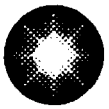
P.O. Box 63
Lycoming, New York 13093



Constellation Energy Group

Nine Mile Point
Nuclear Station

August 8, 2003
NMP1L 1711

U.S. Nuclear Regulatory Commission
Attn.: Document Control Desk
Washington, DC 20555-0001

SUBJECT: Nine Mile Point Units 1 and 2
Docket Nos. 50-220 and 50-410
License Nos. DPR-63 and NPF-69

Request for Relief from Qualification Requirements for Dissimilar Metal Piping Welds

Gentlemen:

Nine Mile Point Nuclear Station, LLC (NMPNS) is submitting inservice inspection relief requests ISI-24A and ISI-24B for Nine Mile Point Unit 1 (NMP1) and Unit 2 (NMP2), respectively. Upon NRC approval, these relief requests will allow utilization of the performance demonstration initiative (PDI) program as an alternative to the American Society of Mechanical Engineers Boiler and Pressure Vessel Code (ASME Code), 1995 Edition with 1996 Addenda, Section XI, Appendix VIII, Supplement 10 requirements for dissimilar metal piping weld examinations. Relief is being requested in accordance with 10CFR50.55a(a)(3)(i) on the basis that the proposed alternative will provide an acceptable level of quality and safety. By letter dated June 23, 2003, the NRC approved similar relief requests for Florida Power and Light Company's St. Lucie Nuclear Plant, Units 1 and 2.

Relief requests ISI-24A and ISI-24B (included as Attachments 1 and 2) are based on Revision 1 of the Generic Requests for Relief for Supplement 10, as developed by PDI. The Enclosure cited in each relief request (included as Attachment 3) was prepared by PDI to compare the Supplement 10 requirements with the PDI proposed alternative requirements. Changes between the Supplement 10 requirements and the PDI proposed alternative requirements are highlighted by bold or "lined-through" text in the PDI proposed requirements.

A047

NMPNS requests NRC approval of relief requests ISI-24A and ISI-24B by February 15, 2004, to support weld examinations planned for NMP2 during the Spring 2004 refueling outage (RFO9).

Very truly yours,

Peter E. Katz
Vice President Nine Mile Point

BSM/IAA/jm
Attachments

cc: Mr. H. J. Miller, NRC Regional Administrator, Region I
Mr. G. K. Hunegs, NRC Senior Resident Inspector
Mr. P. S. Tam, Senior Project Manager, NRR (2 copies)

ATTACHMENT 1
(Relief Request ISI-24A for Nine Mile Point Unit 1)

NINE MILE POINT UNIT 1
THIRD INSERVICE INSPECTION INTERVAL
RELIEF REQUEST ISI-24A

A. COMPONENT IDENTIFICATION

System:	Various Systems
Class:	Quality Group A, ASME Code Class 1
Component Description:	Pressure Retaining Piping Welds subject to examination using procedures, personnel, and equipment qualified to ASME Section XI, Appendix VIII, Supplement 10 criteria
Component Identification:	Attachment 1 provides a list of applicable dissimilar metal welds

B. ASME CODE SECTION XI REQUIREMENTS

ASME Section XI, 1995 Edition with 1996 Addenda, Appendix VIII, Supplement 10, "Qualification Requirements For Dissimilar Metal Piping Welds."

The following paragraphs or statements are from ASME Section XI, Appendix VIII, Supplement 10 and identify the specific requirements that are included in this request for relief.

Item 1 - Paragraph 1.1(b) states in part - Pipe diameters within a range of 0.9 to 1.5 times a nominal diameter shall be considered equivalent.

Item 2 - Paragraph 1.1(d) states - All flaws in the specimen set shall be cracks.

Item 3 - Paragraph 1.1(d)(1) states - At least 50% of the cracks shall be in austenitic material. At least 50% of the cracks in austenitic material shall be contained wholly in weld or buttering material. At least 10% of the cracks shall be in ferritic material. The remainder of the cracks may be in either austenitic or ferritic material.

Item 4 - Paragraph 1.2(b) states in part - The number of unflawed grading units shall be at least twice the number of flawed grading units.

Item 5 - Paragraph 1.2(c)(1) and 1.3(c) state in part - At least 1/3 of the flaws, rounded to the next higher whole number, shall have depths between 10% and 30% of the nominal pipe wall thickness. Paragraph 1.4(b) distribution table requires 20% of the flaws to have depths between 10% and 30%.

Item 6 - Paragraph 2.0 first sentence states - The specimen inside surface and identification shall be concealed from the candidate.

Item 7 - Paragraph 2.2(b) states in part - The regions containing a flaw to be sized shall be identified to the candidate.

Item 8 - Paragraph 2.2(c) states in part - For a separate length sizing test, the regions of each specimen containing a flaw to be sized shall be identified to the candidate.

Item 9 - Paragraph 2.3(a) states - For the depth sizing test, 80% of the flaws shall be sized at a specific location on the surface of the specimen identified to the candidate.

Item 10 - Paragraph 2.3(b) states - For the remaining flaws, the regions of each specimen containing a flaw to be sized shall be identified to the candidate. The candidate shall determine the maximum depth of the flaw in each region.

Item 11 - Table VIII-S2-1 provides the false call criteria when the number of unflawed grading units is at least twice the number of flawed grading units.

Item 12 - Paragraph 3.2(b) states - Examination procedures, equipment, and personnel are qualified for depth sizing when the RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in.

C. **RELIEF REQUESTED**

Pursuant to 10 CFR 50.55a(a)(3)(i), Nine Mile Point Nuclear Station, LLC (NMPNS) requests relief to use the proposed alternative Performance Demonstration Initiative (PDI) Program described below in lieu of the ASME Code Section XI, Appendix VIII, Supplement 10 requirements on the basis that the proposed alternative will provide an acceptable level of quality and safety for examination of the affected welds.

A copy of the proposed revision to Supplement 10 is attached as an Enclosure. It identifies the proposed alternatives and allows them to be viewed in context. It also identifies additional clarifications and enhancements for information. It has been submitted to the ASME Code for consideration and as of September 2002, has been approved by the NDE Subcommittee.

In addition, NMPNS requests relief from the depth sizing less than or equal to 0.125 inch RMS error.

