exam	ic by ir or scars	to determine	•				•	-	
	,, ,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,										
Example - 45 91% coverage	5 deg scan 1 ge for scan 1	= 63% plus supp volume. Repeat	lemental 60 deg for the remainin	scan 1 = 289 g scans, add	% (of rer together	maining red and divide	puired sca by the #	in volume) for of scans (typic	lotal of ally 4).		
Site Field Su	pervisor:	(An	minu	<u> </u>	Date: _	5/16/	100				

Attochment 8 Page 5 & 5

Temp. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 "F Couplant: Sonotrace 40 Batch No.: # Angle Used 0 45 45T 60 Lo Location: Top Dead Center Wo Location: Centerline of We Scanning dB N/A 38.5 53.0 51.0	Summary No.: 501935 Examination For: ISI Applicable Code: 1989 Description: Nozzle to Pipe System ID: RC Component ID: W-13 Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: rigle Used 0 45 45T 60	Procedure Revis Work Ord	der No.: Drawing No :	/ 0000232 2-ISI- 5	Rep	Page: 1	of <u>3</u>
Summery No.	Summary No.: 501935 Examination For: ISI Applicable Code: 1989 Description: Nozzle to Pipe System ID: RC Component ID: W-13 Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: rigle Used 0 45 45T 60	Procedure Revis Work Ord	der No.: Drawing No :	/ 0000232 2-ISI- 5			
Examination For: ISI Work Order No.: 0000232 Applicable Code: 1989 ISO Drawing No: 2.1SI- 5 Location: CONTAI Description: Nozzle to Pipe System ID: RC Component ID: W-13 Size/Length: 6" Thick/Dia: 2.0" T Limitations: *See Comments Serial No.: 3356 Surface Temp.: 95 "F Couplant: Sonotrace 40 Batch No.: a remp. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 "F Couplant: Sonotrace 40 Batch No.: a remp. Tool MFG: N/A 38.5 \$53.0 \$51.0 Lo Location: Top Dead Center Wo Location: Centerline of We canning dB N/A 38.5 \$53.0 \$51.0 Lo Location: Top Dead Center Wo Location: Centerline of We canning dB N/A 38.5 \$53.0 \$51.0 Location: Downstream Downstream CW CCW COWN Order No.: 180 Downstream CW CCW COWN Downstream CW CCW COWN Description: No.: 2.000 CA131, 2000 CA132 Examination Surface: Inside Downstream CW CCW COWN Downstream CW CCW COWN Description: No.: 2.000 CA131, 2000 CA132 Examination Surface: Inside Downstream CW CCW COWN Downstream CW CCW COWN Description: No.: 2.000 CA131, 2000 CA132 Examination Surface: Inside Downstream CW CCW COWN Downstream CW CCW COWN Description: No.: 2.000 CA131, 2000 CA132 Examination Surface: Inside Downstream CW CCW COWN Downstream CW CCW COWN Description: No.: 2.000 CA131, 2000 CA132 Examination Surface: Inside Downstream CW CCW COWN Downstream CW CCW COWN Description: No.: 2.1SI- 5 Location: 2.00 T COWN CW COWN Description: No.: 2.1SI- 5 Location: 2.00 T COWN CW	Examination For: ISI Applicable Code: 1989 Description: Nozzle to Pipe System ID: RC Component ID: W-13 Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: rgle Used 0 45 45T 60	Work Ord	der No.: Drawing No :	0000232 2-ISI- 5		Location: COM	TAINMENT
Applicable Code: 1989	Applicable Code: 1989 Description: Nozzle to Pipe System ID: RC Component ID: W-13 . Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: rgle Used 0 45 45T 60	ISO	Drawing No :	2-ISI- 5		Location: COM	ITAINMENT
Description: Nozzle to Pipe System ID: RC Component ID: W-13	Description: Nozzle to Pipe System ID: RC Component ID: W-13 . Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: rgle Used 0 45 45T 60					Location: CON	ITAINMEN'
System ID: RC Component ID: W-13 Size/Length: 6" Thick/Dia: 2.0" T Limitations: See Comments Serial No.: 3356 Surface Temp.: 95 "F Couplant: Sonotrace 40 Batch No.: 48 properties of the canning dB N/A 33.5 53.0 51.0 Lo Location: Top Dead Center Wo Location: Centerline of We canning dB N/A 33.5 53.0 51.0 Cal Sheet No.: 2000CA131, 2000CA132 Examination Surface: Inside Outdication(s): Yes No Scan Coverage WRT Weld: Upstream Downstream CWD CCWD Downments: No scans on cold leg and weld due to configuration.	System ID: RC Component ID: W-13 Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: gle Used 0 45 45T 60	2350 Cut. 7	Size/Length;	6"			
Component ID: W-13	Component ID: W-13 Limitations: *See Comments mp. Tool MFG: PTC Instruments Serial No.: gle Used 0 45 45T 60	2250 Curls 7	Size/Length:	6"			
Limitations: *See Comments	Limitations: *See Comments	2250 Cudo-7	Size/Length:	6"			
Limitations: *See Comments* Start Time: 11:10 Finish Time: 1 prop. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 48 prop. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 48 prop. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 48 prop. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 48 prop. Tool MFG: PTC Instruments Serial No.: 48 Prop. Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 48 Prop. Tool MFG: PTC Instruments Serial No.: 48 Pro	mp. Tool MFG:	2250 Cultura			Thick/Dia:	2.0" T	
True, Tool MFG: PTC Instruments Serial No.: 3356 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Batch No.: 4 Surface Temp.: 95 *F Couplant: Sonotrace 40 Surface Temp.: 95 *F Coupla	gle Used 0 45 45T 60	2250 Cuda		Start T	_		12:32
gle Used 0 45 45T 60 Lo Location: Top Dead Center Wo Location: Centerline of We anning dB N/A 38.5 53.0 51.0 Cal Sheet No.: 2000CA131, 2000CA132 Examination Surface: Inside Outstream Downstream CW CCW CCW No.: CCW COM CCW COW COW CCW COW COW COW COW COW COW		JUTECO TOT	np.: 95 °F	Couplant:			
Examination Surface: Inside Out of the control of t							#98243
dication(s): Yes No Scan Coverage WRT Weld: Upstream Downstream CW CCW Normanents: No scans on cold leg and weld due to configuration.	anning dB N/A 38.5 53.0 51.0				-		
with: NAD 🔀 IND 🗆 GEO					_	ace: Inside	Outside 5
No scans on cold leg and weld due to configuration.	The state of the s	vveid: Upstream ☑	Downstream [cM⊠ cc∧	V⊠		
most Of Courses Obligated a COV.	sults: NAD ☑ IND □ GEO □					•	
No -		Paulawad Paulaw	- Data				
		Veriamed Lianion	JS Data:	No	•		
Examiner Level II Blechinger, Todd P. / Signature - Date Reviewer 5/6/2000 Halling, David A. / Of Halling, David A.	Examiner Level II Blechinger, Todd P. / Signature			, (10 11 12	9	Date
Examiner Level II Signature Date Site Review Signature Kilpela, Mathew F. Signature Site Review Signature Signature Signature Site Review Site R	Examiner Level II Signature	Date	Site Review			5/9	Date
indicate intition of the state	Other Level N/A Signature N/A	Date	ANII Review Heater, Stephen		Signature	547	Date

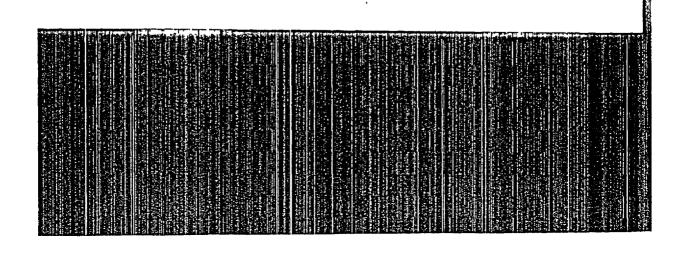
Attachment 9 Page 1 of 3

Site/Unit	NSP	,	Pl2		Procedure.		ISI-UT-1	5	Report No.:		20001	_
ummary No.:		5019	35	Procedure R	evision/FC.	13	1		Page:		2 0	f
mination For:		IS	<u> </u>	Work	Order No.:	•	0000232					
45 deg												
Scan 1	100.000		% Length X	73.000	% volume o	of length.	/ 100 =	73.000	% tota	l for S	Scan 1	
Scan 2	100.000)	% Length X	95.000	% volume d	of length	/100 = _	95.000	% tota	l for S	Scan 2	
Scan 3	100.000)	% Length X	11.000	% volume o	of length	/ 100 =	11.000	% tota	l for S	Scan 3	
Scan 4	100.000)	% Length X	11.000	% volume o	of length	/ 100 =	11.000	% tota	l for S	Scan 4	
<u>.</u>			ivide by # scar		_	er 45 deg	•					
Other deg	60	(to	ivide by # scar o be used for s	upplemental s	cans)	-						
Other deg	60	(to	o be used for s	upplemental so that was not o	cans)	ne 45 deç	g scans.	20 00	0% tot	al for	Scan 1	
Other deg - The data to b	60 e listed b	(to	o be used for s	upplemental s that was not o 20.000	cans) btained with th	ne 45 deg] scans. 1/100 =				Scan 1 Scan 2	
Other deg - The data to b	60 e listed b	(to	o be used for so s for coverage : % Length X	upplemental s that was not o 20.000	cans) btained with th % volume	ne 45 deg of length] scans. 1/100 = 1/100 =)% tot	al for		!
Other deg - The data to b Scan 1 Scan 2	60 e listed b	(to	o be used for so so for coverage to the Length X % Length X	upplemental so that was not o 20.000 5.000	cans) btained with th % volume % volume	of length of length	g scans. 1/100 = 1/100 ≈ 1/100 ≈	5.000	% tot	al for al for	Scan 2	
Other deg - The data to b Scan 1 Scan 2 Scan 3	60 e listed b	(to	o be used for so so for coverage to the Length X % Length X % Length X	upplemental so that was not o 20.000 5.000	cans) btained with th % volume % volume % volume	of length of length	g scans. 1/100 = 1/100 ≈ 1/100 ≈	5.000	% tot	al for al for	Scan 2 Scan 3	

53.75 % Total for complete exam

Example - 45 deg scan 1 = 63% plus supplemental 60 deg scan 1 = 28% (of remaining required scan volume) for total of 91% coverage for scan 1 volume. Repeat for the remaining scans, add together and divide by the # of scans (typically 4).

Site Field Supervisor:





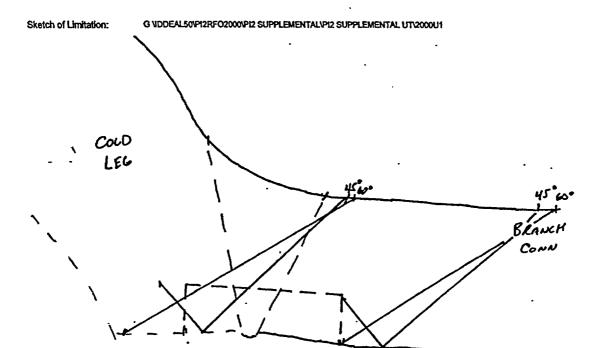
Limitation Record

Report No.: 2000U125

							,			
Site/Unit:	NSP	_/	PI2	Procedure:		SI-UT-16	Page:	3	of	3
Summary No.:		5019	35	Procedure Revision/FC:	13	1			•	
Examination For:		IS	<u> </u>	Work Order No.:		0000232				

Description of Limitation:

No scans on cold leg and weld due to configuration.

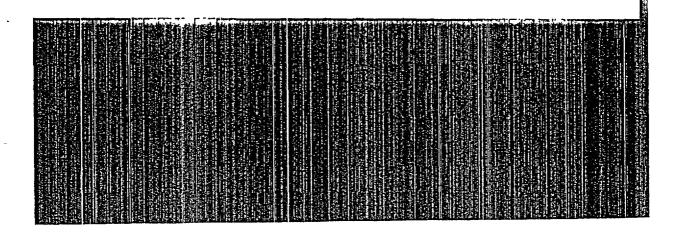


Limitations removal requirements:

None

Radiation field: 250 mR/HR

Examiner Level # Blechinger, Todd P. /	Signature Signature	Date Reviewer 5/6/2000 Halling, David A.	Signature A dre lli	5/9/00
Examiner Level Kilpela, Mathew F. /	Market 1	Date Site Review 5/6/2000 Kinney, Charles R.	Signature	5/14/00 Date
Other Level N/A N/A /	Signature	Date ANII Review Heater, Stephen B.	Signature	Date 5-17-00



Attachment 9
Rage 3 of 3

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Site/Unit;	NSP	P	2		F	rocedure;	ition	91-UT-3_			Report No.: _ Page: _	2000U	
Summary No.:		502624			Procedure Re	vision/FC:	. 9						
Examination For:		ISI			Work	Order No.:	0	000232					
Applicable Code: 198	9				ISC	O Drawing No.;		2- 5 -	37A		Location:	Contai	nment
Description: She	ell to Tran	Cone									-		
System ID: SG	3												
Component ID: W-	E							Siz	e/Length:	450.5°	Thick/Dia:	2.	B2"
Limitations: Sec	attached	imitation	records.					Star	t Time:	11:09	Finish Tim	ne:1	7:32
kamination Surface:	inside		Outside 🔽]	Surface Condition	n: Ground Sm	ooth				·		
emp Tool MFG:	Telate	1p	Serial No.	.: NSP 1	123 Surface To			ouplant:	Son	otrace 40	Batch	No: #	98243
ngle Used 0	45	5T 60	60T		Lo Location;		ne of FW	_		ocation:		Toe	20243
anning dB 44.6	64.6	4.5 80.	60.2		Cal Sheet No.:					CA137, 200			
dication(s): Yes	·								-				
omments:					i: Upstream	Downstream	9₩3	cw⊠	ccw⊠			,	
omments:						Downstream	'₩	cw⊠	ccm⊠			,	
omments:						Downstream	S	cw⊠	ccm⊠			,	•
omments:						Downstream	S	cw⊠	ccw⊠			1	
omments:						Downstream	S	cw⊠	ccw⊠			,	
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omments: oted indications rec	orded on	Report #9	0-229, loca	ted outside				es .				,	•
omments: oted indications rec sults: N/	corded on	Report #9	0-229, loca	ted outside	Reviewed Prev	ious Data:				Siens		,	
omments: oted indications rec esults: N/ recent Of Coverage C	corded on	Report #9	0-229, loca	ted outside	Reviewed Previous	ious Data:	Y			Signa A () 0(. Date
sults: N/ Examiner Level Auer, Robert G. Examiner Level	orded on	Report #9	0-229, loca	ted outside	Reviewed Previous 5/6/200	ious Data:	Y.		· ·	Signa A, (h, O(كسر	<u>5/1</u>	1/00
esults: N/ Examiner Level Auer, Robert G.	AD 🖸)	Report #9	GEO No	ted outside	Reviewed Previous 5/6/200	ious Data: Re Reviewer 10 Halling, Dav	yid A.		· O	A. Hill	dure	5/11	

Attachment 10 Page 1 of 6



Limitation Record

Re

2000U131

ροπ	No.:	
•		_

ISI-UT-3

Procedure: Procedure Revision/FC

Summary No: Examination For:

ISI

502624

Work Order No.:

0000232

Description of Limitation:

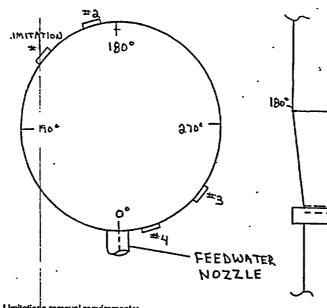
Site/Unit: NSP

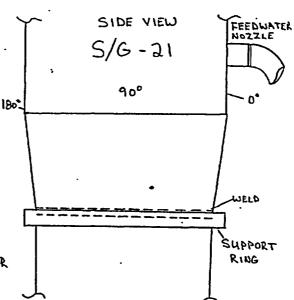
Top view limitations #1 - 4 - upper lateral support ring bolted flanges, each 7" in length, #1 - 12' 10" to 13' 5", #2 - 17' 2" to 17' 9", #3 - 31' 5" to 32', #4 - 36' 2" to 36' 9". Side view limitation - support ring covers entire weld and lower 1/2" of base material include in the exam area.