D. **BASIS FOR RELIEF**

Item 1 - The proposed alternative to Paragraph 1.1(b) states:

"The specimen set shall include the minimum and maximum pipe diameters and thicknesses for which the examination procedure is applicable. Pipe diameters within a range of **½ in. (13 mm) of the** nominal diameter shall be considered equivalent. Pipe diameters larger than 24 in. **(610 mm)** shall be considered to be flat. When a range of thicknesses is to be examined, a thickness tolerance of ±25% is acceptable."

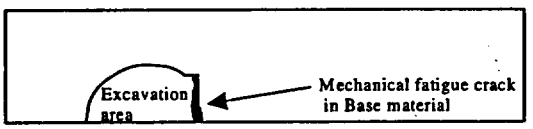
Technical Basis - The change in the minimum pipe diameter tolerance from 0.9 times the diameter to the nominal diameter minus 0.5 inch provides tolerances more in line with industry practice. Though the alternative is less stringent for small pipe diameters, they typically have a thinner wall thickness than larger diameter piping. A thinner wall thickness results in shorter sound path distances that reduce the detrimental effects of the curvature. This change maintains consistency between Supplement 10 and the recent revision to Supplement 2.

Item 2 - The proposed alternative to Paragraph 1.1(d) states:

"At least 60% of the flaws shall be cracks, the remainder shall be alternative flaws. Specimens with IGSCC shall be used when available. Alternative flaws, if used, shall provide crack-like reflective characteristics and shall be limited to the case where implantation of cracks produces spurious reflectors that are uncharacteristic of actual flaws. Alternative flaw mechanisms shall have a tip width of less than or equal to 0.002 in. (.05 mm). Note, to avoid confusion the proposed alternative modifies instances of the term "cracks" or "cracking" to the term "flaws" because of the use of alternative flaw mechanisms."

Technical Basis - As illustrated below, implanting a crack requires excavation of the base material on at least one side of the flaw. While this may be satisfactory for ferritic materials, it does not produce a useable axial flaw in austenitic materials because the sound beam, which normally passes only through

base material, must now travel through weld material on at least one side, producing an unrealistic flaw response. In addition, it is important to preserve the dendritic structure present in field welds that would otherwise be destroyed by the implantation process. To resolve these issues, the proposed alternative allows the use of up to 40% fabricated flaws as an alternative flaw mechanism under controlled conditions. The fabricated flaws are isostatically compressed, which produces ultrasonic reflective characteristics similar to tight cracks.



Item 3 - The proposed alternative to Paragraph 1.1(d)(1) states:

"At least **80%** of the **flaws** shall be contained wholly in weld or buttering material. At least **one and a maximum of** 10% of the **flaws** shall be in ferritic **base** material. **At least one and a maximum of 10% of the flaws shall be in austenitic base material.**"

Technical Basis - Under the current Code, as few as 25% of the flaws are contained in austenitic weld or buttering material. Recent experience has indicated that flaws contained within the weld are the likely scenarios. The metallurgical structure of austenitic weld material is ultrasonically more challenging than either ferritic or austenitic base material. The proposed alternative is therefore more challenging than the current Code.

Item 4 - The proposed alternative to Paragraph 1.2(b) states:

"Detection sets shall be selected from Table VIII-S**10**-1. The number of unflawed grading units shall be at least **one and a half** times the number of flawed grading units."

Technical Basis - Table VIII-S10-1 provides a statistically based ratio between the number of unflawed grading units and the number of flawed grading units. The proposed alternative reduces the ratio to 1.5 times to reduce the number of test samples to a more reasonable number from the human factors perspective. However, the statistical basis used for screening personnel and procedures is still maintained at the same level with competent personnel being successful and less skilled personnel being unsuccessful. The acceptance criteria for the statistical basis are in Table VIII-S10-1.

Item 5 - The proposed alternative to the flaw distribution requirements of Paragraph 1.2(c)(1) (detection) and 1.3(c) (length) is to use the Paragraph 1.4(b) (depth) distribution table (see below) for all qualifications.

Flaw Depth (% Wall Thickness)	Minimum Number of Flaws
10-30%	20%
31-60%	20%
61-100%	20%

Technical Basis - The proposed alternative uses the depth sizing distribution for both detection and depth sizing because it provides for a better distribution of flaw sizes within the test set. This distribution allows candidates to perform detection, length, and depth sizing demonstrations simultaneously utilizing the same test set. The requirement that at least 75% of the flaws shall be in the range of 10 to 60% of wall thickness provides an overall distribution tolerance yet the distribution uncertainty decreases the possibilities for testmanship that would be inherent to a uniform distribution. It must be noted that it is possible to achieve the same distribution utilizing the present requirements, but it is preferable to make the criteria consistent.

Item 6 - The proposed alternative to Paragraph 2.0 first sentence states:

"For qualifications from the outside surface, the specimen inside surface and identification shall be concealed from the candidate. When qualifications are performed from the inside surface, the flaw location and specimen identification shall be obscured to maintain a "blind test."

Technical Basis - The current Code requires that the inside surface be concealed from the candidate. This makes qualifications conducted from the inside of the pipe (e.g., PWR nozzle to safe end welds) impractical. The proposed alternative differentiates between ID and OD scanning surfaces, requires that they be conducted separately, and requires that flaws be concealed from the candidate. This is consistent with the recent revision to Supplement 2.

Items 7 and 8 - The proposed alternatives to Paragraph 2.2(b) and 2.2(c) state:

"... containing a flaw to be sized **may** be identified to the candidate."

Technical Basis - The current Code requires that the regions of each specimen containing a flaw to be length sized shall be identified to the candidate. The candidate shall determine the length of the flaw in each region (Note, that length and depth sizing use the term "regions" while detection uses the term "grading units" - the two terms define different concepts and are not intended to be equal or interchangeable). To ensure security of the samples, the proposed alternative modifies the first "shall" to a "may" to allow the test administrator the option of not identifying specifically where a flaw is located. This is consistent with the recent revision to Supplement 2.

Items 9 and 10 - The proposed alternative to Paragraph 2.3(a) and 2.3(b) state:

"... regions of each specimen containing a flaw to be sized **may** be identified to the candidate."

Technical Basis - The current Code requires that a large number of flaws be sized at a specific location. The proposed alternative changes the "shall" to a "may" which modifies this from a specific area to a more generalized region to ensure security of samples. This is consistent with the recent revision to Supplement 2. It also incorporates terminology from length sizing for additional clarity.

Item 11 - The proposed alternative modifies the acceptance criteria of Table VIII-S2-1 as follows:

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TABLE VIII-S2-1
PERFORMANCE DEMONSTRATION DETECTION TEST
ACCEPTANCE CRITERIA

Detection Test Acceptance Criteria		False Call Test Acceptance Criteria	
No. of Flawed Grading Units	Minimum Detection Criteria	No. of Unflawed Grading Units	Maximum Number of False Calls
~~5~~	~~5~~	~~10~~	~~0~~
~~6~~	~~6~~	~~12~~	~~1~~
~~7~~	~~6~~	~~14~~	~~1~~
~~8~~	~~7~~	~~16~~	~~2~~
~~9~~	~~7~~	~~18~~	~~2~~
10	8	~~20~~ 15	~~3~~ 2
11	9	~~22~~ 17	~~3~~ 3
12	9	~~24~~ 18	~~3~~ 3
13	10	~~26~~ 20	~~4~~ 3
14	10	~~28~~ 21	~~5~~ 3
15	11	~~30~~ 23	~~5~~ 3
16	12	~~32~~ 24	~~6~~ 4
17	12	~~34~~ 26	~~6~~ 4
18	13	~~36~~ 27	~~7~~ 4
19	13	~~38~~ 29	~~7~~ 4
20	14	~~40~~ 30	~~8~~ 5

Technical Basis - The proposed alternative is identified as new Table VIII-S10-1 above. It was modified to reflect the reduced number of unflawed grading units and allowable false calls. As a part of ongoing Code activities, Pacific Northwest National Laboratory has reviewed the statistical significance of these revisions and offered the revised Table VIII-S10-1.

Item 12 - The proposed alternative to Paragraph 3.2(b) states:

"Examination procedures, equipment, and personnel are qualified for depth sizing when the RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in."

Technical Basis - The industry is in the process of qualifying personnel to Supplement 10; however, as of March 14, 2003, Nine Mile Point Nuclear Station was informed that personnel qualifying to the Supplement 10 procedures have not been successful in achieving the 0.125 inch RMS criteria for depth sizing. Industry personnel have only been capable of achieving an accuracy of 0.155 in. RMS.

NINE MILE POINT UNIT 1
THIRD INSERVICE INSPECTION INTERVAL
RELIEF REQUEST ISI-24A

E. ALTERNATIVE EXAMINATIONS

As an alternate to the requirements of ASME Section XI, 1995 Edition, 1996 Addenda, Appendix VIII, Supplement 10, NMPNS proposes to use the PDI Program alternative as described in the Enclosure.

NMPNS also proposes that if a flaw is detected during the performance of an ultrasonic examination, the flaw will be sized using the depth sizing of a 0.155 inch RMS value determined during the PDI performance demonstration. In addition NMPNS proposes to take into account the increase in allowable depth sizing error, by adding the difference between the ASME Code required 0.125 inch RMS error and the demonstrated 0.155 inch RMS error to measurements acquired from actual flaw sizing. Specifically, 0.030 inches will be added to the measured flaw size when performing fracture mechanics calculations.

F. IMPLEMENTATION SCHEDULE

The remainder of the Third Ten-Year Inservice Inspection Interval for Unit 1 (December 26, 1999 through December 25, 2009)

G. ATTACHMENTS

Attachment 1	List of Applicable Dissimilar Metal Welds
Enclosure	Comparison of the ASME Code, Section XI, Supplement 10 current requirements to the proposed changes.

NINE MILE POINT UNIT 1
THIRD INSERVICE INSPECTION INTERVAL
RELIEF REQUEST ISI-24A

Attachment 1
List of Applicable Dissimilar Metal Welds

System	Weld Identification	Weld Description	System	Weld Identification	Weld Description
00.0 Closure Head	RV-WD-011	Nozzle N7A to Flange	32.0 Reactor Recirculation	32-WD-208	Nozzle N2E to Safe End
00.0 Closure Head	RV-WD-013	Nozzle N7B to Flange	32.0 Reactor Recirculation	32-WD-002	Nozzle N1A to Safe End
00.0 Closure Head	RV-WD-015	Nozzle N7C to Flange	32.0 Reactor Recirculation	32-WD-045	Nozzle N1B to Safe End
00.0 Closure Head	RV-WD-017	Nozzle N7D to Flange	32.0 Reactor Recirculation	32-WD-085	Nozzle N1C to Safe End
00.0 Closure Head	RV-WD-019	Nozzle N7E to Flange	32.0 Reactor Recirculation	32-WD-125	Nozzle N1D to Safe End
00.0 Closure Head	RV-WD-021	Nozzle N7F to Flange	32.0 Reactor Recirculation	32-WD-167	Nozzle N1E to Safe End
00.0 Closure Head	RV-WD-023	Nozzle N7G to Flange	33.0 Reactor Water Clean-Up	33-WD-004	Pipe to Pipe Bend
00.0 Closure Head	RV-WD-025	Nozzle N7H to Flange	33.0 Reactor Water Clean-Up	33-WD-014	Pipe to Pipe
00.0 Closure Head	RV-WD-027	Nozzle N7J to Flange	36.0 Reactor Instrumentation	36-WD-003	Nozzle N13A to Safe End
00.0 Closure Head	RV-WD-029	Nozzle N7K to Flange	36.0 Reactor Instrumentation	36-WD-073	Nozzle N13B to Safe End
00.0 Closure Head	RV-WD-031	Nozzle N7M to Flange	36.0 Reactor Instrumentation	36-WD-141	Nozzle N14A to Safe End
00.0 Closure Head	RV-WD-033	Nozzle N7N to Flange	36.0 Reactor Instrumentation	36-WD-315	Nozzle N14B to Safe End
00.0 Closure Head	RV-WD-035	Nozzle N7P to Flange	36.0 Reactor Instrumentation	36-WD-538	Nozzle N15A to Safe End
00.0 Closure Head	RV-WD-037	Nozzle N7R to Flange	36.0 Reactor Instrumentation	36-WD-705	Nozzle N15B to Safe End
00.0 Closure Head	RV-WD-039	Nozzle N7S to Flange	36.0 Reactor Instrumentation	36-WD-1000	Nozzle N16B to Safe End
00.0 Closure Head	RV-WD-041	Nozzle N7T to Flange	36.0 Reactor Instrumentation	36-WD-924	Nozzle N16A to Safe End
00.0 Closure Head	RV-WD-043	Nozzle N7U to Flange	36.0 Reactor Instrumentation	36-WD-1074	Closure Head Nozzle N7L to Flange
32.0 Reactor Recirculation	32-WD-042	Nozzle N2A to Safe End	36.0 Reactor Instrumentation	36-WD-1136	Nozzle N17B to Safe End
32.0 Reactor Recirculation	32-WD-082	Nozzle N2B to Safe End	37.0 Reactor Head Vent	37-WD-002	Nozzle N8 to Flange
32.0 Reactor Recirculation	32-WD-122	Nozzle N2C to Safe End	39.0 Emergency Condenser	39-WD-002	Nozzle N5A to Safe End