Sketch of Limitation:

G.VIDDEAL50/PI2RFO2000/PI2 SUPPLEMENTAL/PI2 SUPPLEMENTAL UT\2000U1

TOP VIEW



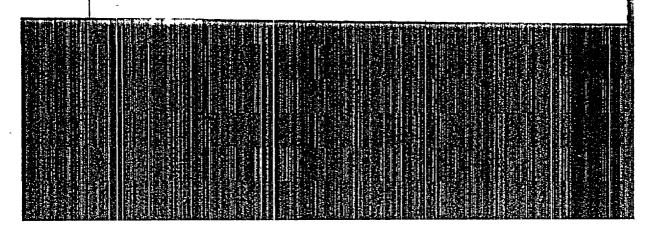


Limitations removal requirements:

None

Radiation field. 5-30 mR

Examiner Auer, Ro		II ,	Signature		Reviewer Ialling, David A.	,	Signature	Date 5/17/00
Examiner Newgard	Level Jerry W.	11 /	Signature	`	ite Review Inney, Charles R.	10	Signature	Jale Sept
Other N/A	Level	N/A /	0 · Osignature		Nil Review leater, Stephen B.	1	Signature	Date 5:22.00





Supplemental Report

Report No.: 2000U131

į						Pa	ge: <u>3</u>	_ of	6
Summan	No.:	502624							
Exan	iner.	Auer, Robert G.	Level.	U	Reviewer:	Halling, David A.	Date	5/	17/00
Exan	iner:	Newgard, Jerry W.	Level:	- (t	Site Review:	Kinney, Charles R.	_		z/a
C	ther:	N/A	Level:	N/A	ANII Review:	Heater, Stephen B.	Date:		
	L								

Comments:

0 Degree Scan - No exam volume achieved due to support ring.

45 and 60 Degree Scans - Scan #1 - No scan from this direction due to support ring. Limited exam volume was achieved from second leg of Scan #2.

Scan #2 - Limited scan from this direction due to support ring and support ring boited flanges. Limited exam volume was achieved,

Scans #3 and 4 - No exam volume was achieved due to support ring.

See attached coverage worksheets.

Attachment 10 Page 3 g 6



Determination of Percent Coverage for UT Examinations - Vessels

	.						Report No:	20	31		
Site/Unit:	NSP		PI2		Procedure:	ISI-UT-	3	Page:	4	_ of	6
Summary No.:		502	524	Procedure	Revision/FC:	9 /					
Examination For:		18	81 	We	ork Order No.:	000023	12				
0 deg Plana	<u>r</u>										
Scan _	93,800	<u> </u>	_% Length X	0.000	% volume	of length / 100 =	0.000	% total	for 0 d	eg	-
45 deg											
Scan 1	93.800)	% Length X	27.400	% volume d	of length / 100 =	25.701	% total :	for Sca	en 1	
\$can 2	93.800	·	% Length X	30.500	% volume o	of length / 100 =	28.609	% total	for Sca	in 2	
\$can 3	93.800	1	% Length X	0.000	% volume o	of length / 100 =	0.000	% total t	or Sca	ın 3	
\$can 4	93.800)	% Length X	0 000	% volume o	of length / 100 =	0.000	% total 1	or Sca	n 4	
Add tota	is and di	vide i	by #scans ≖	13.578	% total for 4	5 deg					
Scan 1 _	93.800		% Length X	34.700	% volume o	of length / 100 =	32,549	% total f	or Sca	n 1	
Scan 2	93.800		% Length X	53.700	% volume o	of length / 100 =	50.371	% total f	or Sca	n 2	
Scan 3	93,800		% Length X	0.000	% volume o	f length / 100 =	0.000	% total f	or Sca	n 3	
Scan 4	93.800		% Length X	0.000	% volume o	f length / 100 =	0.000	% total f	or Sca	n 4	
Add total	s and div	/id e 1	y#scans=	20.730	% total for 6	0 deg					
11.436 %	each ang	ie an	_	d and divide b	ny# of angles to	determine;				·• •	-
Note:											
Supplemental obtained with examination.	coverage angles as	e may s note	be achieved I	by use of other be calculated	r angles / metho and added to th	ods. When used, to be total to provide	the coverage the percent	e for volume no total for the co	ot omplet	e	
Site Field Sup	ervisor:	_(Tune.		Date: 5/20	lo lo				

4Hachmend 10 Page 4 of 6

NSP	Supple	emental Repo	 ort	Report No.:	2000U131	
Summary No.: 502624 Examiner: Auer, Robert G. Examiner: Newgard, Jerry W. Other: N/A Comments None		II Site Review:	Hailing, David A. Kinney, Charles R. Heater, Stephen B.	Page:	5 of 6 Date: 5/10/00 Date: 5-12000	Attachmens 14 fage 5d 6
Skelch or Photo: G.NDDEAL50VPI2RF02000VPI2 SUR upper latea support ring	il g W-1		UT12000U1			

NSP		Suppleme	ental Repo	ort	Report No.:	2000U	131	٥
, –	luer, Robert G. lewgard, Jerry W.	Level: II Level II Level. N/A	Site Review	Halling, David A. Kinney, Charles R. Heater, Stephen B.	Page:		_6 117100 toloo	tachmend 14
Comments:	None	·	•					Att
Sketch of Photo:	upper lateral support ring	ı	SUPPLEMENTAL	UT2000U1				
		60° C	W-E OVERAGE I	PLOT ·		<i></i>		
1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1								
		/.	/ · 					
	MAKET MA				militarizatio con mana e			



Magnetic Particle Examination

Attachment 11 Page 1 of 3

04-1										Report No).: <u> </u>	000M087
Site/		NSP /	Pl2			rocedure:		ISI-MT	-1	Pag	e: <u>1</u>	of 3
Summary	No.:	50	01377		Procedure Rev	rision/FC:	10					
Examination	For:		ISI		Work C	order No.:		000023	32			
Applicable C	ode: 19	89			ISO Dra	wing No.:	2	:-ISI- 60)B	Location	n Ain	x Building
Descrip	tion: Su	pport A				,					"	Comming
System	n ID- SI			_								
Component	t ID: H-	1			Size/Le	ength:	N/A		Thick/Dia:	.75		
Limitatio	ons: Se	e attached	l sketch.					-				
Light Meter M	AFG:		N/A		Ser	ial No.:	N/A	:=== \	Illuminat	ion:	N/A	uw/cm²
Temp. Tool N	/IFG:		N/A		Ser	iai No.:	N/A	1		e Temp.:		0W/CIII
Gray Card (if	used): _	Not	Used	Cal E	llock Serial No				Surface Cond	•		
Lo Location:		Support E	olt Cente						Longitu			
Magnetic Pa	rticle Ma	terial:										
Brand:	M	agnaflux		_	Wet [Mixed:	Yes □		Applie	ed Bv:	Dustin	na 571
Type:		BA Red		•	Dry 🗹		No ☑		•••		Sprayin	
Batch No.: _		92B062		_ Fluc	rescent [With:	N/A				Floodin	
Equipment:				Parker R	lesearch			Se	· erial No.: _		7817	. 9 —
Head Shot		N/	A	Amperes		Fixed S	pacing				☑ DC	
Adj. Spacing	$\mathbf{\nabla}$	6'	,	inches		Encirclin	ng Coils	П	N/A	Turns	ب	₩
Prods. Spacir	ng 🔲	N/	Α	inches		Current	(machine s	etting)	0	N/A	An	nperes
Indication	Loc	Loc	Diameter	Length	Туре				Remarks			
No.	L	w	ļ		R/L	ļ			•			
						1						
		 	 -			-						
		 	<u> </u>						·			
		1	1									:
Comments:		<u> </u>	L									
MT Pi Gauge	- LMT-	90										
		_										
Results:	NAD	\mathbf{Z}	IND		_							
Percent Of Co	overage (Obtained >	90%:	No		Reviewe	d Previous	Data:	N			
Examiner	Level	ļi .	1	ature	Da	te Review	er		s	ignature		Date
Johnson, Je			M	<u> </u>			, David A.		1 Walk	alli		30/00
Examiner N/A	Level	NA, (Sigh:	ature	Da	te Site Re	view , Charles F		100	ignature	<u>'</u>	Date
Other	Level	N/A	Signa	ature	Da	te ANII Re			-611	ignature/		Date
N/A		1				1	Stephen E	3.	1 Steel	To the	www.	3.200

Attachment 11 Páge 2 of 3

of



Limitation Record

Report No : 2000M087

Page:

Site/Unit: NSP / PI2 Procedure: ISI-MT-1
Summary No.: 501377 Procedure Revision/FC: 10 /

Examination For: ISI

Work Order No.:

0000232

Description of Limitation:

6" of weld on bottom of pads are inaccessible due to concrete pad.

Sketch of Limitation:

G:VDDEAL50VPI2RFO2000VPI2 SUPPLEMENTALVPI2 SUPPLEMENTAL MTV2000M

Looking West & EAST

SI Pump CASING

World

NON Accessable weld well coverete. Support Pad

Typical of ALL 4
Supports

SI
Pump
Casug

Non Accessable
Support.
Pad -

Limitations removal requirements:

None

Radiation field: <-5 mR/hr

Examiner Johnson, J		11 /	Signature	 Reviewer Halling, David A.	Signature / OA Longlin	Date 5/30/00
Examiner N/A	Level	N/A /	Signature	 Site Review Kinney, Charles R.	Signature	Date > 5-30-00
Other N/A	Level	N/A /	Signature	 ANII Review Heater, Stephen B.	Signature 1	Date 3:31-00

Attachment 11 Page 3 of 3



Determination of Percent Coverage for Surface Examinations

								Report No.:	20	оомо	87
Site/Unit:	NSP	1	PI2	Procedure:		ISI-MT-1	ľ	Page:	3	of	3
Summary No.:		5013	77	Procedure Revision/FC:	10	1				-	
Examination For:	xamination For: ISI		Work Order No.:	Work Order No.: 0000232							
Lengt	,	36.	000_*	le reference drawing) Width 2.000 square inches							
Coverage Achie	ved										
Area	examine	ed	60.000	sq. in. / Total area require	ed (1009	6)	72.000	_ sq. in.			
= Pero	ent cove	rage	\$ 33	8 (area required - area o	f limitati	ons = are	ea examine	d)			

To determine length of a circumferential weld

Note - Diameter refers to actual external diameter not pipe size (see table below)

Diameter _____ * (Pi) 3.1416

= Length __0.000 __ inches

Pipe Size	Actual Diameter	(Length) Circumference		Pipe Size	Actual Diameter	(Length) Circumference
2	2.375	7.46	1	12	12.75	40.06
2.5	2.875	9.03	1	14	14.0	43.98
3	3.5	11.0	1	16	16.0	50.27
3.5	4.0	12.57	1	18	18.0	56.55
4	45	14.14	1	20	20.0	62.83
5	5.563	17.48	1	22	22.0	69.12
6	6.625	20.81	1	24	24.0	75.40
8	8.625	27.10	1	30	30.0	94.25
10	10.75	33.77	l l			

Site Field Supervisor:

Date: 3-30-200E



Magnetic Particle Examination

Attachment 12 Page 1 of 3

										Report No).: 	2000M0	88
Site	/Unit: —	NSP /	PI2		Pro	cedure:		ISI-MT	-1	Page	e: 1	of	3
Summary	No.:	50	1385		Procedure Revis	sion/FC:	10	,					
Examination	For:		ISI		Work On		00002	32					
Applicable C	ode: 19	89			ISO Drawing No.:			2-ISI- 60B			v. A	ux Build	41
Descrip	otion: Su	pport B				•				Location	" <u>~</u>	ux Bulk	ang
Syster	m ID: SI												
Componer	nt ID: H-	2			Size/Len	gth:	N/A		Thick/Dia	.75	···		
Limitat	ions: Se	e attached	sketch.									•	
Light Meter I	MFG:		N/A	——————————————————————————————————————	Seria	l No.:	N/	Ά	Illumina	tion:	N/A		w/cm²
Temp. Tool I	MFG:		N/A			l No.:				e Temp.:		u <600	•F
Gray Card (i				_	Block Serial No.:		N/A		Surface Con-	•		Welded	
Lo Location:		Support B	olt Center	rline	Field Orien	tation:	~		Longit	udinal			
Magnetic Pa													
Brand:		lagnaflux		-	Wet □	Mixed:	Yes [3	Appli	ed By:	Dus	ting 🗹	
Туре:				_	Dry 🗹		No 🗹	3			Spray	ing 🗌	
Batch No.:		92B062		_ Flu	orescent 🗌	With: _	N/A	<u> </u>	-		Flood	ling 🔲	
Equipment:				Parker I	Research			s	erial No.:		7817		
Head Shot		N/.		Amperes		Fixed Sp	pacing			AC [y [c 🗆	
Adj. Spacing	$\mathbf{\Sigma}$	<u>e,</u>	·	inches		Encirclin	g Coils		N/A	Tums			
Prods. Spaci	ing 🗀	N/A	<u> </u>	inches		Current	(machine	setting)	<u> </u>	N/A	/	\mperes	;
Indication	Loc	Loc	Diameter	Length	Туре			•	Remarks	;	~		
No.	L.	W			R/L								i
					<u> </u>	 							_
						 							-
		 				<u> </u>							
<u></u>	<u> </u>											_	
Comments: None								_					
None													
Results:	NAD	\mathbf{Z}	IND 🔲										
Percent Of C	overage (Obtained >	90%:	No	·	Reviewe	d Previou	s Data:	N	0			
Examiner	Level	11	/ Signa	ture	Date	Review	er			Signatune			Date
Johnson, Jo	effery M.	1	m	<u> </u>	5/25/2000	Halling,	David A.		10	lath	<u>L</u> .	5/30.	
Examiner N/A	Level	NA,	Signa	ture	Date	Site Re	/iew Charles	ь	, /	ignature	->		Date
Other	Level	N/A	Signa	iture	Date	ANII Re		r.	' B	Signature	uu j	-/3-34	Date
N/A		1	•				Stenhen	R				ويرر	أممه



Procedure:

Work Order No.:

Procedure Revision/FC:

ISI-MT-1

0000232

10

Attachment 12 Page 2 of 3

	Report No.:	200	2000M088						
-	Page:		of	3					

Description of Limitation:

Site/Unit:

Summary No.:

Examination For:

NSP

6" of weld on bottom of pads are inaccessible due to concrete pad.

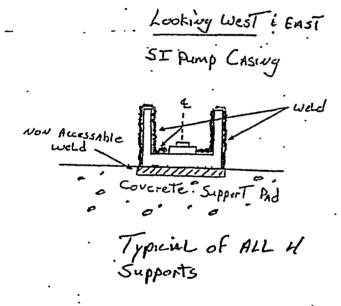
501385

ISI

PI2

Sketch of Limitation:

G:VDDEAL50/PI2RFO2000/PI2 SUPPLEMENTAL/PI2 SUPPLEMENTAL MT\2000M



SI Pump CASING

NON Accessable

Support.