NINE MILE POINT UNIT 1
THIRD INSERVICE INSPECTION INTERVAL
RELIEF REQUEST ISI-24A

Attachment 1 List of Applicable Dissimilar Metal Welds					
System	**Weld Identification**	**Weld Description**	**System**	**Weld Identification**	**Weld Description**
32.0 Reactor Recirculation	32-WD-164	Nozzle N2D to Safe End	39.0 Emergency Condenser	39-WD-090	Nozzle N5B to Safe End
40.0 Reactor Core Spray	40-WD-039	Nozzle N6A to Safe End	42.1 Liquid Poison	42.1-WD-034	Nozzle N12 to Safe End
40.0 Reactor Core Spray	40-WD-080	Nozzle N6B to Safe End	44.1 Control Rod Drive	44.1-WD-017	Nozzle N9 to Safe End

ATTACHMENT 2
(Relief Request ISI-24B for Nine Mile Point Unit 2)

NINE MILE POINT UNIT 2
SECOND INSERVICE INSPECTION INTERVAL
RELIEF REQUEST ISI-24B

A. COMPONENT IDENTIFICATION

System:	Various Systems
Class:	ASME Code Class 1
Component Description:	Pressure Retaining Piping Welds subject to examination using procedures, personnel, and equipment qualified to ASME Section XI, Appendix VIII, Supplement 10 criteria
Component Identification:	Attachment 1 provides a list of applicable dissimilar metal welds

B. ASME CODE SECTION XI REQUIREMENTS

ASME Section XI, 1995 Edition with 1996 Addenda, Appendix VIII, Supplement 10, "Qualification Requirements For Dissimilar Metal Piping Welds."

The following paragraphs or statements are from ASME Section XI, Appendix VIII, Supplement 10 and identify the specific requirements that are included in this request for relief.

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Item 3 - Paragraph 1.1(d)(1) states - At least 50% of the cracks shall be in austenitic material. At least 50% of the cracks in austenitic material shall be contained wholly in weld or buttering material. At least 10% of the cracks shall be in ferritic material. The remainder of the cracks may be in either austenitic or ferritic material.

Item 4 - Paragraph 1.2(b) states in part - The number of unflawed grading units shall be at least twice the number of flawed grading units.

Item 5 - Paragraph 1.2(c)(1) and 1.3(c) state in part - At least 1/3 of the flaws, rounded to the next higher whole number, shall have depths between 10% and 30% of the nominal pipe wall thickness. Paragraph 1.4(b) distribution table requires 20% of the flaws to have depths between 10% and 30%.

Item 6 - Paragraph 2.0 first sentence states - The specimen inside surface and identification shall be concealed from the candidate.

Item 7 - Paragraph 2.2(b) states in part - The regions containing a flaw to be sized shall be identified to the candidate.

Item 8 - Paragraph 2.2(c) states in part - For a separate length sizing test, the regions of each specimen containing a flaw to be sized shall be identified to the candidate.

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Item 11 - Table VIII-S2-1 provides the false call criteria when the number of unflawed grading units is at least twice the number of flawed grading units.

Item 12 - Paragraph 3.2(b) states - Examination procedures, equipment, and personnel are qualified for depth sizing when the RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in.

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In addition, NMPNS requests relief from the depth sizing less than or equal to 0.125 inch RMS error.

D. **BASIS FOR RELIEF**

Item 1 - The proposed alternative to Paragraph 1.1(b) states:

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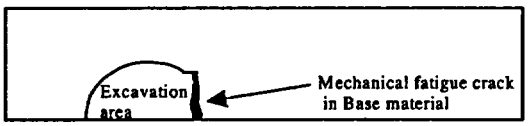
Technical Basis - As illustrated below, implanting a crack requires excavation of the base material on at least one side of the flaw. While this may be satisfactory for ferritic materials, it does not produce a useable axial flaw in austenitic materials because the sound beam, which normally passes only through base material, must now travel through weld material on at least one side, producing an unrealistic flaw

response. In addition, it is important to preserve the dendritic structure present in field welds that would otherwise be destroyed by the implantation process. To resolve these issues, the proposed alternative allows the use of up to 40% fabricated flaws as an alternative flaw mechanism under controlled conditions. The fabricated flaws are isostatically compressed, which produces ultrasonic reflective characteristics similar to tight cracks.



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Technical Basis - Table VIII-S10-1 provides a statistically based ratio between the number of unflawed grading units and the number of flawed grading units. The proposed alternative reduces the ratio to 1.5 times to reduce the number of test samples to a more reasonable number from the human factors perspective. However, the statistical basis used for screening personnel and procedures is still maintained at the same level with competent personnel being successful and less skilled personnel being unsuccessful. The acceptance criteria for the statistical basis are in Table VIII-S10-1.

Item 5 - The proposed alternative to the flaw distribution requirements of Paragraph 1.2(c)(1) (detection) and 1.3(c) (length) is to use the Paragraph 1.4(b) (depth) distribution table (see below) for all qualifications.

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Technical Basis - The proposed alternative uses the depth sizing distribution for both detection and depth sizing because it provides for a better distribution of flaw sizes within the test set. This distribution allows candidates to perform detection, length, and depth sizing demonstrations simultaneously utilizing the same test set. The requirement that at least 75% of the flaws shall be in the range of 10 to 60% of wall thickness provides an overall distribution tolerance yet the distribution uncertainty decreases the possibilities for testmanship that would be inherent to a uniform distribution. It must be noted that it is possible to achieve the same distribution utilizing the present requirements, but it is preferable to make the criteria consistent.

Item 6 - The proposed alternative to Paragraph 2.0 first sentence states:

"For qualifications from the outside surface, the specimen inside surface and identification shall be concealed from the candidate. When qualifications are performed from the inside surface, the flaw location and specimen identification shall be obscured to maintain a "blind test."

Technical Basis - The current Code requires that the inside surface be concealed from the candidate. This makes qualifications conducted from the inside of the pipe (e.g., PWR nozzle to safe end welds) impractical. The proposed alternative differentiates between ID and OD scanning surfaces, requires that they be conducted separately, and requires that flaws be concealed from the candidate. This is consistent with the recent revision to Supplement 2.

Items 7 and 8 - The proposed alternatives to Paragraph 2.2(b) and 2.2(c) state:

"... containing a flaw to be sized **may** be identified to the candidate."

Technical Basis - The current Code requires that the regions of each specimen containing a flaw to be length sized shall be identified to the candidate. The candidate shall determine the length of the flaw in each region (Note, that length and depth sizing use the term "regions" while detection uses the term "grading units" - the two terms define different concepts and are not intended to be equal or interchangeable). To ensure security of the samples, the proposed alternative modifies the first "shall" to a "may" to allow the test administrator the option of not identifying specifically where a flaw is located. This is consistent with the recent revision to Supplement 2.

Items 9 and 10 - The proposed alternative to Paragraph 2.3(a) and 2.3(b) state:

"... regions of each specimen containing a flaw to be sized **may** be identified to the candidate."

Technical Basis - The current Code requires that a large number of flaws be sized at a specific location. The proposed alternative changes the "shall" to a "may" which modifies this from a specific area to a more generalized region to ensure security of samples. This is consistent with the recent revision to Supplement 2. It also incorporates terminology from length sizing for additional clarity.

NINE MILE POINT UNIT 2
SECOND INSERVICE INSPECTION INTERVAL
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Item 11 - The proposed alternative modifies the acceptance criteria of Table VIII-S2-1 as follows:

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TABLE VIII-~~S2-1~~
PERFORMANCE DEMONSTRATION DETECTION TEST
ACCEPTANCE CRITERIA

Detection Test Acceptance Criteria		False Call Test Acceptance Criteria	
No. of Flawed Grading Units	Minimum Detection Criteria	No. of Unflawed Grading Units	Maximum Number of False Calls
~~5~~	~~5~~	~~10~~	~~0~~
~~6~~	~~6~~	~~12~~	~~1~~
~~7~~	~~6~~	~~14~~	~~1~~
~~8~~	~~7~~	~~16~~	~~2~~
~~9~~	~~7~~	~~18~~	~~2~~
10	8	~~20~~ 15	~~0~~ 2
11	9	~~22~~ 17	~~0~~ 3
12	9	~~24~~ 18	~~0~~ 3
13	10	~~26~~ 20	~~4~~ 3
14	10	~~28~~ 21	~~5~~ 3
15	11	~~30~~ 23	~~5~~ 3
16	12	~~32~~ 24	~~6~~ 4
17	12	~~34~~ 26	~~6~~ 4
18	13	~~36~~ 27	~~7~~ 4
19	13	~~38~~ 29	~~7~~ 4
20	14	~~40~~ 30	~~8~~ 5

Technical Basis - The proposed alternative is identified as new Table VIII-S10-1 above. It was modified to reflect the reduced number of unflawed grading units and allowable false calls. As a part of ongoing Code activities, Pacific Northwest National Laboratory has reviewed the statistical significance of these revisions and offered the revised Table VIII-S10-1.

Item 12 - The proposed alternative to Paragraph 3.2(b) states:

"Examination procedures, equipment, and personnel are qualified for depth sizing when The RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in."

Technical Basis - The industry is in the process of qualifying personnel to Supplement 10; however, as of March 14, 2003, Nine Mile Point Nuclear Station was informed that personnel qualifying to the Supplement 10 procedures have not been successful in achieving the 0.125 inch RMS criteria for depth sizing. Industry personnel have only been capable of achieving an accuracy of 0.155 in. RMS.

NINE MILE POINT UNIT 2
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E. ALTERNATIVE EXAMINATIONS

As an alternate to the requirements of ASME Section XI, 1995 Edition, 1996 Addenda, Appendix VIII, Supplement 10, NMPNS proposes to use the PDI Program alternative as described in the Enclosure.

NMPNS also proposes that if a flaw is detected during the performance of an ultrasonic examination, the flaw will be sized using the depth sizing of a 0.155 inch RMS value determined during the PDI performance demonstration. In addition NMPNS proposes to take into account the increase in allowable depth sizing error, by adding the difference between the ASME Code required 0.125 inch RMS error and the demonstrated 0.155 inch RMS error to measurements acquired from actual flaw sizing. Specifically, 0.030 inches will be added to the measured flaw size when performing fracture mechanics calculations.

F. IMPLEMENTATION SCHEDULE

The remainder of the Second Ten-Year Inservice Inspection Interval for Unit 2 (April 5, 1998 through April 4, 2008)

G. ATTACHMENTS

Attachment 1	List of Applicable Dissimilar Metal Welds
Enclosure	Comparison of the ASME Code, Section XI, Supplement 10 current requirements to the proposed changes.