Pad =

Limitations removal requirements:

None

Radiation field: <-5 mR / hr

Examiner Johnson, J		••	Signature M 5		Reviewer Halling, David A.	Signature Pa
Examiner N/A	Level	N/A /	Signature		Site Review Kinney, Charles R.	Signature Da
Other N/A	Level	N/A /	Signature	Date	ANII Review Heater, Stephen B.	Signature Date 53/-00

Attachment 12 Page 3 of 3



Determination of Percent Coverage for Surface Examinations

										Report No.:	20	омо	88				
Site/Unit:	NSP		PI2	_	Procedure	:	IS	I-MT-1		Page:	3	of	3				
Summary No.:		5013	85	_ Pro	ocedure Revision/FC	: 10		1				_					
Examination For:		ISI		_	Work Order No.:	No.: 00		0000232		000232		000232					
Area Required (as show	n in ap	plicable co	de refere	ence drawing)												
Lengt	h _	36.0	000 *	Width	2.000			•									
= Tota	al Area n	equired	72	000	square inches			•									
					_ ,												
Coverage Achie	ved						_		· · · · ·								
Area	examine	ed _	60.00)s	q. in. / Total area req	uired (100%	%)	72.000		sq. in.							
= Perce	ent covei	age	6.933	83 %	6 (area required - are	a of limitati	ons	= area exam	ined)								
			•														
						·											

To determine length of a circumferential weld

Note - Diameter refers to actual external diameter not pipe size (see table below)

Diameter ______ • (Pi) 3.1416

= Length 0.000 inches

Pipe Size	Actual Diameter	(Length) Circumference	Pipe Size	Actual Diameter	(Length) / Circumference
2	2.375	7.46	12	12.75	40.06
2.5	2.875	9.03	14	14.0	43.98
3	3.5	11.0	16	16.0	50.27
3.5	4.0	12.57	18	18.0	56.55
4	45	14.14	20	20.0	62.83
5	5.563	17.48	22	22.0	69.12
6	6.625	20.81 ·	24	24.0	75.40
8	8.625	27.10	30	30.0	94.25
10	10.75	33.77		···	

Site Field Supervisor:



Magnetic Particle Examination

Attachmens 13 Page 1 of 3

Site/Unit:	: NSP	1	PI2		Pro	cedure:	1:	SI-MT-1		Page	" — <u>-</u> -	òf	3
Summary No.:		501	390	P	rocedure Revis	•					·	- · -	
Examination For:			51			der No.:		000232					
												····	
Applicable Code:					ISO Draw	ing No,:	2	-isi-60-b		Location	: <u>Au</u>	x Buildi	ing
Description:		t C											
System ID:													
Component ID:					Size/Len	ngth:	N/A	-	Thick/Dia:	.75	• 		
Limitations:	See att	ached s	sketch.										
Light Meter MFG:	:		N/A		Seria	al No.:	N/A		Illuminat	ion:	N/A	uv	v/cm²
Temp. Tool MFG:	;		N/A		Seria	al No.:	N/A		_ Surfac	e Temp.:	<	600	_ •F
Gray Card (if use	d):	Not U	sed	_ Cal B	lock Serial No.	•	N/A	Su	rface Cond	lition:	As V	Velded	
Lo Location:	Sup	port Bo	It Center	rline	Field Orier	ntation:			Longitu	ıdinal			
Magnetic Particl	e Materia	ı l :							_				
Brand:	Magn	aflux		_	Wet [Mixed:	Yes 🗌		Applie	ed By:	Dusti	ing 🗹	
Туре:	8A R	led		_	Dry 🗹		No 🗹				Sprayi	ing 🗀	
Batch No.:				_ Fluc	rescent 🗌	With: _	N/A				Flood	ing 🔲	
Equipment:	····			Parker R	esearch_			Seria	al No.:		7817		
Head Shot	o	N/A		Amperes		Fixed S	pacing			AC	⊘ D	c 🗆	
Adj. Spacing	Z	6"		inches		Encirclin	ng Coils	-	N/A	Tums			
Prods. Spacing		N/A		inches		Current	(machine s	etting)		N/A	A	mperes	
Indication L	oc	Loc	 Diameter	Length	Туре	1			Remarks				
No.	L	w	i		R/L								
						 							
									·····				
						<u> </u>	***					,	
													Ì
Comments:						٠							
None													
Results: 1	VAD 🗹	1	ND 🗌										
Percent Of Cover	age Obtai	ned > 9	0%:	No	•	Reviewe	d Previous	Data:	N	0			
•	evel [[Signa	ature		e Review	-			Signature			Date
Johnson, Jeffer		/	m	45/-			, David A.		<u>40</u>	Hele	<u> </u>	<u>5/30/0</u>	
Examiner Le	evel N/A	,	Signa	ture V	Dat	e Site Re	view , Charles F	,	A	ignature	\Rightarrow	-	Date
	vel N/A	-	Signa	ature	Dat	e ANII Re				Signature		100	Date
N/A		,	_				Stephen E	s. <i>1</i>	1	-195	Z	5-53/	ia



A Hackment 13 Page 2 of 3

Report No.: 2000M086 Page: of 3

Site/Unit: NSP PI2 Procedure: ISI-MT-1 Summary No.: 501390 Procedure Revision/FC: 10 Examination For: ISI Work Order No.: 0000232

Description of Limitation:

6" of weld on bottom of pads are inaccessible due to concrete pad.

Sketch of Limitation:

G VDDEAL50VPI2RFO2000VPI2 SUPPLEMENTALVPI2 SUPPLEMENTAL MTV2000M

Looking West & Enst SI Pump Casing NON ALLESSABLE Typical of ALL 4 Supports

Looking South & NOrTh NON Accessable weld

Limitations removal requirements:

None

Radiation field: <-5 mR/hr

Examiner Johnson, J	Level leffery M.	•••	-	Signature M //	Reviewer Halling, David A.	Signature A Coli	Date 5/30/00
Examiner N/A	Level	N/A /	0	Signature	 Site Review Kinney, Charles R.	Signature	Date
Other N/A	Level	N/A /		Signature	ANII Review Heater, Stephen B.	Signature State	Date 53100

NSP

Attachment 13 Page 3 of 3

Determination of Percent Coverage for Surface Examinations

							Report No.:	20	00M0	86
Site/Unit:	NSP	1	PI2	Procedure:		ISI-MT-1	Page:	3	of	3
Summary No.:		5013	90	Procedure Revision/FC:	10	1			_	
Examination For:		ISI		Work Order No.:		0000232				
Lengt		36.0	*	e reference drawing) Width 2.000 square inches						
Coverage Achie	ved									
	examine ent cove	-	60.000 // 1/833	sq. in. / Total area require 83 % (area required - area o	-	· ———	· ·			
To determine ler		ı circui	nferential v	<i>r</i> eid	-					

Diameter 0.000 * (Pi) 3.1416

= Length 0.000 inches

			•		
Pipe Size	Actual Diameter	(Length) Circumference	Pipe Size	Actual Diameter	(Length) Circumference
2	2.375	7.46	12	12.75	40.06
2.5	2.875	9.03	14	14.0	43.98
3	3.5	11.0	16	16.0	50.27
3.5	4.0	12.57	18	18.0	56.55
4	45	14.14	20	20.0	62.83
5	5.563	17.48 .	22	22.0	69.12
6	6.625	20.81	24	24.0	75.40
8	8.625	27.10	30	30.0	94.25
10	10.75	33.77			

Site Field Supervisor:

Date: 3



Magnetic Particle Examination

Attachmen 14 Page 1 of 3

0:4- #										Report N	o.:	2000	M089
Site/		NSP /	Pi2			ocedure:		ISI-MT	-1	Pag	e:	1 0	of 3
Summary		50	1396	¹	Procedure Revi	ision/FC:	10						
Examination	For:		ISI		Work O	rder No.:		000023	32				
Applicable Co	ode: 198	9			ISO Draw	ring No.:		2- i si-60	-b	Locatio	n· /	ur Pu	ildina
Descript	ion: Sup	port D				• .				Locatio	''·	ux Bu	nuing
System	ID: SI												
Component	ID: H-4	<u> </u>			Size/Lei	ngth:	N/A		Thick/Dia:	.75	······································		
Limitatio	ons: See	attached	sketch.					_				-	
Light Meter M	IFG:		N/A		Seri	al No.:	N//	4	Illumina	tion:	N/A		uw/cm²
Temp. Tool M			N/A		Seri	al No.:	N/A	4	Surfac	e Temp.:		<600	•F
Gray Card (if					llock Serial No.				Surface Cond	dition:	As	Welde	ed
Lo Location:			olt Center	rline	Field Orie	ntation: _			Longiti	udinal			
Magnetic Par					`								
Brand:				_	Wet 🗌	Mixed:	Yes []	Applic	ed By:	Du	sting 🛭	2
Type:				_	Dry 🗹		No 🗹				Spra	ying []
Batch No.:		92B062		_	rescent	With: _	N/A		-		Floo	ding [)
Equipment:				Parker R	esearch			s	erial No.:		7817	· 	
Head Shot	ο.	N/A		Amperes		Fixed S	pacing			AC	lacksquare	DC 🗆	
Adj. Spacing	\mathbf{Z} .	6'		inches		Encirclin	ng Coils	□.	N/A	Turns			
Prods. Spacir	ng 🔲 .	N/	4	inches		Current	(machine t	setting)	□	N/A		Amper	es
Indication	Loc	Loc	Diameter	Length	Туре				Remarks	;			
No.	L	w			R/L				<u>.</u>				
	•												
		 											
 		ļ				<u> </u>							
		<u> </u>				<u> </u>							
Comments:													
None													
Results:	NAD	\mathbf{Z}	IND [
Percent Of Co		_		No		Povious	ed Previous	- Doto:	10	lo			
	verage C	blaned >	3070.			Keneme	A LICAIOUS	Data.					
Examiner	Level		11	ature		te Review				Signature	Ω	.مه	Date
Johnson, Je Examiner	Level	N/A	M G	ature		le Site Re	, David A. view	·	ر ب <u>ي</u> م	Signature	لالا	1 5/	30/00) Date
N/A			J "Ö"	uiv			, Charles	R.	1/4	Will.	وشير	2	30 a
Other	Level	N/A	Sign	ature	Da	e ANII R				Signature	7	7 -	Date
N/A		1				ineater	Stephen	5 .	1	. 1 74		ززورس	?/-00



Procedure:

Attachment 14 Page 2 of 3

Report No.: 2000M089

Page:

Procedure Revision/FC:

ISI-MT-1

Examination For: ISI

NSP

Work Order No.:

0000232

Description of Limitation:

Site/Unit:

Summary No.:

6" of weld on bottom of pads are inaccessible due to concrete pad.

501396

Sketch of Limitation:

G:\IDDEAL50\Pi2RFO2000\Pi2 SUPPLEMENTAL\Pi2 SUPPLEMENTAL MT\2000M

Looking West & EAST

SI Pump CASING

WON ACCESSABLE WOLD

Coverete Support Pad

SI
Pump
Casug

Now accessable
Support:
Pad -

Limitations removal requirements:

None

Radiation field: < - 5 mR / hr

Examiner Johnson,	Level Jeffery M	••	J	Signature M	 Reviewer Halling, David A.	,	Of bully	Date 5/30/0
Examiner N/A	Level	N/A /	0	Signature	Site Review Kinney, Charles R.	1/	Signature	Date
Other N/A	Level	N/A /		Signature	 ANII Review Heater, Stephen B.	7	Signature	Date 5:5/00

Attachment 14 Page 3 of 3



Determination of Percent Coverage for Surface Examinations

							Report N	o.: _	20	00M0	89
Site/Unit:	NSP	/ PI2		Procedure:		ISI-MT-1	Pag	је: -	3	of	3
Summary No.:		501396	Procedure	Revision/FC:		10 /		_		•	
Examination For:		ISI	Wo	rk Order No.:		0000232					
Area Required (a	as show	n in applicable	code reference dra	awing)							
Length	, _	36.000	• Width	2.000			•				
= Tota	l Area re	equired	72.000 squar	e inches							
						,					
Coverage Achiev	red										
Aroa	examine		000 sq. in. / 1	Total area req	uimd (4	DO9/\ 7*	2.000 sq.:in.				
= Perce			tusti -	•		·					
- Perce	ant cover	age	73 73 % (area	reduired - are	a oi min	tations = area	examined)				
		······································									
To determine len	gth of a	circumferenti	al weld								
Note - Dia	meter re	efers to actual	external diameter r	ot pipe size (see tabl	e below)					
Dia	ameter .	0.000	* (Pi) 3.1416								
=1	ength .	0.000	inches								
	Pipe	Actual	(Length)		Pipe	Actual	(Length)				
	Size	Diameter	Circumference		Size 12	Diameter 12.75	Circumference 40.06				
	25	2.375	7.46		14	14.0	43.98				

Pipe Size	Actual Diameter	(Length) Circumference	Pipe Size	Actual Diameter	(Length) Circumference
2	2.375	7.46	12	12.75	40.06
2.5	2.875	9.03	14	14.0	43.98
3	3.5	11.0	16	160	50.27
3.5	4.0	12.57	18	18.0	56.55
4	45	14.14	20	20.0	62.83
5	5.563	17.48 -	22	22,0	69.12
6	6.625	20.81	24	24.0	75.40
8	8.625	27.10	30	30.0	94.25
10	10.75	33.77			

Site Field Supervisor:

Date: 5-3000

Arraenmeno 15 Page 1 of 3



Liquid Penetrant Examination

					٠	•				Report No.:	2000P0	54
Site/	Unit: N	ISP /	Pl2		Pro	cedure:		ISI-PT-1		_ Page:	1 of	3
Summary	No.:	50			Procedure Revis	ion/FC:	12			_		
Examination										-		
										-		
Applicable C	ode: 1989	<u> </u>	-		ISO Drawi	ing No.:		2-isi-69-	<u> </u>	Location:	RHR PIT	21
Descrip	tion: Sup	port A				·				···		
Systen	n ID: RH											
Componen	t ID: H-1				Size/Len	gth:	N/A		Thick/Dia:	N/A		
			limitation									····
Temp. Tool M	IFG:		Telatem	P	Seria	al No.:	N	SP 123		Surface Temp.:	85	•F
						-				y Card (if used):		
Lo Location:							_			•	•	
										7		
		Cleane	r	<u> </u>	Penetrant			Remover	· 	Deve	eloper	
Brand		Magnafl	ux		Magnaflux		ı	Magnaflu	×	Magr	naflux	
Туре		SKC-S	i		SKL-HF/S			SKC-S		SKI	D-S2	
Batch No.		98L07F	ς .		87C054			98L07K		97J	104K	
Time	Evap.	5	Min ·	Dwell	15 Min		Evap.	5 M	lin	Develop	10 Min	1 .
	Time E	kam Start	ed:	11:10			Time Exan	n Comple	led:	12:00		
Indication	Loc	Loc	Diameter	Length	Туре				Remark	(S		
No.	L	w		i i i i i i i i i i i i i i i i i i i	R/L				,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
		'''			1	1					, 	
										· · · · · · · · · · · · · · · · · · ·		
					-				·			
]												
					<u> </u>							
Comments:	L	l	<u> </u>		<u> </u>	<u> </u>		·····				
See attached	d limitatio	n data sh	eets.									
000 4040000												
Results:		nad 🗹	IN	D 🔲						 		
Percent Of Co	overage O	btained >	90%:	No	<u> </u>	Reviev	ved Previou	ıs Data:		No		
Examiner	Level	1	Sign	atore		Revie		•		Signature		Date
Auer, Rober		1 1856		0			g, David A		1 (<u>)</u>	FHOLL	25/	14/00
Examiner N/A	Level [AVA /	Signa	iture	Date	Site R	eview y, Charles	Ŕ.	1/13	Signature	3 5h	Date
Other	Level	NA.	Signa	ature	Date	ANII F				Gignature	7_ <i>['''</i>	Date
N/A						Heate	r, Stephen	В.	Sty	How	-5:22	.00



Attachment 15

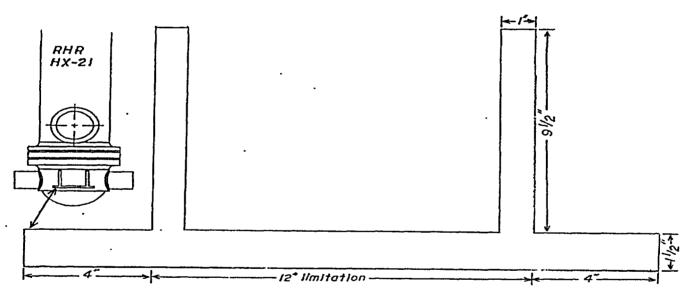
Site/Unit:	NSP	1	Pl2	Procedure:		ISI-PT-1	Page:	2	of	3
Summary No.:		5014	12	Procedure Revision/FC:	12	,			•	
Examination For:		ISI	<u> </u>	Work Order No.:		0000232				

Description of Limitation:

Support sits on top of concrete pedestal. The outer radius of RHR-HX-21 and pedestal are in such close proximity as to preclude access to the center 12" of the bottom attachment weld.

Sketch of Limitation:

G:VDDEAL50VPI2RFO2000VPI2 SUPPLEMENTALVPI2 SUPPLEMENTAL PTV2000P0



Limitations removal requirements:

None

Radiation field: 2-5 mR/hr.