NINE MILE POINT UNIT 2
SECOND INSERVICE INSPECTION INTERVAL
RELIEF REQUEST ISI-24B

Attachment 1
List of Applicable Dissimilar Metal Welds

System	Weld Identification	Weld Description
ISC - Reactor Vessel Instrument	2ISC-102CDA-FW001	NOZ SOC WELD @ N14B
ISC - Reactor Vessel Instrument	2ISC-102CDA-FW005	NOZ SOC WELD @ N14C
ISC - Reactor Vessel Instrument	2ISC-104CDA-FW001	NOZ SOC WELD @ N13B
ISC - Reactor Vessel Instrument	2ISC-105CDA-FW001	NOZ SOC WELD @ N14A
ISC - Reactor Vessel Instrument	2ISC-105CDA-FW007	NOZ SOC WELD @ N14D
ISC - Reactor Vessel Instrument	2ISC-107CDA-FW001	NOZ SOC WELD @ N13A
ISC - Reactor Vessel Instrument	2ISC-208CDA-FW001	NOZ SOC WELD @ N12B
ISC - Reactor Vessel Instrument	2ISC-210CDA-FW001	NOZ SOC WELD @ N12C
ISC - Reactor Vessel Instrument	2ISC-215CDA-FW001	NOZ SOC WELD @ N12D
ISC - Reactor Vessel Instrument	2ISC-217CDA-FW001	NOZ SOC WELD @ N12A
RCS - Reactor Recirculation	2RPV-KB01	NOZ/SE @ N1A Az 000 RECIRC OUTLET
RCS - Reactor Recirculation	2RPV-KB02	NOZ/SE @ N1B Az 180 RECIRC OUTLET
RCS - Reactor Recirculation	2RPV-KB03	NOZ/SE @ N2A Az 030 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB04	NOZ/SE @ N2B Az 060 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB05	NOZ/SE @ N2C Az 090 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB06	NOZ/SE @ N2D Az 120 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB07	NOZ/SE @ N2E Az 150 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB08	NOZ/SE @ N2F Az 210 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB09	NOZ/SE @ N2G Az 240 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB10	NOZ/SE @ N2H Az 270 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB11	NOZ/SE @ N2J Az 300 RECIRC INLET
RCS - Reactor Recirculation	2RPV-KB12	NOZ/SE @ N2K Az 330 RECIRC INLET
FWS - Feedwater	2RPV-KB17	NOZ/SE @ N4A Az 030 FEEDWATER
FWS - Feedwater	2RPV-KB18	NOZ/SE @ N4B Az 090 FEEDWATER
FWS - Feedwater	2RPV-KB19	NOZ/SE @ N4C Az 150 FEEDWATER
FWS - Feedwater	2RPV-KB21	NOZ/SE @ N4E Az 270 FEEDWATER
FWS - Feedwater	2RPV-KB22	NOZ/SE @ N4F Az 330 FEEDWATER
CLS - Low Pressure Core Spray	2RPV-KB23	NOZ/SE @ N5 Az 120 LOW PRESS CS
RHS - Residual Heat Removal	2RPV-KB24	NOZ/SE @ N6A Az 045 RHR-LPCI
RHS - Residual Heat Removal	2RPV-KB25	NOZ/SE @ N6B Az 135 RHR-LPCI
RHS - Residual Heat Removal	2RPV-KB26	NOZ/SE @ N6C Az 315 RHR-LPCI
ISC- Reactor Vessel Instrument	2RPV-KB29	NOZ/SE @ N9A Az 105 JET PUMP INSTR
ISC- Reactor Vessel Instrument	2RPV-KB30	NOZ/SE @ N9B Az 285 JET PUMP INSTR
CHS - High Pressure Core Spray	2RPV-KB32	NOZ/SE @ N16 Az 240 HIGH PRESS CS
ISC - Reactor Vessel Instrument	2RPV-KB34	NOZ/SE @ N11 BOTTOM HEAD
CLS - Low Pressure Core Spray	2RPV-KC23	SE/SEEX @ N5 Az 120 LOW PRESS CS
RHS Residual Heat Removal	2RPV-KC24	SE/SEEX @ N6A Az 045 RHR-LPCI
RHS Residual Heat Removal	2RPV-KC25	SE/SEEX @ N6B Az 135 RHR-LPCI
RHS Residual Heat Removal	2RPV-KC26	SE/SEEX @ N6C Az 315 RHR-LPCI
ISC- Reactor Vessel Instrument	2RPV-KC29	SE/PENSEAL N9A Az 105 JETPMP INSTR
ISC- Reactor Vessel Instrument	2RPV-KC30	SE/PENSEAL N9B Az 285 JETPMP INSTR
CHS - High Pressure Core Spray	2RPV-KC32	SE/SEEX @ N16 Az 240 HIGH PRESS CS

ATTACHMENT 3
(Enclosure to Relief Requests ISI-24A and ISI-24B)

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
	1.0 SCOPE	
	Supplement 10 is applicable to dissimilar metal piping welds examined from either the inside or outside surface. Supplement 10 is not applicable to piping welds containing supplemental corrosion resistant clad (CRC) applied to mitigate Intergranular Stress Corrosion Cracking (IGSCC).	A scope statement provides added clarity regarding the applicable range of each individual Supplement. The exclusion of CRC provides consistency between Supplement 10 and the recent revision to Supplement 2 (Reference BC 00-755). Note, an additional change identifying CRC as "in course of preparation" is being processed separately.
1.0 SPECIMEN REQUIREMENTS	**2.0 SPECIMEN REQUIREMENTS**	Renumbered
Qualification test specimens shall meet the requirements listed herein, unless a set of specimens is designed to accommodate specific limitations stated in the scope of the examination procedure (e.g., pipe size, weld joint configuration, access limitations). The same specimens may be used to demonstrate both detection and sizing qualification.	Qualification test specimens shall meet the requirements listed herein, unless a set of specimens is designed to accommodate specific limitations stated in the scope of the examination procedure (e.g., pipe size, weld joint configuration, access limitations). The same specimens may be used to demonstrate both detection and sizing qualification.	No Change
1.1 General. The specimen set shall conform to the following requirements.	**2.1 General.** The specimen set shall conform to the following requirements.	Renumbered
	(a) The minimum number of flaws in a test set shall be ten	New, changed minimum number of flaws to 10 so sample set size for detection is consistent with length and depth sizing.
(a) Specimens shall have sufficient volume to minimize spurious reflections that may interfere with the interpretation process.	(b) Specimens shall have sufficient volume to minimize spurious reflections that may interfere with the interpretation process.	Renumbered
(b) The specimen set shall include the minimum and maximum pipe diameters and thicknesses for which the examination procedure is applicable. Pipe diameters within a range of 0.9 to 1.5 times a nominal diameter shall be considered equivalent. Pipe diameters larger than 24 in. shall be considered to be flat. When a range of thicknesses is to be examined, a thickness tolerance of ±25% is acceptable.	(c) The specimen set shall include the minimum and maximum pipe diameters and thicknesses for which the examination procedure is applicable. Pipe diameters within a range of **1/2 in. (13 mm)** of the nominal diameter shall be considered equivalent. Pipe diameters larger than 24 in. **(610 mm)** shall be considered to be flat. When a range of thicknesses is to be examined, a thickness tolerance of ±25% is acceptable.	Renumbered, metricated, the change in pipe diameter tolerance provides consistency between Supplement 10 and the recent revision to Supplement 2 (Reference BC 00-755)
(c) The specimen set shall include examples of the following fabrication condition:	(d) The specimen set shall include examples of the following fabrication conditions:	Renumbered, changed "condition" to "conditions"