Examiner	Level	11	Signature		Reviewer	Şignature	Date
Auer, Robe	π υ.		1000 Talen	5/13/2000	Halling, David A.	1 With bulling	5/16/00
Examiner	Level	N/A	Signature	Date	Site Review	Signature	_/ Pate
N/A				•	Kinney, Charles R.	1 (Mhinna)	9/2/2
Other	Level	N/A	Signature	Date	ANII Review	Signature	Date
N/A		1			Heater, Stephen B.	1 Suel Bar	5.22.00



Attachment 15
Page 3 of 3
Determination of Percent Coverage for Surface Examinations

•								Report No.:	2(00P0	54
Site/Unit:	NSP	1	PI2	Procedure:		IS	I-PT-1	Page:	3	of	3
Summary No.:		5014	112	Procedure Revision/FC:	12		1	····		-	
Examination For:		IS	1	Work Order No.:		00	00232				
Lengt		81.	.000 *	de reference drawing) Width 1.750 750 square inches							
Coverage Achiev	red										
· Area = Perce	examine ent cover		120.750 _0.852 85.7	% (area required - area o	· -	•	141.750 = area exam				
			KGA								

To determine length of a circumferential weld

Note - Diameter refers to actual external diameter not pipe size (see table below)

33.77

Diameter 0.000 * (Pi) 3.1416

= Length 0.000 inches

Pipe Size	Actual Diameter	(Length) Circumference		Pipe Size	Actual Diameter	(Length) Circumference
2	2.375	7.46	1	12	12.75	40.06
2.5	2.875	9.03		14	14.0	43.98
3	3.5	11.0		16	16.0	50.27
3.5	4.0	12.57		18	18.0	56.55
4	45	14.14		20	20.0	62.83
5	5.563	17,48		22	22.0	69.12
6	6.625	20.81		24	24.0	75 40
8	8.625	27.10		30	30.0	94.25

Site Field Supervisor:

Date: 5/17/00



Liquid Penetrant Examination

Attachment 16 Page 1 of 3

										кероп но.:	2000P05	6
Site/U	Init: N	SP /	Pl2		Prox	cedure:		ISI-PT-1		Page:	1 of	3
Summary N	No.:	50	1419		Procedure Revisi	ion/FC:	12	1		•		
Examination F	For:		ISI		Work Ord	ler No.:		0000232	· -			
Applicable Co	de: <u>198</u> 9)			ISO Drawii	ng No.:	3	2-isi-69-a		Location:	RHR PIT	21
Descripti	ion: <u>Sup</u>	port B										
System	ID: RH				· · · · · · · · · · · · · · · · · · ·				·			
Component	ID: H-2				Size/Leng	gth:	N/A	_	Thick/Dia:	N/A	_	
Limitatio	ns: <u>See</u>	attached	Limitation	ı Data S	heet.				 -			
Temp. Tool MF	G:		Telatem)	Seria	l No.:	NS	SP 123		Surface Temp.:	85	·F
Surface Tempe	erature of	Compara	tor Block (f used):	Side A: N/A	<u> </u>	Side B: _	N/A	_ •F Gray	/ Card (if used):	Not Us	ed_
Lo Location:		Upp	er Left Co	mer	······································	Surface	Condition:			As Welded		
		Cleane	r		Penetrant		F	Remover		Devel	oper	
Brand		Magnafl	ux		Magnaflux		M	lagnaflux	-	Magn	aflux	
Туре		SKC-S			SKL-HF/S			SKC-S		SKD	-S2	
Batch No.		98L07	ζ		87C054			98L07K		97J0	4K	
Time	€vap.	5	Min	Dwell	15 Min		Evap.	5 Mil	7	Develop	10 Min	
	Time Ex	am Starte	ed:	11:25		-	Time Exam	Complete	d:	12:15		
Indication	Loc	Loc	Diameter	Length	Туре		., ., ., .		Remark	<u> </u>		\neg
No.	L	w		<u></u>	R/L						<u></u>	
	•											
												
												一
									•			-
Comments:		<u> </u>	<u></u>		<u> </u>	l						
None.			•									
Results:		NAD 🔽		Р <u>П</u>	•							
Percent Of Co	verage O	btained >	90%:	No) 	Review	ed Previous	Data:		lo 		
Examiner	Level I	, 1	Signs	red		Review			$\overline{\bigcirc}$	Signature		Date
Auer, Robert Examiner	Level N	<u>'</u> <i>La</i>	Sigha	ture		Site R	g, David A. eview		<u> </u>	Signature		Date
N/A		1		-		Kinne	y, Charles F	R. /	M	huma	× 5/19/	6
Other N/A	Level N	VA I	Signa	ture	Date	ANII R	eview r. Stephen I	B. /		Signature) (1 3:20	Date



Attachment 16 Page 2 of 3

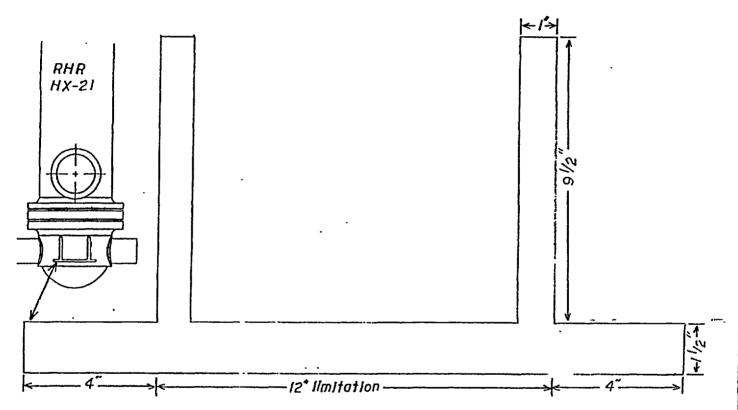
							Report No.:	20	00P0	56	
Site/Unit:	NSP	1	PI2	Procedure:		ISI-PT-1	 Page:	2	of	3	
Summary No.:		5014	19	Procedure Revision/FC:	12	1	 •		-		•
Examination For:		ISI	<u> </u>	Work Order No.:		0000232					

Description of Limitation:

Support sits on top of a concrete pedestal. The outer radius of RHR-HX-21 and pedestal are in such close proximity as to preclude access to the center 12" of the bottom attachment weld.

Sketch of Limitation:

G:\IDDEAL50\Pi2RF02000\Pi2 SUPPLEMENTAL\Pi2 SUPPLEMENTAL PT\2000\P0



Limitations removal requirements:

None.

Radiation field: 2-5 mR / hr

Examiner	Level II		[] / Signature	Date	Reviewer	Signature Dat
Auer, Robe	rt G.	1	16horas	5/13/2000	Halling, David A.	1 OA hellin 5/16/00
Examiner	Level N	VA.	Signature	Date	Site Review	Signature Date
N/A		. /			Kinney, Charles R.	1 M hammer 5/19/00
Other	Level N	VA.	Signature	Date	ANII Review	Signature Date
N/A				<u>. </u>	Heater, Stephen B.	1 Style Heart 5.2000



A Hachmen 8 16 Page 3 of 3

Determination of Percent Coverage for Surface Examinations

									Report No.:	2(00P0	56
Site/Unit:	NSP	<u>'</u>	Pl2		Procedure:		ISI-PT-1		Page:	3	of	3
Summary No.:		01419)	Procedure Re	evision/FC:	12	1		'		-	
xamination For:		ISI		Work	Order No.:	0000232			•			
Area Required(ing) /50							
	al Area req	81.00 uired	141.7									
= Tota	al Area req									· · · · · · · · · · · · · · · · · · ·		
= Tota	al Area req			50 square l		ed (100%	.	1.750	sq. in.			
= Tota Coverage Achie	al Area req	uired	141.7	sq. in. / Tot	nches				-			
= Tota Coverage Achie	I Area req	uired	120.750 	sq. in. / Tot	al area require				-			

Note - Diameter refers to actual external diameter not pipe size (see table below)

inches

Diameter 0.000 * (Pi) 3.1416 = Length 0.000

Pipe Size	Actual Diameter	(Length) Circumference	!	Pipe Size	Actual Diameter	(Length) Circumference
2	2.375	7.46		12	12.75	40.06
2.5	2.875	9.03		14	14.0	43.98
3	3.5	11.0		16	16.0	50.27
3.5	4.0	12.57		18	18.0	56.55
4	45	14.14		20	20.0	62.83
5	5.563	17.48		22	22.0	69.12
6	6.625	20.81		24	24.0	75.40
8	8.625	27.10		30	30.0	94.25
10	10.75	33.77				

Site Field Supervisor:



Liquid Penetrant Examination

Attachment 17 Page 1 of 1

									кероп но.:	2000P02	.3
Site/L	Jnit: N	SP /	Pl2		Proce	edure:	ISI-PT-1		Page:	1 of	1
Summary I	No.:	50	1405	F	rocedure Revisio	n/FC:12			· · · · · · · · · · · · · · · · · · ·		
Examination I						er No.:			•		
Applicable Co	ode: <u>1989</u>)			1SO Drawing	g No.:	2-ISI- 30A	,	Location:	Pressuriz	er
Descript	ion: <u>Noz</u>					<u></u>					
System	ID: RC										
Component	ID: W-1	\			Size/Leng	th: 6"/ 19"	7	hick/Dia:	.719"		
Limitation	ons: Non							~~		-	
Temp. Tool M	FG:		Telatem)	Serial	No.:	ISP 128		Surface Temp.:	95	•F
					Side A: N/A						
								_			
		Cleane	er		Penetrant		Remover		Deve	loper	\neg
Brand		Magnafi	ux		Magnaflux		Magnaflux		Magr	affux	
Туре		SKC-S	3		SKL-HF/S		SKC-S		SKI)-S2	
Batch No.		97H11	К		87C054		97H11K		97J	04K	
Time	Evap.		5	Dwell	10	Evap.	2		Develop	7	
	Time E	kam Start	ed:	14:45		Time Exa	m Complete	ed:	16:00		
Indication	Loc	Loc	Diameter	Length	Туре			Remark	:s		\neg
No.	L	w			R/L				· 		
		{									1
		 	 				•				\neg
		 -	╁						 		
<u> </u>	<u> </u>	<u>l</u>	<u> </u>	<u> </u>							
Comments:				•							
None											
Results:		NAD 🔀	j in	ID []							
Percent Of C	overage C	Obtained :	> 90%:	Ye	8	Reviewed Previ	ous Data:		No		
Examiner	Level	11		ature		Reviewer			Signature		Date
Blechinger		1		P. BU		Halling, David	A. /	<u></u>	Signature	5/	4/00 Date
Examiner N/A	Level	N/A	Sign	ature	U Date	Site Review Kinney, Charle	es R.		Le france	2 5/	1/2
Other	Level	N/A	Siar	ature	Date	ANII Review		- 715	Signature		Date
N/A	20101		5			Heater, Steph	en B.	de	well Hea	2 3.8	7-00

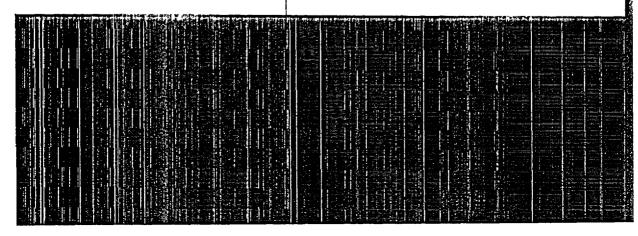


Liquid Penetrant Examination

Attochment 18 Page 1 of 1

										report No	2000F031
Site/U	nit <u>N</u>	SP /	Pl2		Proc	edure:		ISI-PT-1	····	Page:1	1 of1_
Summary N	lo.:	501	935	F	Procedure Revision	on/FC:	12				
Examination F	or:	[;	SI		Work Orde	er No.:		0000232		•	
Applicable Co	de: <u>1989</u>)			ISO Drawin	g No.:		2-151- 5		Location: CC	ONTAINMENT
Descripti	on: Nozz	de to Pipe	3							4	
System	ID: RC										
Component	ID: W-13	3			Size/Leng	th:	6"		Thick/Dia:	2.56*	
	ns: None				-			_	,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,		
										Surface Temp.:_	
Surface Tempe	erature of	Comparat	or Block (i	f used):	Side A: N/A	°F	Side B:	N/A	_ *F Gray	Card (if used):	Not Used
o Location:		Тор	Dead Ce	nter		Surface	Condition	·		Blended	
		Cleaner		Т	Penetrant			Remover		Develo	oper
Brand		Magnaflu		 	Magnaflux					Magna	·
	 -			 							·
Туре		SKC-S		 	SKL-HF/S		·	SKC-S		SKD	S2
Batch No.		97H11K			87C054			97H11K		97J0	4K
Time	Evap.	51	Min	Dwell	10 Min		Evap.	2 Mi	n	Develop	7 Min
	Time Ex	ram Starte	ed:	13:00			Time Exan	n Complete	ed.	14:45	
Indication	Loc	Loc	Diameter	Length	Туре				Remark	s	
No.	L	w			R/L						
	•										
											
 				l						·	
Comments:					<u> </u>						
None											
.		ALAD CO	16.1	D []							
Results:		NAD 🔽		D [] Ye	•e	Poviou	ved Previo	us Data:	-	No	
Percent Of Co	overage C	otained >	90%:			1/GAIGA	ved i tevio	us Data.			
Examiner	Level	II , .	Sign	ature		Revie	wer ng, David A	۸	,	Signature	5/9/0
Kilpela, Mati		/	Sign	ature		Site F			· * //	Signature 1	
N/A	FOAGI	/	Cigii		Date	1	ey, Charle	s R.	16	Musico	5/12/0
Other	Level	N/A	Sign	ature	Date		Review			Signature	Date
NIA		1				Heate	er, Stephe	n B.	de	esta Hoa	2 513.00

Site/Unit. NSP Summary No.: Examination For:	/ PI2 501377 ISI	Procedure Procedure Revision/F Work Order No	C: 8 / 99V	-	2000V393 } _1 of _3_	Page 1 of
Applicable Code: 1989 Description: Support A System ID: Si		ISÓ Drawing No.	:2-ISI- 60B	Location: _	Aux Building	İ
Component ID. H-1 Limitations: See attach	ned sketch.	Size/Length	n' <u>N/A</u>	Thick/Dia:75°		
Light Meter MFG: Temp. Too! MFG: Gray Card. 1/32" Direct & Visual Equipment/Alds: Fla: Visual Examination:			N/A Illun N/A	nination: N/A Surface Temp.: As Welded	FL/CDS N/A *F	
4) = 1	NAD IND N/A	19 20 21 22 23 46 24 25 26 Hy 27 28 29 No VN/A 30 31	oring Supports) Off Scale High) Off Scale Low) Locking Device In Place) Spring Degraded) Gross Misalignment schanical Snubbers) Swing Clearance Bent Extension Rod) Housing Damage rdraulic Snubbers) Reservoir Level) Leakage) Piston Fully Extended) Piston Fully Retracted) Reservoir Inverted) Piston Damage	NAD IND N/A	See Comments	
Percent Of Coverage Obtaine Examiner Level Johnson, Jeffery M. / Examiner Level N/A N/A	ind power in the state of the s	Date Rev 5/25/2000 Hall Date Site	ling, David A. /	No Signature A W U Signature	Date 5/31/00 Date 5-5/00	



:		8
	-	f
	3	

Report No.: 2000V393 Page 2 of 3

								report No		0013	-
Site/Unit:	NSP	1	Pi2	Procedure:	1	SI-V1	r-2.0	Page [.]	2	of	3
Summary No.:		5013	77	Procedure Revision/FC:	8	7	99VT2-1			•	
Examination For:		IS		_ Work Order No:		0000	232				
	-			<u> </u>							

Description of Limitation.

6" of weld on bottom of pads are inaccessible due to concrete pad.