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
(1) geometric conditions that normally require discrimination from flaws (e.g., counterbore or weld root conditions, cladding, weld buttering, remnants of previous welds, adjacent welds in close proximity);	(1) geometric **and material** conditions that normally require discrimination from flaws (e.g., counterbore or weld root conditions, cladding, weld buttering, remnants of previous welds, adjacent welds in close proximity, **and weld repair areas**);	Clarification, some of the items listed relate to material conditions rather than geometric conditions. Weld repair areas were added as a result of recent field experiences.
(2) typical limited scanning surface conditions (e.g., diametrical shrink, single-side access due to nozzle and safe end external tapers).	(2) typical limited scanning surface conditions (e.g., **weld crowns,** diametrical shrink, single-side access due to nozzle and safe end external tapers **for outside surface examinations; and internal tapers, exposed weld roots, and cladding conditions for inside surface examinations). Qualification requirements shall be satisfied separately for outside surface and inside surface examinations.**	Differentiates between ID and OD scanning surface limitations. Requires that ID and OD qualifications be conducted independently (Note, new paragraph 2.0 (identical to old paragraph 1.0) provides for alternatives when "a set of specimens is designed to accommodate specific limitations stated in the scope of the examination procedure.").
(d) All flaws in the specimen set shall be cracks.		Deleted this requirement, because new paragraph 2.3 below provides for the use of "alternative flaws" in lieu of cracks.
(1) At least 50% of the cracks shall be in austenitic material. At least 50% of the cracks in austenitic material shall be contained wholly in weld or buttering material. At least 10% of the cracks shall be in ferritic material. The remainder of the cracks may be in either austenitic or ferritic material.	**2.2 Flaw Location.** At least **80%** of the **flaws** shall be contained wholly in weld or buttering material. At least **one and a maximum of** 10% of the **flaws** shall be in ferritic **base** material. **At least one and a maximum of 10% of the flaws shall be in austenitic base material.**	Renumbered and re-titled. Flaw location percentages redistributed because field experience indicates that flaws contained in weld or buttering material are probable and represent the more stringent ultrasonic detection scenario.
(2) At least 50% of the cracks in austenitic base material shall be either IGSCC or thermal fatigue cracks. At least 50% of the cracks in ferritic material shall be mechanically or thermally induced fatigue cracks.	**2.3 Flaw Type.** **(a) At least 60% of the flaws shall be cracks, the remainder shall be alternative flaws. Specimens with IGSCC shall be used when available. Alternative flaws, if used, shall provide crack-like reflective characteristics and shall be limited to the case where implantation of cracks produces spurious reflectors that are uncharacteristic of actual flaws. Alternative flaw mechanisms shall have a tip width of less than or equal to 0.002 in. (.05 mm).**	Renumbered and re-titled. Alternative flaws are required for placing axial flaws in the HAZ of the weld and other areas where implantation of a crack produces metallurgical conditions that result in an unrealistic ultrasonic response. This is consistent with the recent revision to Supplement 2 (Reference BC 00-755). The 40% limit on alternative flaws is needed to support the requirement for up to 70% axial flaws. Metricated
(3) At least 50% of the cracks shall be coincident with areas described in (c) above.	(b) At least 50% of the **flaws** shall be coincident with areas described in 2.1(d) above.	Renumbered. Due to inclusion of "alternative flaws", use of "cracks" is no longer appropriate.

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
	2.4 Flaw Depth. All flaw depths shall be greater than 10% of the nominal pipe wall thickness. Flaw depths shall exceed the nominal clad thickness when placed in cladding. **Flaws in the sample set shall be distributed as follows:** **Flaw Depth (% Wall Thickness) / Minimum Number of Flaws** **10-30% — 20%** **31-60% — 20%** **61-100% — 20%** **At least 75% of the flaws shall be in the range of 10 to 60% of wall thickness.**	Moved from old paragraph 1.3(c) and 1.4 and re-titled. Consistency between detection and sizing specimen set requirements (e.g., 20% vs. 1/3 flaw depth increments, e.g., original paragraph 1.3(c))
1.2 Detection Specimens. The specimen set shall include detection specimens that meet the following requirements.		Renumbered and re-titled and moved to paragraph 3.1(a). *No other changes*
(a) Specimens shall be divided into grading units. Each grading unit shall include at least 3 in. of weld length. If a grading unit is designed to be unflawed, at least 1 in. of unflawed material shall exist on either side of the grading unit. The segment of weld length used in one grading unit shall not be used in another grading unit. Grading units need not be uniformly spaced around the pipe specimen.		Renumbered to paragraph 3.1(a)(1). No other changes.
(b) Detection sets shall be selected from Table VIII-S2-1. The number of unflawed grading units shall be at least twice the number of flawed grading units.		Moved to new paragraph 3.1(a)(2).
(c) Flawed grading units shall meet the following criteria for flaw depth, orientation, and type.		Flaw depth requirements moved to new paragraph 2.4, flaw orientation requirements moved to new paragraph 2.5, flaw type requirements moved to new paragraph 2.3, "Flaw Type."

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
(1) All flaw depths shall be greater than 10% of the nominal pipe wall thickness. At least 1/3 of the flaws, rounded to the next higher whole number, shall have depths between 10% and 30% of the nominal pipe wall thickness. However, flaw depths shall exceed the nominal clad thickness when placed in cladding. At least 1/3 of the flaws, rounded to the next whole number, shall have depths greater than 30% of the nominal pipe wall thickness.		Deleted, for consistency in sample sets the depth distribution is the same for detection and sizing.
(2) At least 30% and no more than 70% of the flaws, rounded to the next higher whole number, shall be oriented axially. The remainder of the flaws shall be oriented circumferentially.	**2.5 Flaw Orientation.** **(a)** At least 30% and no more than 70% of the flaws, rounded to the next higher whole number, shall be oriented axially. The remainder of the flaws shall be oriented circumferentially.	Note, this distribution is applicable for detection and depth sizing. Paragraph 2.5(b)(1) requires that all length-sizing flaws be oriented circumferentially.
1.3 Length Sizing Specimens. The specimen set shall include length sizing specimens that meet the following requirements.		Renumbered and re-titled and moved to new paragraph 3.2
(a) All length sizing flaws shall be oriented circumferentially.		Moved, included in new paragraph 3.2(a)
(b) The minimum number of flaws shall be ten.		Moved, included in new paragraph 2.1 above
(c) All flaw depths shall be greater than 10% of the nominal pipe wall thickness. At least 1/3 of the flaws, rounded to the next higher whole number, shall have depths between 10% and 30% of the nominal pipe wall thickness. However, flaw depth shall exceed the nominal clad thickness when placed in cladding. At least 1/3 of the flaws, rounded to the next whole number, shall have depths greater than 30% of the nominal pipe wall thickness.		Moved, included in new paragraph 2.4 above after revision for consistency with detection distribution
1.4 Depth Sizing Specimens. The specimen set shall include depth sizing specimens that meet the following requirements.		Moved, included in new paragraphs 2.1, 2.3, 2.4
(a) The minimum number of flaws shall be ten.		Moved, included in new paragraph 2.1
(b) Flaws in the sample set shall not be wholly contained within cladding and shall be distributed as follows:		Moved, potential conflict with old paragraph 1.2(c)(1); "However, flaw depths shall exceed the nominal clad thickness when placed in cladding.". Revised for clarity and included in new paragraph 2.4