Sketch of Limitation:

G:VDDEAL50YPI2RF02000YPI2 SUPPLEMENTALYPI2 SUPPLEMENTAL VT/2000V3

NON Accessable word word word Coverete Support Pad

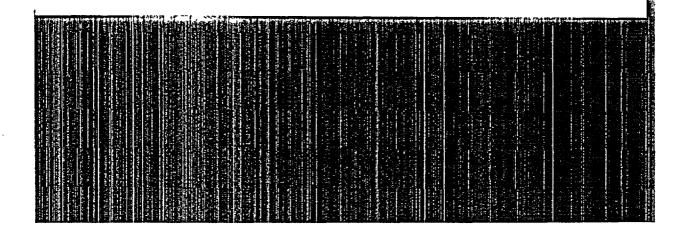
Looking South & NORTH

Limitations removal requirements:

None

Radiation field: <-5 mR / hr

Examiner Johnson, J	Level 11 leffery ML /	Signature	Date Reviewer 5/25/2000 Halling, David A.	Signature Dat
Examiner N/A	Level N/A	Signature	Date Site Review Kinney, Charles R.	Bignature Dat
Other N/A	Level N/A	Signature	Date ANII Review Heater, Stephen B.	Signature Dat





Determination of Percent Coverage for Surface Examinations

Attachment 19 Page 3 of 3

								Report No.:	20	00V3	93
Site/Unit:	NSP		PI2	Procedure:	1	ISI-VT-	2.0	Page:	3	of	3
Summary No:		5013	77	Procedure Revision/FC:	8	1	99VT2-1	_		_	
examination For:		ISI		Work Order No.:		00002	32	-			
Area Required (as show	n in ap	plicable co	de reference drawing)							
Lengt	h _	36.0	000 *	Width							
= Tota	al Area re	equired	72.	000 square inches							
								<u> </u>			
Coverage Achie	ved										
Area	examine	ed	60.00	sq in. / Total area require	ed (1009	6)	72.000	sq in.			
= Perc	ent cove	race .	£353	83 % (area required - area or	f limitati	 ons = 8	area examin	ed)			
					,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			,			
To determine le			mfa sa uti-1				_				

Note - Diameter refers to actual external diameter not pipe size (see table below)

Diameter 0.000 * (Pi) 3.1416

= Length 0.000 inches

Pipe Size	Actual Diameter	(Length) Circumference	Pipe Size	Actual Diameter	(Length) Circumference
2	2.375	7.46	12	12.75	40 06
2.5	2.875	9 03	14	14.0	43 98
3	3.5	11.0	16	16.0	50.27
35	40	12.57	18	18.0	56 55
4	45	14.14	20	200	62.83
5	5.563	17.48	22	22.0	69.12
6	6.625	20.81	24	240	75.40
8	8.625	27.10	30	30.0	94.25
10	10.75	33.77			

Site Field Supervisor:

Date[.]

5-31-0

Site/Unit: NSP Summary No : Examination For:	/ PI2 501385 ISI	Procedure Procedure Revision/FC: Work Order No:	t Supports and Sn	Report No.: 2000V394 Page. 1 of 3	_ ^ ^ ^
Applicable Code: 1989 Description: Support	В	ISO Drawing No.: _	2-ISI- 60B	Location Aux Building	
System ID: SI Component ID: H-2 Limitations: See attac	ched sketch.	Size/Length:	N/A Thick/	Dia:75**	-
Light Meter MFG: Temp. Tool MFG: Gray Card: 1/32" Direct Visual Equipment/Aids. FI	N/A N/A ☑ 1/64" Remote □ ashlight, Mirror, Neu				DS F
Visual Examination: Observed Condition All Components 1) External Obstruction 2) Cracks or Linear Ind. 3) Loose Parts 4) Missing Parts 5) Obstr. To Moving Parts 6) Wear 7) Corrosion 8) Contaminants 9) Improper Weld Reinfor. 10) Physical Deformation 11) Misuse 12) Slipped Clamps 13) Other (Describe) 14) Correct Settings	NAD IND N/A	20) Or 21) Lo 22) Sp 23) Gi Mech. 24) Sc 25) Be 26) Ho Hydra 27) Ro 28) Le 29) Pi	g Supports NAD If Scale High If Scale Low cking Device In Place pring Degraded ross Misalignment anical Snubbers ving Clearance ent Extension Rod pusing Damage ulic Snubbers eservoir Level akage ston Fully Extended eservoir Inverted	IND N/A See Commen	ts

Level II Examiner Date Reviewer Johnson, Jeffery M. 5/25/2000 Halling, David A. Examiner Level N/A Date Site Review N/A Kinney, Charles R. Other Level N/A Signature Date ANII Review N/A Heater, Stephen B.

Reviewed Previous Data:

No

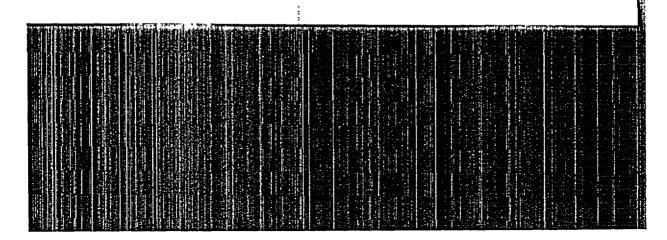
None .

Results:

NAD 🗹

Percent Of Coverage Obtained > 90%:

IND 🗌



100	G	
	5	3

Attachment 20 Page 2 of 3

							Report No.:	21)00V3	94	
Site/Unit:	NSP	1	PI2	_ Procedure:	1	ISI-VT-2.0	Page:	2	of	3	•
Summary No.:		5013	85	Procedure Revision/FC:	8	/ 99VT2-1			- ·	<u> </u>	-
Examination For:	ISI			Work Order No:	0000232						
_											_

Description of Limitation:

6" of weld on bottom of pads are inaccessible due to concrete pad.

Sketch of Limitation:

G.VDDEAL50/PI2RFO2000/PI2 SUPPLEMENTAL/PI2 SUPPLEMENTAL VT/2000/3

Looking West & EAST SI Pump CASING

Non Amessable weld weld Coverete. Support Pad

Looking South & North

SI
Pump
CASWG

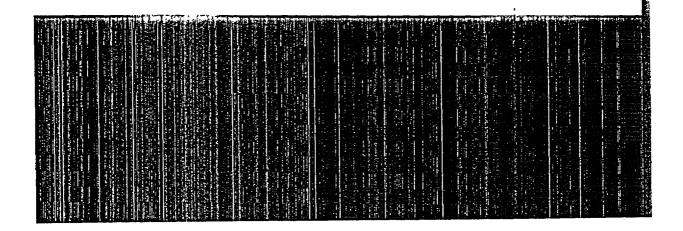
NON Accessable
Support:
Pad -

Limitations removal requirements:

¹None

Radiation field. <-5 mR / hr

Examiner Johnson, J	Level Jeffery ML /	Signature	Date Reviewer 5/25/2000 Halling, David A.	Signature Date 1 SALLU 5/31/00
Examiner N/A	Level N/A	Signature	Date Site Review Kinney, Charles R.	1 Signature Date
Other N/A	Level N/A	Signature	Date ANII Review Heater, Stephen B.	Gignature Date





Determination of Percent Coverage for Surface Examinations

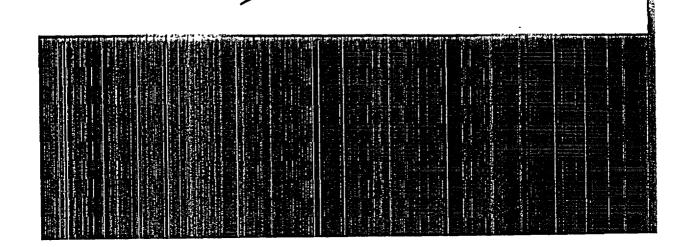
Attachment 20 Page 3d 3

							Report I	۷o: _	20	00V3	14
Site/Unit:	NSP	/ P12		Procedure:		ISI-VT-2.0	Pa	ige.	3	of	3
Summary No.:		501385	Procedure	Revision/FC.		8 / 99	VT2-1				
Examination For:		ISI	Wo	rk Order No.:		0000232					
Lengt		36.000	-	2.000 e inches							
Coverage Achie	examine		7	Total area req	•	00%) 7:	2.000 sq in.		· ·	_	
	•		external diameter r		see tabl	le below)			-		
	Length _	0.000	* (Pi) <u>3.1416</u> inches	•							
	Pipe	Actual	(Length)		Pipe	Actual	(Length)				
	Size	Diameter	Circumference	!	Size 12	Diameter 12.75	Circumference 40 06				
	2	2.375	7.46 9.03		14	14.0	43 98				
	2.5	2.875 3.5	11.0	[16	16.0	50.27				
•	35	4.0	12.57		18	18 0	56.55				
	4	. 45	14.14	1	20	20.0	62.83				
	5	5.563	17.48	1	22	22.0	69 12				
	6	6 625	20.81	1	24	24.0	75 40				
	8	8 625	27.10	1	30	30.0	94.25	l			

Site Field Supervisor.

Date

5-31-0



Site/Unit: Summary No.: Examination For:	k	P12 390 SI	Proc	edure Revis	cedure: _ ion/FC· _ ler No.: _	8	/T-2.0 / 99\ 0232	/T2-1	Report Pa	_	2000V388 1 of 3	
Applicable Code 19 Description: Si System ID. Si	apport C		_	ISO Drawing	J No.:	2-isi-	60-b		Locat	ion:	Aux Bulldin	<u>g</u>
Component ID. H	-3	sketch		Size/L	ength:	N/A	•	Thick/I	Dia.	.75"		_
Light Meter MFG: Temp. Tool MFG: Gray Card. 1/32*		N/A N/A	io □ S	Serial No.	:	N/A N/A	lliur		rface Te	N/A	Ft/C	cos *F
Visual Equipment/Aid	ds: Flashlig				on:			N/.	<u> </u>			-]
Visual Examination Observed Condition				:								_
All Components 1) External Obstruct 2) Cracks or Linear				Còmments	19) Off	Supports Scale High Scale Low		NAD		N/A :	See Comme	nts
3) Loose Parts 4) Missing Parts 5) Obstr. To Moving 6) Wear	g Parts			<u>:</u>	22) Spri 23) Gro	king Device I ng Degraded ss Misalignm	í ent					
7) Corresion 8) Contaminants 9) Improper Weld F	Zeinfor -d				24) Swir 25) Ben	ical Snubbeing Clearance t Extension F sing Damage	e Rod			<u>v</u>	_	
10) Physical Deform 11) Misuse					Hydrau	ic Snubben ervoir Level				<u>~</u>	_	
12) Slipped Clamps 13) Other (Describe)			<u>v</u> 	<u>-</u>		on Fully Exte				<u> </u>	_	
14) Correct Settings 15) Actual Setting		Yes _ N/A	No	N/A	•	on Fully Retr ervoir Inverte			 -			
16) Serial No Constant Load Sup 17) Travel Stops in I	-	N/A		- - :		on Damage				<u></u>		
18) Housing Damag			<u>~</u>	<u>.</u>								
Comments None				,								
Results: Percent Of Coverage	NAD ☑ Obtained >:	IND []	No	:	Reviewed	l Previous D	ata:	N	io			- An Arthur Arth
Examiner Level		Signat	re Å	Date					Signature			ate
Johnson, Jeffery M Examiner Level N/A	N/A /	Signar			Site Revi	ew Charles R.	<u>'</u>	N.	e Idaa Signaturi Adda	بلام	6/1/00 2-1-0	1 88
Other Level	N/A /	Signatu	re	Date	ANII Rev Heater, S	iew Stephen B.	1	Ty	ignatur		Da G-fac	1 10%
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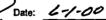
Attachment 21 Page 2 6 3

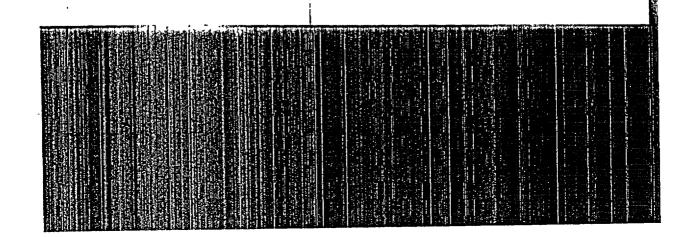
		LIM	itation	Record					Pag
Site/Unit	NSP / PI2		Denne d		101127	Report No		2000V3	88
Summary No.:	501390	Procedur	Proced e Revision		/ 99VT2-	Pag	e. —	2 of	
Examination For:	ISI					<u>-</u>			
			/ork Order	No.:	0000232				
Description of Limitat			_	_			•		
or werd ou portor	n of pads are inacce	ssible due to co	oncrete pa	d.					
		•							
		•							
Sketch of Limitation:	G VIDDEAL50VP	12RF02000\P12 St	JPPLEMEN'	TALVPI2 SUPPI	LEMENTAL VIV	000/3			
						,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,			
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	4					SI			
		Wa	-0		1	Pump			
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Limitations removal re	acuiremente:								
None	equaements.		•						
NOIR									
•			:						
Radiation field. < 8	5 mr/hr		•						
xaminer Level	II (Sigi	nature		Reviewer		Signatu			Date
Johnson, Jeffery M.				Halling, Dav	ld A. /	EXA Ball	<u> </u>	6/	1/00
Examiner Level N/A	N/A Sign	nature		Site Review Kinney, Cha	rios R	Signatu		\ /	Date / C
Other Level		nature	Date	ANII Review	10012	Signatu	re /	-)0	Date
N/A	····/			Heater, Step	hen B. /	Auch &	The) 6	400
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	T TOREST TORE	of he serves the taken	200 b-12 B-202	na rekonduktion	Arthur and white Book words	nerson and the section was in a	702 P. C.		on plications
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HELLER									
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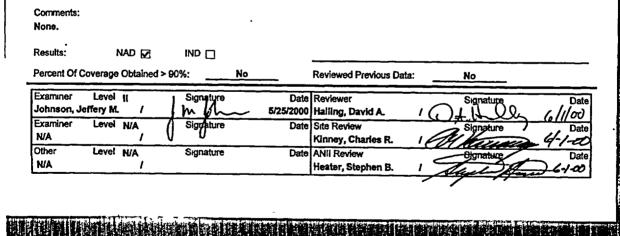


Determination of Percent Coverage for Surface Examinations Page 3 of 3

Site/Unit:	NSP	/ P12		D			F	Report No.:	200	0V3	88
Summary No.:		501390	Procedure	Procedure:		ISI-VT-2.0		Page	3	of	3
Examination For:				Revision/FC:	8	/ 99	VT2-1				
Continuon Pol.		ISI	Wo	rk Order No:		0000232					
Area Required (a		36.000		awing) 2.000							
= Total	Area rec	uired	72.000 squar	e inches				•			
			:								
											
Coverage Achiev	ed										
Area e	examined	60.	900 sq. in. / 1	Total area requin	ed (10	00%)72	2.000	ed. in			
= Perce	nt covera	nge of	## 83 % (area	required - area o	of limit	ations = area	examined)				
		~ 									
		- 						····			
To determine len	gth of a	circumferent	ial weld :	not pipe size (se		e below)					
To determine len	gth of a meter re	circumferent fers to actual 0.000	ial weld external diameter)	not pipe size (se		e below)					
To determine len Note - Dia	gth of a	circumferent	ial weld :	not pipe size (se		a below)					
To determine len Note - Dia	gth of a uneter reameter	circumferent fers to actual 0.000 0.000	ial weld : external diameter; (Pi) 3.1416 inches	not pipe size (se	ee table		T. Gen	11)			
To determine len Note - Dia	gth of a meter re	circumferent fers to actual 0.000	ial weld external diameter)	not pipe size (se		e below) Actual Diameter	(Leng Circumfe	th)			
To determine len Note - Dia	gth of a meter remained or meter met	circumferent fers to actual 0.000 0.000	ial weld : external diameter ; (Pi) 3.1416 inches (Length)	not pipe size (se	ee table	Actual Diameter 12.75	Circumfe 40.0	rence 6			
To determine len Note - Dia	gth of a commetter remarker	circumferent fers to actual 0.000 0.000 Actual Diameter 2.375 2.875	external diameter and the second seco	not pipe size (se	ee table	Actual Diameter 12.75	40.0 43.9	rence 6 8			
To determine len Note - Dia	gth of a cumeter resumeter	0.000 0.000 Actual Diameter 2.375 2.875 3.5	external diameter) (Pi) 3.1416 inches (Length) Ckroumference 7.48 9.03 11.0	not pipe size (se	Pupe Size 112 14 18	Actual Diameter 12.75 14.0 16 0	40.0 43.9 50.2	rence 6 8 7			
To determine len Note - Dia	gth of a cumeter resumeter	0.000 0.000 Actual Diameter 2.375 2.875 3.5 4.0	ial weld external diameter and the second of	not pipe size (se	Pupe Size 12 14 16 18	Actual Diameter 12.75 14.0 16 0 18.0	40.0 43.9 50.2 56.5	rence 6 8 7			
To determine len Note - Dia	gth of a meter remeter remeter	0.000 0.000 Actual Diameter 2 375 2.875 3.5 4.0 4.5	tal weld external diameter) (Pi) 3.1416 inches (Length) Circumference 7.48 9.03 11.0 12.57 14.14	not pipe size (se	Pupe Size 12 14 16 18 20	Actual Diameter 12.75 14.0 16 0 18.0 20 0	40.0 43.9 50.2 56.5 62.6	7			
To determine len	gth of a meter remeter remeterength	0.000 0.000 Actual Diameter 2 375 2.875 3.5 4.0 4.5 5.563	tal weld : (Pi) 3.1416 inches (Length) Circumference 7.48 9.03 11.0 12.57 14.14 17.48	not pipe size (se	Pupe Size 12 14 16 18 20 22	Actual Diameter 12.75 14.0 16 0 18.0 20 0 22.0	40.0 43.9 50.2 56.8 62.8	rence 6 8 7 5 3 2			
To determine len	gth of a meter remeter remeter	0.000 0.000 Actual Diameter 2 375 2.875 3.5 4.0 4.5	tal weld external diameter) (Pi) 3.1416 inches (Length) Circumference 7.48 9.03 11.0 12.57 14.14	not pipe size (se	Pupe Size 12 14 16 18 20	Actual Diameter 12.75 14.0 16 0 18.0 20 0	40.0 43.9 50.2 56.5 62.6	rence 6 8 77 5 3 2			







18) Housing Damage



Attachment 22
Page 2 of 3
Report No.: 2000V389

Site/Unit: NSP / Summary No.:

Procedure: Procedure Revision/FC:

Work Order No.:

ISI-VT-2.0 / 99VT2-1 0000232

Page 2 of 3

Description of Limitation.

Examination For:

6" of weld on bottom of pads are inaccessible due to concrete pad.

Sketch of Limitation:

G VDDEAL50/PI2RFO2000/PI2 SUPPLEMENTAL/PI2 SUPPLEMENTAL VT/2000/V3

Looking West & EnsT SI Pump Casing.

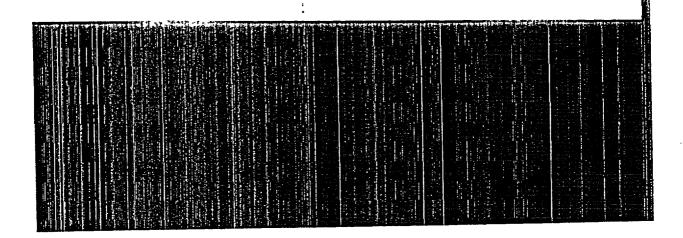
Looking South & North NOW Accessable weld Support.

Limitations removal requirements:

'None

Radiation field: <5 mR/hr

Examiner Johnson,	Level Jeffery M.	-	Signature		Reviewer Halling, David A.	Signature	Date 6/1/00
Examiner N/A	Level	N/A /	Signature		Site Review Kinney, Charles R.	Signature	Date 6-1-05
Other N/A	Level	N/A /	Signature	Date	ANII Review Heater, Stephen B.	Signature	Date 2-1-00



Affachment 22 Determination of Percent Coverage for Surface Examinations Page 3 of 3

Site/Unit:					Report No:	2000V3	103
	NSP / PI2	Procedure:	tsi-V	T-2.0	Page:		_3
Summary No.:	501396	Procedure Revision/FC		99VT2-1	•		
examination For:	ISI	Work Order No.: _	000	232	_		
			000	232			
Area Required (as	showπ in applicable co	de reference drawing)					
Length	36.000	Width 2.000					
= Total	Area required	square inches					
							
Coverage Achieve	d						
	camined 60.00		•	72.000	sq. in.		
= Percen	t coverage	783 % (area required - area o	of limitations :	area examin	ed)		
	77						
	-						
To determine leng	th of a circumferential	weld					
Note - Diar	neter refers to actual ext	ternal diameter not pipe size (se	e table below)			
Dia	neter0.000	(Pi) 3.1416					
= L:	ength 0.000	inches					
		•					
i	Pipe Actual	(Length) P	ipe Act	ıal (L	ength)		
ļ			ize Diam		mference 10 06		
}	2 2.375 2.5 2.875		12 12 14 14		43.98		
	3 3.5		16 16		50.27		
		12.57	18 18	0 :	56.55		
	35 4.0		20 20		62.83		
•	4 45		~~ ~~				
	4 45 5 5.563	17.48	22 22		59.12		
	4 45 5 5.563 6 6.625	17.48 20 81	24 24	0	75.40		
-	4 45 5 5.563	17.48 20 81		0			
	4 45 5 5.563 6 6.625 8 8 625	17.48 20.81 27.10	24 24	0	75.40		
-	4 45 5 5.563 6 6.625 8 8 625	17.48 20.81 27.10 33.77	24 24 30 30	0	75.40		
Site Field Supervis	4 45 5 5.563 6 6.625 8 8625 10 1075	17.48 20.81 27.10 33.77	24 24	0	75.40		
Site Field Supervis	4 45 5 5.563 6 6.625 8 8625 10 1075	17.48 20.81 27.10 33.77	24 24 30 30	0	75.40		
Site Field Supervis	4 45 5 5.563 6 6.625 8 8625 10 1075	17.48 20.81 27.10 33.77	24 24 30 30	0	75.40		
Site Field Supervis	4 45 5 5.563 6 6.625 8 8625 10 1075	17.48 20.81 27.10 33.77	24 24 30 30	0	75.40		
Site Field Supervis	4 45 5 5.563 6 6.625 8 8625 10 1075	17.48 20.81 27.10 33.77	24 24 30 30	0	75.40	201 6 1	
Site Field Supervis	4 45 5 5.563 6 6.625 8 8625 10 1075	17.48 20.81 27.10 33.77	24 24 30 30	0 0	75.40	501 (1)	
Site Field Supervis	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77	24 24 30 30	0 0	75.40		
	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77	24 24 30 30	0	75.40	50 i € 1	
Site Field Supervis	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77	24 24 30 30	0 0	75.40	7.44 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1	
	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77 Date.	24 24 30 30	0 0	75.40		
	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77 Date.	24 24 30 30	0 0	75.40		
	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77 Date.	24 24 30 30	<u>රෙ</u>	75.40		
	4 45 5 5.563 6 6.625 8 8 625 10 10 75	17.48 20.81 27.10 33.77 Date.	24 24 30 30	0	75.40		
	4 45 5 5.563 6 6.625 8 8 625 10 1075	17.48 20.81 27.10 33.77 Date.	24 24 30 30	0 0	75.40	Port of the state	

RSP

Visual Examination of Component Supports and Snubbers

Site/Unit: NSP	/ PI2	Ď			Report No.:	2000V314
	÷501412	Procedure Revision		T-2.0	Page:	
Examination For:	ISI			99VT2-1	•	5:21 od
	191	Work Orde		0232		4 - -
Applicable Code: 1989		ISO Drawing	No.: 2-131-6	9-a	Location:	Aux
Description: Support A	1					
System ID: RH				1		
Component ID: H-1		Size/Le	ength: N/A	Thick	/Dia: N/A	
Limitations: None						-
Light Meter MFG:	N/A	Serial No.:	N/A'	Illumination	i: N/A	FLICOS
Tèmp. Tool MFG:	ŇÁ	Serial No.:	N/A	· .	urface.Temp.	N/A *F
Gray Card: 1/32" Direct			on)	Painted ,		*****
Visual Equipment/Aids: Fla	shlight, Mirror, Cam	era, 6" Scale, Neu	tral Gray Card		-	
Visual Examination:					* *	
Observed Condition			•			
•	NAD IND NA	See Comments	Spring Supports	"NAD	IND NA	See Comments
1) External Obstruction	<u> </u>	Section Control of the Control of th	19) Off Scale High	• .	, <u>v</u>	ore commission
2) Cracks or Linear ind.	~		20) Off Scale Low	 -		
3) Loose Parts	<u>v</u>	- -	21) Locking Device In	Place		
4) Missing Parts	<u> </u>		22) Spring Degraded			
5) Obstr. To Moving Parts 6) Wear		·	23) Gross Misalignme			·
7) Corrosion			Méchanical Snubber 24) Swing Clearance		وراس	
8) Contaminants			25) Bent Extension R		<u> </u>	-
9) Improper Weld Reinfor.			26) Housing Damage	 	<u>~</u>	Alla Communicación
10) Physical Deformation			Hydraulic Snubbers			*************************************
11) Misuse	<u> </u>		27) Reservoir Lèvel			
12) Slipped Clamps			28) Leakage			
13) Other (Describe)	, <u>v</u>	3	29) Piston Fully Exten			
14) Correct Settings		No × N/A		-	<u> </u>	. **********
15) Actual Setting	N/A)	31) Reservoir Inverted			- pronouncias
16) Serial No.	N/A _		32) Piston Damage			and the second s
Constant Load Supports		Arr 1/3 dz	April of marris marriages	1.		***************************************
17) Travel Stops in Place	v .	_				
18) Housing Damage						
Comments: The plant of the second of the sec		To will the block he	-41 /4°	±		3
Cracking of base paylously	Lisboirea. Vaisieie	ie: Kebött noo-no)8. Current condition	įs more seven	e than previou	isly reported.
Results: NAD	IND 🗹					
Percent Of Coverage Obtaine		res . í	Salamad Dandaya Da		/es	
Seloeur nu constrate Artanie	id > 8ń¼;	es ,	Reviewed Previous Dal	ia:	'es	-
Examiner Level II	D (Signature)		Reviewer	لِتِسرِ.	Signature.	Date
Auer, Robert G.	Book		Halling, David A.	1 4	JA 1977	J. 3/13/09
Examiner Level N/A	Gignature		Site Review	100	Signature	Date
N/A I I	- Clandum		Kinney, Charles R.	1 CAY	Geging	- 15-24-20
Other Level N/A	Signature		ANII Review Heater, Stephen B.		Signature	Date
	* * *1		nestal nekneli m.	Kly	el Hours	\$ 2400



Attachment 23 Page 2 of 8

					Report No.:		2000V	314
						Page:		88
Summary No.:	501412						•	17 H
Examiner.	Auer, Robert G.	Level	Jt .	Reviewer	Halling, David A.		Date: 5	113/00
Examiner:	ÑĄ	Level:	-N/A	Site Review:	Kinney, Charles R.		Date: ,5	
Other:	N/A	Level:	AŴ.		Heater, Stephen B.		Date: メカ	
					,			

Comments:

- 2) and 10) Northeast End 2 Cracks, 1.65" L. from bolt area through grout across top of pedestal, over comer and down backside of pedestal. One location had a depth of 0.4" L.
 - Southwest End Cracked from bolt area through grout and along base of grout to edge of pedestal, 4.3" L.
 - Middle Crack runs from bolt area through grout to top of pedestal, then in both directions at base of grout such that the entire length of grout is cracked at the base, 15" L. This area shows evidence of the concrete being upset by less than 0.1".



Report No.: 2000V314

Page:

Summary No.: 501412

Examiner: Auer, Robert G.

Examiner: N/A

Other: N/A

Level:

Level:

Level: N/A

N/A

Reviewer: Halling, David A.

Site Review: Kinney, Charles R.

ANII Review: Heater, Stephen B.

Comments: Northeast End

Sketch of Photo: G:UDDEAL50/PI2RFO2000/PI2 SUPPLEMENTAL/PI2 SUPPLEMENTAL VT/2000/V3





Attachmens 23

Report No.:

.2000V314

Page:

Summary No.: 501412

Examiner: Auer, Robert G.

Examiner: N/A

Other: N/A

Level: IÍ

Level: ΝA Level: NA Reviewer: Halling, David A.

Site Review: Kinney, Charles R.

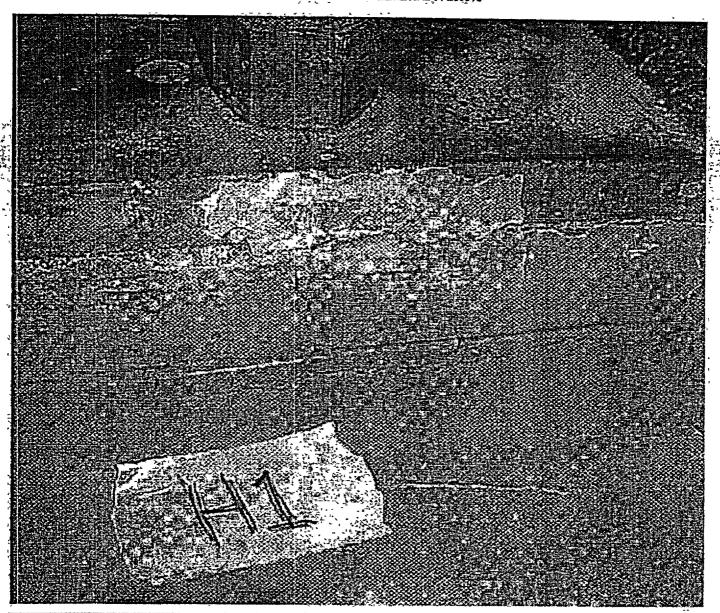
ANIL Review: Heater, Stephen B.

Date: 5-24-00

Date: 5-29

Comments: Middle

Sketch or Photo: G:\IDDEAL50\PI2RFO2000\PI2.SUPPLEMENTAL\PI2.SUPPLEMENTAL\VT\2000\V3





Attachment 23 Page 5 of 8

Report No.: 2000V314

Page:

Summary No.: 501412

Examiner: Auer, Robert G.

Examiner: N/A Other: N/A

Level:

Level: N/A

Level: N/A

Reviewer: Halling, David A.

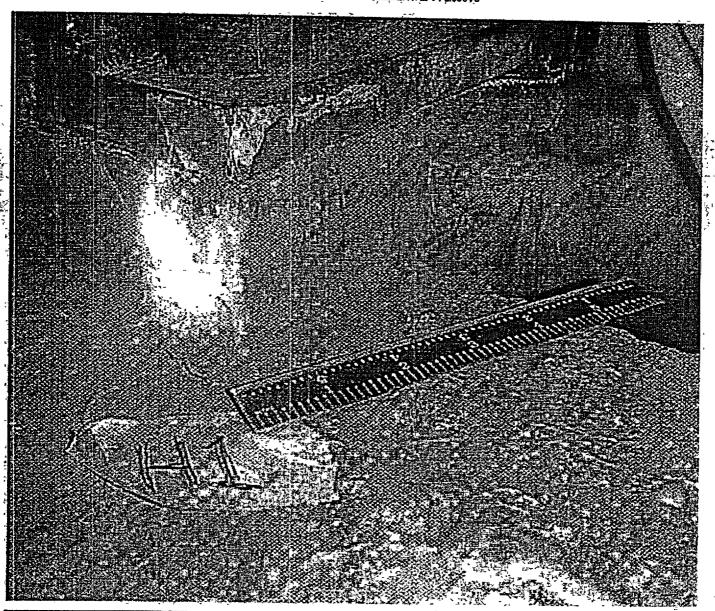
ANII Review: Heater, Stephen B.

Site Review: Kinney, Charles R.

Date: 5-24-00

Comments: Southwest End

Sketch or Photo: G:\UDDEAL50\PI2RFO2000\PI2 SUPPLEMENTAL\PI2 SUPPLEMENTAL VT\2000\V3





A Hachment 23 Page 6 of 8

2000V314 Report No.:

Summary No.: . 501412

Examiner: Auer, Robert G.

Examiner: N/A Other: N/A

Level: 'n Lévél: N/A

Level:

N/A

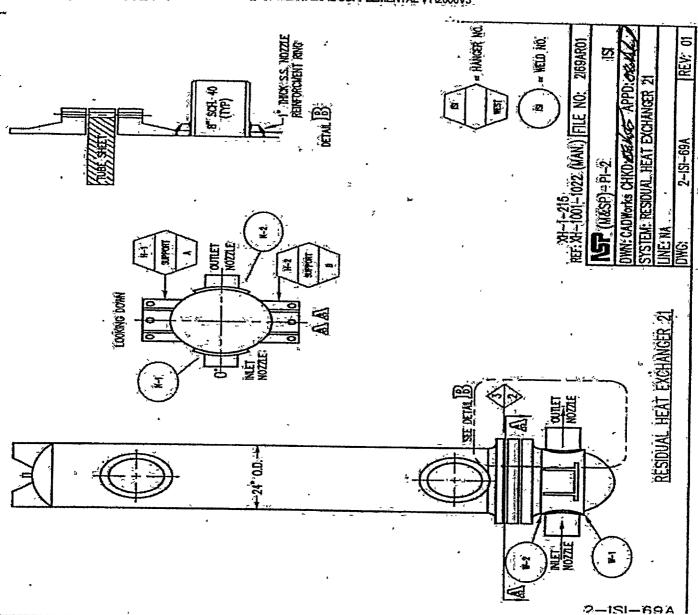
Reviewer: Halling, David A.

Site Review: Kinney, Charles R. ANII Review: Heater, Stephen B. Date: 5

Date: 35-24-00

Comments: None

Sketch of Photo: G.VDDEAL50VPI2RFO2000VPI2.SUPPLEMENTALVPI2.SUPPLEMENTAL VTV2000V3



Attachment 23 Page 7 of 8

ENGINEERING ISI 3RD INTERVAL DISCREPANCY DISPOSITION

UNIT 2 - 2000

Report Number: 2000V314

Item Description: #21 RHR Heat Exchanger Support A

Discrepancy: Various cracks noted in pedestal grout.

Disposition: Structural engineers at AES were contacted to review the subject

condition. NSP concurs with their determination that the observed cracks do not represent any structural degradation of the pedestal. See attached letter from Doctor-Setlur to Paul Hajovy dated May 22, 2000. This support

Is operable in its as found condition.

SM NOTIFIED: 5/15/00 1500

Prepared By: Date: 05-22-00

Reviewed By: A.M. Thouslehow Date: 5-22-00

PAGE 7 0F 8

REPORT # 2000 y 314

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AUTOMATED ENGINEERING SERVICES CORP.

Attachment 23 Page 8 of 8

3060 Ogden Ave., Suué 205 Lisle, IL 60532-1685 (630) 357-8880 Fax: (630) 357-4445 E-mail: desc@xnet.com

May 22, 2000

Mr. Paul Hajovy
Northern States Power Company
Prairie Island Nuclear Generating Plant
1717 Wakonade Drive East
Welch, MN 55089

Dear Mr. Hajovy:

Subject: Engineering Evaluations of ISI Examination Reports - Unit 2 Report Nos. 2000V313 and 2000V314 dated 5/13/2000

Automated Engineering Services Corp. (AES) has evaluated the subject reports involving the #21 RHR Heat Exchanger pedestal grout cracking. Cracks in the grout were observed and evaluated in 1986. The evaluation stated that these cracks were hairline cracks of the concrete/grout and that the cracks do not create any immediate concern for the safety of the plant. However, the evaluation recommended that the extent of the cracking should be investigated carefully for proper corrective action.

The cracks that were observed in the subject ISI reports are the same ones that were observed in 1986. Reviewing the photographs and the sketches, it is our opinion that the cracks have not grown or widened in the past 14 years. These cracks are superficial hairline cracks in the grout and may be partly through the concrete. They appear to have occurred during the shrinking of the concrete and grout during original installation of the pedestal.

Review of the pedestal structural drawings (NF 38298-3 &-5 and 38313-1) show that the each baseplate is anchored to the concrete by three 1-1/8" diameter 1'-8" long J-type cast-in-place anchor bolts in the pedestals supporting the HX. Because of the deep embedment of the anchor bolts, surface cracks will not have any adverse effect on the structural capability of these anchors. Therefore, in our opinion, the observed cracks do not represent any structural degradation of the pedestal.

If you have any questions, please give me a call. Thank you for the opportunity to be of service to Prairie Island and NSP.

Sincerely,

A.V. Setlur President

A. V. Settus

PAGE 8 OF 8 REPORT # 2000/314

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Site/Unit:	NSP	1	Pi2			Proce	edure:	isi-vt-	·2.0		J	Page: _	1 of	<u>8</u> 8
Summary No.:		50141	19`		Proce	dure Revisio		``	7Vee	72-1				74 5-22-00
Examination For:		ISI			. <u> </u>	Work Orde	r No.:	00002	32					* ***
Applicable Code:	1989				.1	SO Drawing	Ño.:	2-IsI-69	-a		Loca	ation:	RHR PIT 2	1
Description:		<u> 3</u> .								,				
System ID:														
Component ID;					. '	Size/Le	ngth:	N/A	•	Thick/I	Dla:	-N/A	<u> </u>	
Limitations	None							1						
Light Meter MFG:			N/A			_ Serial No."	_	N/A	Illum	ination:	<u> </u>	NA		CDŞ
Temp. Tool MFG: Gray Card: 1/3	: 32" Direct :[ें के के	NA Bar Bor	molio F	1 18.00	Serial No.:		N/A 1	př.		rface T	•	N/A`	_ ` F
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2) Cracks or Lin	ear Ind.	;			~	*************		off Scale Low				~	, 	
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7) Corrosion		<u>~</u>			· -		.24) S	wing Clearance	-			<u>:v</u>		
8) Contaminant		<u>~</u>		,	.	4.	,	ent Extension Ro	ď.			- 10		
9) Improper We		<u>~~`</u>	<u> </u>		:	· <u> </u>		lousing Damage		 -		<u> </u>	<u> </u>	
11) Misuse	MINDUON		<u> </u>	-	•	,,	Ρ.	leservoir Level				¥	_	
12) Slipped Clair	nos.			· · ·	•			eakage	•			~	,====	
13) Other (Descr	-				•	/		iston Fully Extend	led			~		
14) Correct Setti		,	Yes-		No .	N/A		iston Fully Retrac			***************************************	<u>~</u>		
15) Actual Setting	- •	***************************************	,	NA	,,0	,,,,,,,,,,,		teservoir inverted		<u></u>		<u>~</u>	-	
16) Serial No.		-		N/A		levirus	•	iston Damage	.			-	-	
Constant Load S	Supports			-		and the same of th	,,			\			· /ki-ki-ii-ii-i -	
17) Travel Stops	in Place			<u>:</u> ÿ	_	·								
(8) 'Housing' Dan	hage			<u>ن. </u>	·	,								
Comments:														
Results:	NAD [נ	IND	Ø		:								
Percent Of Cover	age Obtain	.ed > '9(J% <u>:</u>		Yes .		Review	ved Previous Data	<u>. </u>	۲' ،	(eš		; ;	
Examiner Le Auer, Robert G.	vel	all	Sign	raturge.			Reviev Hallin	ver g, Davíď Á.	ĵč		Signati 0 1	.00°.		pate 60
	vel N/A	V V	Sign	ature		Date	Site R		1/1	748	Signati	ITO .		Pate
Other Le	vel N/A		Sign	ature :		'Date	ANII R	(43	The state of the s	Gignat	Te de la constante de la const	5:240	Date ਲੇ



Attachment 24 Page 2 of 8

						Report No.:	20	00V313
						Page:		of \$ 8
Summary No.:	<u>501419</u>					•		5-22-00
Examiner:	Auer, Robert G.	¿Level:	-11	Revièwer:	Halling, David A.		Date:	5/13/w
Examiner:		Level:	, N/A	Site Review:	Kinney, Charles R.			5-24-00
Oth éri:	N/A	,Level:	ŅĄ	ANII Review:	Heater, Stephen B.			5-24-00
<u> </u>							•	1 41

Comments:

- Southwest End Crack runs from bolt area through grout then along base of grout for 14", also runs in opposite direction along base of grout around corner of grout to an area under the support, 6.5" L.
- Middle Crack runs from bolt area through grout, 1,5"L:

²⁾ and 10) - Northeast End - Crack runs from bolt area into grouf, 1.2" L



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Report No.: 2000V313

Page:

Summary No.: 501419

Examiner: Auer, Robert G.

Examiner: N/A

Other: N/A

Level:

Level: N/A Level: NA

Reviewer: Halling, David A.

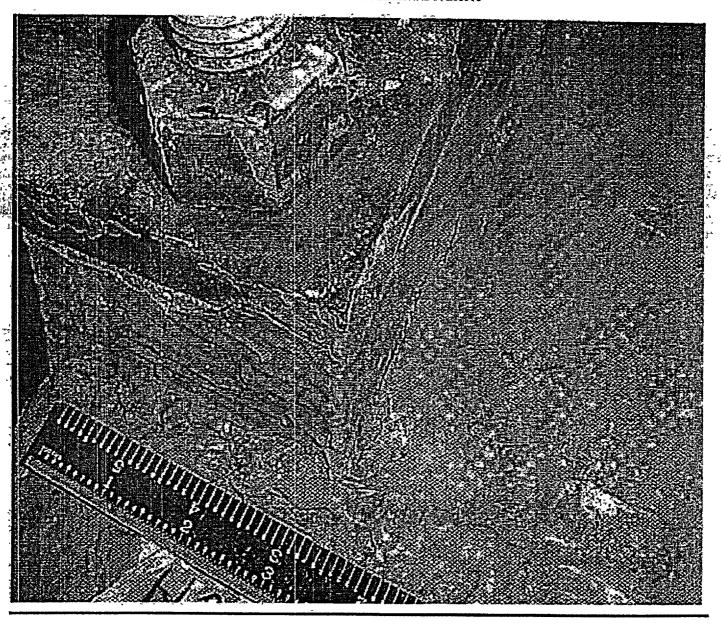
Site Review: Kinney, Charles R.

ANII Review: Heater, Stephen B.

Date: <u>5-24-00</u>

Comments: Southwest End

Sketch or Photo: G:VDDEAL50/PI2RFO2000/PI2 SUPPLEMENTAL/PI2 SUPPLEMENTAL VT12000/V3





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Page 4 of 8
Report No.: 2000V313

Summary No.: 501419

Examiner: Auer, Robert G.

Examiner: N/A

Other: N/A

Level: 11

Level: N/A

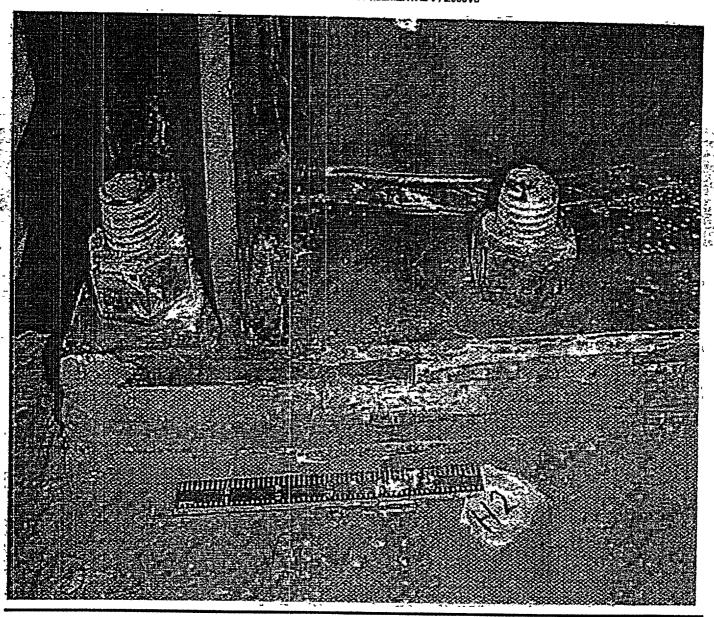
Level: NIA Reviewer: Halling, David A.

Site Review: Kinney, Charles R.

ANII Review: Heater, Stephen B.

Comments: Middle

Sketch or Photo: G'IDDEAL50\PI2RFO2000\PI2 SUPPLEMENTAL\PI2 SUPPLEMENTAL VT\2000V3





Attachment 24

Report No.: 2000V313

Summary No.: 501419

Examiner: Auer, Robert G.

Examiner: N/A

Other: N/A

Level:

Level:

Level: N/A.

N/A

Reviewer: Halling, David A.

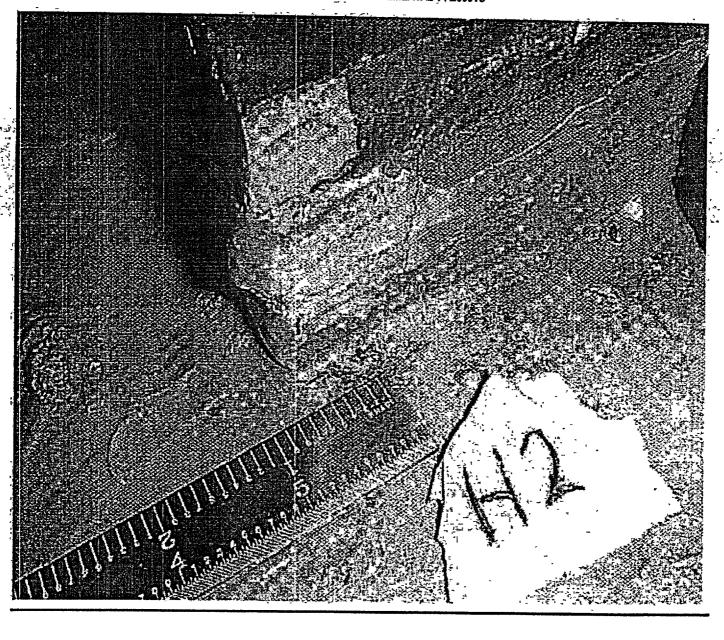
Site Review: Kinney, Charles R.

ANII Review: Heater, Stephen B.

Date: 5-24-00

Comments: Northeast End

Sketch or Photo: G:\u00e40DEAL50\PI2RFO2000\PI2 SUPPLEMENTAL\\PI2 SUPPLEMENTAL\\\VT\2000\V3



Attachmand 24 rage 6 of 8 Report No.: 2000 V313

Śupplemental Report



Date: 3-24-00 ANII Review: Heater, Stephen B. _Level; AIN AN Tierto Date: 8-14-60 Site Review: Kinney, Charles R. **Y/N** Level Examiner: MA Reviewer: Halling, David A. 11 Level: Examiner: Auer Robert G. 17. 8 8 10 Summas to Vision 501419 Page:

ənoM :ainəmmoລີ,

DWG; SYSTEM: RESIDUAL HEAT EXCHANGER: 21 Not (M&SP)-19-2 WN: CADWORKS CHIKD XXXXXXX 2-ISI-69A 2169AR01 WELD NO. HANGER NO. Skejch οι Ριίζίο: cinddealeoplishe cononti supplemental supplemental vizogova

Attachment 24 Page 7 of 8

ENGINEERING ISI 3RD INTERVAL DISCREPANCY DISPOSITION UNIT 2 - 2000

Report Number: 2000V313

Item Description: #21 RHR Heat Exchanger Support B

Discrepancy: Various cracks noted in pedestal grout.

Disposition: Structural engineers at AES were contacted to review the subject condition. NSP concurs with their determination that the observed cracks do not represent any structural degradation of the pedestal. See attached letter from Doctor Setlur to Paul Hajovy dated May 22, 2000. This support

is operable in its as found condition.

SM NOTIFIED: 5/15/00 1500

Prepared By: Date: 05-22-00

Reviewed By: SM. Shouldson Date: 5-22-00

PAGE 7 0F 8
REPORT # 2000 V 3/3

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AUTOMATED ENGINEERING SERVICES CORP.

Attachment 24
Page 8 of 8
3060 Ogden Ave., Suite 205
Liste, IL 60532-1685
(630) 357-8880
Fax: (630) 357-4445
E-mail: aesc@xhet.com

May 22, 2000

Mr. Paul Hajovy Northern States Power Company Prairie Island Nuclear Generating Plant: 1717 Wakonade Drive East Welch, MN 55089

Dear Mr. Hajovy:

Subject: Engineering Evaluations of ISI Examination Reports - Unit 2 Report Nos. 2000V313 and 2000V314 dated 5/13/2000

Automated Engineering Services Corp. (AES) has evaluated the subject reports involving the #21 RHR Heat Exchanger pedestal grout cracking. Cracks in the grout were observed and evaluated in 1986. The evaluation stated that these cracks were hairline cracks of the concrete/grout and that the cracks do not create any immediate concern for the safety of the plant. However, the evaluation recommended that the extent of the cracking should be investigated carefully for proper corrective action.

The cracks that were observed in the subject ISI reports are the same ones that were observed in 1986. Reviewing the photographs and the sketches, it is our opinion that the cracks have not grown or widened in the past 14 years. These cracks are superficial hairline cracks in the grout and may be partly through the concrete. They appear to have occurred during the shrinking of the concrete and grout during original installation of the pedestal.

Review of the pedestal structural drawings (NF 38298-3 &-5 and 38313-1) show that the each baseplate is anchored to the concrete by three 1-1/8" diameter 1'-8" long J-type cast-in-place anchor bolts in the pedestals supporting the HX. Because of the deep embedment of the anchor bolts, surface cracks will not have any adverse effect on the structural capability of these anchors. Therefore, in our opinion, the observed cracks do not represent any structural degradation of the pedestal.

If you have any questions, please give me a call. Thank you for the opportunity to be of service to Prairie Island and NSP.

Sincerely,

A.V. Setlur President

A. V. Setter

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Attachment 25

XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: **Limitations to NDE**

NUMBER: **ISI-LTS-1**

Revision 2

PREPARED BY:

亚 REVIEWED BY:

APPROVED BY:

ANII REVIEW:

EFFECTIVE DATE: 10-18-01

1.0 **PURPOSE**

This procedure provides instruction for identifying, quantifying and recording of limitations encountered while performing examinations under the ISI program.

2.0 REFERENCES

This procedure complies with the applicable portions of the following referenced documents:

- 2.1 American Society of Mechanical Engineers Boiler & Pressure Vessel Code:
 - Sections V and XI, 1986 edition, no addenda (Monticello Third Interval)
 - Sections V and XI, 1989 edition, no addenda (Prairie Island Third Interval)
- 2.2 Nuclear Regulatory Commission Regulatory Guide - 1.150 "Ultrasonic Testing of Reactor Vessel Welds during Preservice and Inservice Examinations", (Rev. 1 dated Feb. 1983).
- 2.3 Code case N-460 Alternative Examination Coverage for Class 1 and Class 2 Welds - Section XI, Division 1
- 2.4 ISI NDE Manual procedure
 - ISI-NDE-0 "Equipment, Personnel and Material Reporting".
- 2.5 Metals and Materials Resources Procedure
 - MMRN 2.3 "ISI Examination Program".
- 2.6 ISI Administrative Manual procedures
 - ISIA-1.4 "Preparation of Relief Request from ASME Section XI Code Requirements"
 - ISIA-2.2 "ISI Field Activities Preparation and Control

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

3.0 APPLICABILITY

3.1 This procedure is applicable to examinations performed at Xcel Energy's Nuclear Generating Plants.

- 3.2 This procedure is to be followed when it has been determined that there is a limitation which prevents obtaining full coverage of an area or volume as stated by the applicable examination procedure.
 - For ultrasonic examinations, this would mean less than all of the required scans and/or a reduction of required scan path for one or more scans.

4.0 DEFINITIONS

- 4.1 <u>Limitation</u> something that limits, restraint : An obstacle to the performance of an examination procedure.
- 4.2 <u>Evaluation</u> to determine the significance, worth, or condition of, usually by careful appraisal and study
- 4.3 <u>Practical</u> " of, relating to, or manifested in practice or action: not theoretical or ideal; concerned with voluntary action and ethical decisions. Useful." For this application this is interpreted to mean, for a specific case the benefits of a proposed action outweigh the negative aspects of that action.

5.0 PREREQUISITES

- 5.1 Personnel Requirements
 - Examination personnel certification and eye examinations shall be documented in accordance with ISI-NDE-0.
 - Nondestructive examination personnel shall be certified to a minimum of Level I in the appropriate method to operate equipment and Level II to interpret test results.

6.0 EQUIPMENT

This item is not applicable to this procedure. If alternate methods are required to augment coverage, that work shall be done under a separate procedure.

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

7.0 INSTRUCTIONS

7.1 Initial Examination

Where the examiner is not able to complete a full examination as dictated by applicable procedure, the following steps shall be taken;

- Complete original examination on accessible portions
- Make sketch which includes dimensions defining location and size of limitations using a report format similar to that shown in Fig 3.
- Describe the limitation including what it is and how it interferes with the exam.
 State what appears to be required to remove the limitation using a report format similar to that shown in Fig 3.
- For volumetric examinations, construct a surface profile using a surface contour gauge and perform a thickness profile (typically one reading each 1/2" in a line) of the area that encompasses the code required volume. For UT that would include the available scanning surface.
- Record radiation field information on the report (this may require assistance from the health physics group).
- Sign and date the data sheet then forward it to the Xcel Energy's Field Supervisor.

7.2 Evaluation

- The data gathered by the initial examiner shall be reviewed by the Xcel Energy's field supervisor / designee to determine if alternate methods may be used to achieve additional coverage.
- If alternate methods would provide additional coverage, a review of the benefit versus the required resources (radiation dose, time, cost etc.) to achieve that coverage shall be performed by the Xcel Energy's field supervisor to determine if that action is practical (see para 7.3).
- If it is determined that the entire examination volume or area cannot be examined due to interference by another component or part geometry, a reduction in examination coverage on any Class 1 or Class 2 weld may be accepted provided the reduction in coverage for that weld is less than 10%. The applicable examination records shall identify both the cause and percentage of reduced examination coverage (see para 7.4).

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

7.3 Alternate methods to achieve coverage

- For surface examinations, MT and PT may be interchanged / intermixed as appropriate to the material and the conditions.
- For volumetric examinations, RT may be substituted for or augment UT assuming the ability to drain the line, and that the wall thickness / diameter is within a practical range.
- For UT, use of other angles, full node or node and one half calibrations, skewed scans or approach from another surface to achieve additional coverage shall be considered.

7.4 Determining Coverage Achieved

When evaluation of initial and alternate examination methods results in examinations which do not provide full coverage, a determination of percent coverage shall be made. The required examination coverage is defined by applicable figures in ASME Sect XI.

- For surface examinations, a worksheet similar to that shown in Fig 4 shall be completed.
- For volumetric examinations, a worksheet similar to that shown in Fig 5 or 6 (ultrasonic examinations) shall be completed.
- 7.5 Should the evaluation show that 90% weld coverage has been achieved, attach all related information to the original NDE report and no further action is required.
- 7.6 Contractor procedures for performing examinations utilizing automated equipment (e.g. reactor vessel and nozzle safe-end exams) shall be reviewed by an Xcel Energy's level III in the appropriate method to ensure the requirements for identifying, quantifying and recording of limitations encountered are adequately addressed.
- 7.7 When it has been determined that the maximum examination coverage practically achievable for a code required item is less than required; a relief request is required to be submitted to the NRC (refer to ISIA 1.4).

8.0 ACCEPTANCE CRITERIA

This item is not applicable to this procedure.

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

9.0 REPORTING

- 9.1 Information addressed in Fig's 3, 4, 5 and 6 (as applicable) shall be reported.
- 9.2 Information for examinations that are required to meet Reg. Guide 1.150 shall also include the following from Appendix A Alternate Method;
 - 7.c "The best estimate of the portion of the volume required to be examined by the ASME Code that has not been effectively examined such as volumes of material near each surface because of near-field or other effects, volumes near interfaces between cladding and parent metal, volumes shadowed by laminar material defects, volumes shadowed by part geometry, volumes inaccessible to the transducer, volumes affected by electronic gating, and volumes near the surface opposite the transducer. Sketches and/or descriptions of the tools, fixtures and component geometry which contribute to incomplete coverage should be included."
- 9.3 Reference System

Recording of limitations shall be based on the reference system shown in the original examination procedure.

9.4 Documentation

A picture of the limitation should be taken and added to the description, preferably in a digital format.

10.0 RECORDS

- 10.1 Inservice inspection examinations shall be incorporated in the ISI records. See Metals and Materials Resurces North Procedure 2.3 "ISI Examination Program".
- 10.2 Records of other examinations shall be the responsibility of the organization requesting the examination.

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

Figure 1
Example of UT scan coverage 1/4 with no weld crown limits 45 deg ... minimum for one side exam Supplemental 60 deg exam

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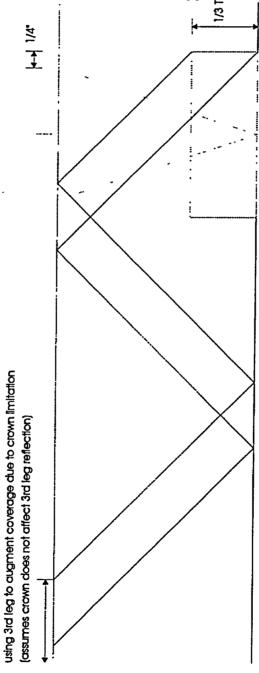
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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

Figure 2
Example of UT, one sided exam, supplemental coverage



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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

Figure 3 Limitation Data Sheet

Initial exam report #	Procedure #	
Description of Limitation		
Sketch of Limitation		
	•	
Limitation removal requirements		
Radiation field		
Examiner:	Date:	

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

Figure 4

<u>Determination of Percent Coverage for Surface Examinations</u> <u>This is a sample form only</u>

	Initial exam rpt # Procedure #							
	ISO#_				Item # _			
	Applicat	ole Code figu	ıre #	 -				
	Area Re	equired (as s	shown in applicable	e code re	eference	drawing)		
	Length_		* Width		_			
	= Total	area required	i:	square i	nches			
	Coverag	ge Achieved			·			
	Area exa	amined	sq. in.	/ Total a	area requ	ired (100%)	sq	. in.
			·% (a					
	To dete	rmine lengtl	h of a circumferer	ntial wel	d			
	Note - D	iameter refe	rs to actual externa	al diame	ter not pi	ipe size (see	table below)	
			_ *(Pi) <u>3.1416</u>		•	•	•	
		ļ <u>. </u>	• •					
	Pipe	Actual	(Length)		Pipe	Actual	(Length)	1
	Size	_ Diameter	Circumference		Size	Diameter	Circumference	1
	2	2.375	7.46		12	12.75	40.06]
	2.5	2.875	9.03		14	14.0	43.98]
i	3	3.5	11.0		16	16.0	50.27]
	2.5	4.0	40 E7		40	40.0	EO EE	1

Size	_ Diameter	Circumference		Size	Diameter	Circumference
2	2.375	7.46]	12	12.75	40.06
2.5	2.875	9.03	7	14	14.0	43.98
3	3.5	11.0		16	16.0	50.27
3.5	4.0	12.57		18	18.0	56.55
4	4.5	14.14	1	20	20.0	62.83
5	5.563	17.48	1	22	22.0	69.12
6	6.625	20.81]	24	24.0	75.40
8	8.625	27.10	7	30	30.0	94.25
10	10.75	33.77]			

Xcel Energy's Field Supervisor: Date:	
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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

Figure 5

<u>Determination of Percent Coverage for UT Examinations - Pipe</u> <u>This is a sample form only</u>

Initial exam rpt #	Procedure #
ISO#	Item #
Applicable Code figure #	_
45 deg	
Scan 1 % length X	_ % volume of length / 100 = % total for Scan 1
Scan 2 % length X	_ % volume of length / 100 = % total for Scan 2
Scan 3 % length X	% volume of length / 100 = % total for Scan 3
Scan 4 % length X	% volume of length / 100 = % total for Scan 4
Add totals and divide by # scan	s = % total for 45 deg
Other deg (to be used f	or supplemental scans)
The data to be listed below is for	coverage that was not obtained with the 45 deg scans.
Scan 1 % length X	% volume of length / 100 = % total for Scan 1
Scan 2 % length X	% volume of length / 100 = % total for Scan 2
Scan 3 % length X	% volume of length / 100 = % total for Scan 3
Scan 4 % length X	% volume of length / 100 = % total for Scan 4
Percent complete coverage	
Add totals for each scan required	and divide by # of scans to determine;
% total for complete	e exam
required scan volume) for total of	olus supplemental 60 deg scan 1 = 28% (of remaining 91% coverage for scan 1 volume. Repeat for the d divide by the # of scans (typically 4).
Xcel Energy's Field Supervisor:	Date:

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

Figure 6

<u>Determination of Percent Coverage for UT Examinations - Vessels</u> <u>This is a sample form only</u>

Initial exam rpt #	Procedure #	 ,
ISO#		
Applicable Code figure #		
0 deg Planar		
Scan % length X % v	volume of length / 100 =	% total for 0 deg
45 deg		
Scan 1 % length X % v	olume of length / 100 =	% total for Scan 1
Scan 2 % length X % v	olume of length / 100 =	% total for Scan 2
Scan 3 % length X % v	olume of length / 100 =	% total for Scan 3
Scan 4 % length X % v	olume of length / 100 =	% total for Scan 4
Add totals and divide by # scans =	% total for 45 deg	
60 deg		
Scan 1 % length X % v	olume of length / 100 =	% total for Scan 1
Scan 2 % length X % v	olume of length / 100 =	% total for Scan 2
Scan 3 % length X % v	olume of length / 100 =	% total for Scan 3
Scan 4 % length X % v	rolume of length / 100 =	% total for Scan 4
Add totals and divide by # scans =	% total for 60 deg	
Percent complete coverage		
Add totals for each angle and scan red	quired and divide by # angles	to determine;
% total for complete ex	am	
Note: Supplemental coverage may be used, the coverage for volume not obtacalculated and added to the total to pro-	ained with angles as noted ab	ove shall be
Xcel Energy's Field Supervisor:	Date:	

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XCEL ENERGY METALS & MATERIALS RESOURCES NORTH INSERVICE INSPECTION - NONDESTRUCTIVE EXAMINATION PROCEDURE

TITLE: Limitations to NDE

NUMBER: ISI-LTS-1 Revision 2

SUMMARY OF SIGNIFICANT CHANGES

Title block changed NSP to Xcel Energy and Materials & Special Processes to Metals & Materials Resources North.

2.1 Added no addenda to code years.

Changed O&MS to MMRN, two places.

Changed NSP to Xcel Energy's, seven places.

NORTHERN STATES POWER INSERVICE INSPECTION

SUMMARY REPORT

Attachment 26 SUMMARY REPORT Page 1 of 2 PRAIRIE ISLAND UNIT 2, 1998

APPENDIX D

LIST OF SECTION XI VT-2 EXAMINATIONS

1 Page

ISI RESULTS UNIT 2 3/30/97 - 1/1/99

E.F	

SYSTEM	class	Y-usupressüretesps (- Description	INTO SERVICE OF THE S	DRAWING	DATE SE
RC	11	Reactor Coolant	2070	NF-39835	12/29/1998
FW	2	Feedwater	2168.17	NF-39843	3/6/1998
vc	2 ·	Chemical Vol Control	2168.16	NF-39836-7	10/15/1997



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NORTHERN STATES POWER INSERVICE INSPECTION

SUMMARY REPORT
PRAIRIE ISLAND UNIT 2, 2000

APPENDIX B

LIST OF SECTION XI VT-2 EXAMINATIONS

1 Page

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ISI RESULTS UNIT 2 1/1/99 - 6/7/00

S CITEMA	GEASS	GIPPESSURETESTS) BESCRIPTION	MES PROCEDURE	EFFAWING:	DATE
RC	1	Reactor Coolant	2070	NF-39835	6/5/2000
CC	2	Component Cooling	2168.4A	NF-39844-1	4/29/2000
RH	2	Residual Heat Removal	2168.10	NF-39840	6/2/2000
MS	2	Main Steam	2168.11	NF-39842	6/5/2000
SI	2	Safety Injection	2168.12	NF-39838	5/29/2000
cs	2	Containment Spray	2168.14	NF-39824	5/29/2000
HC	2	Post LOCA	2168.15	NF-39830	5/31/2000
SS	2	Sampling System	2168.19	NF-39825	5/28/2000
RV	2	Vessel Vent System	2168.23	NF-39835	6/5/2000
	2	Containment Vent (Misc)	2168.24	NF-39847	6/3/2000
SI/RH/CS	2	RWST to RHR Pit Trench	2168.25	NF-39839	5/28/2000
				•	

The above tests were performed on Unit Two Code Class 1 and 2 systems between the dates of 1/1/99 and 6/7/00.