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
Flaw Depth (% Wall Thickness) Minimum Number of Flaws 10-30% 20% 31-60% 20% 61-100% 20% The remaining flaws shall be in any of the above categories.		Moved, included in paragraph 2.4 for consistent applicability to detection and sizing samples.
	(b) Sizing Specimen sets shall meet the following requirements.	Added for clarity
	(1) All length-sizing flaws shall be oriented circumferentially.	Moved from old paragraph 1.3(a)
	(2) Depth sizing flaws shall be oriented as in 2.5(a).	Included for clarity. Previously addressed by omission (i.e., length, but not depth had a specific exclusionary statement)
2.0 CONDUCT OF PERFORMANCE DEMONSTRATION	**3.0 CONDUCT OF PERFORMANCE DEMONSTRATION**	Renumbered
The specimen inside surface and identification shall be concealed from the candidate. All examinations shall be completed prior to grading the results and presenting the results to the candidate. Divulgence of particular specimen results or candidate viewing of unmasked specimens after the performance demonstration is prohibited.	**For qualifications from the outside surface, the specimen inside surface and identification shall be concealed from the candidate. When qualifications are performed from the inside surface, the flaw location and specimen identification shall be obscured to maintain a "blind test."** All examinations shall be completed prior to grading the results and presenting the results to the candidate. Divulgence of particular specimen results or candidate viewing of unmasked specimens after the performance demonstration is prohibited.	Differentiate between qualifications conducted from the outside and inside surface.
2.1 Detection Test. Flawed and unflawed grading units shall be randomly mixed	**3.1 Detection Qualification.**	Renumbered, moved text to paragraph 3.1(a)(3)
	(a) The specimen set shall include detection specimens that meet the following requirements.	Renumbered, moved from old paragraph 1.2.

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
	(1) Specimens shall be divided into grading units. Each grading unit shall include at least 3 in. (76 mm) of weld length. If a grading unit is designed to be unflawed, at least 1 in. (25 mm) of unflawed material shall exist on either side of the grading unit. The segment of weld length used in one grading unit shall not be used in another grading unit. Grading units need not be uniformly spaced around the pipe specimen.	Renumbered, moved from old paragraph 1.2(a). Metricated. No other changes.
	(2) Detection sets shall be selected from Table VIII-S10-1. The number of unflawed grading units shall be at least **one and a half** times the number of flawed grading units.	Moved from old paragraph 1.2(b). Table revised to reflect a change in the minimum sample set to 10 and the application of equivalent statistical false call parameters to the reduction in unflawed grading units. Human factors due to large sample size.
	(3) flawed and unflawed grading units shall be randomly mixed.	Moved from old paragraph 2.1
	(b) Examination equipment and personnel are qualified for detection when **personnel demonstrations** satisfy the acceptance criteria of Table **VIII S10-1** for both detection and false calls.	Moved from old paragraph 3.1. Modified to reflect the 100% detection acceptance criteria of procedures versus personnel and equipment contained in new paragraph 4.0 and the use of 1.5X rather than 2X unflawed grading units contained in new paragraph 3.1(a)(2). Note, the modified table maintains the screening criteria of the original Table VIII-S2-1.
2.2 Length Sizing Test	**3.2 Length Sizing Test**	Renumbered
(a) The length sizing test may be conducted separately or in conjunction with the detection test.	(a) **Each reported circumferential flaw in the detection test shall be length sized.**	Provides consistency between Supplement 10 and the recent revision to Supplement 2 (Reference BC 00-755).
(b) When the length sizing test is conducted in conjunction with the detection test, and less than ten circumferential flaws are detected, additional specimens shall be provided to the candidate such that at least ten flaws are sized. The regions containing a flaw to be sized shall be identified to the candidate. The candidate shall determine the length of the flaw in each region.	(b) When the length sizing test is conducted in conjunction with the detection test, and less than ten circumferential flaws are detected, additional specimens shall be provided to the candidate such that at least ten flaws are sized. The regions containing a flaw to be sized **may** be identified to the candidate. The candidate shall determine the length of the flaw in each region.	Change made to ensure security of samples, consistent with the recent revision to Supplement 2 (Reference BC 00-755). Note, length and depth sizing use the term "regions" while detection uses the term "grading units." The two terms define different concepts and are not intended to be equal or interchangeable.
(c) For a separate length sizing test, the regions of each specimen containing a flaw to be sized shall be identified to the candidate. The candidate shall determine the length of the flaw in each region	(c) For a separate length sizing test, the regions of each specimen containing a flaw to be sized **may** be identified to the candidate. The candidate shall determine the length of the flaw in each region.	Change made to ensure security of samples, consistent with the recent revision to Supplement 2 (Reference BC 00-755).

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
	(d) Examination procedures, equipment, and personnel are qualified for length sizing **when** the RMS error of the flaw length measurements, as compared to the true flaw lengths, is less than or equal to 0.75 in. **(19 mm).**	Moved from old paragraph 3.2(a) includes inclusion of "when" as an editorial change. Metricated.
2.3 Depth Sizing Test	**3.3 Depth Sizing Test**	Renumbered
(a) For the depth sizing test, 80% of the flaws shall be sized at a specific location on the surface of the specimen identified to the candidate.	(a) **The depth sizing test may be conducted separately or in conjunction with the detection test. For a separate depth sizing test, the regions of each specimen containing a flaw to be sized may be identified to the candidate. The candidate shall determine the maximum depth of the flaw in each region.**	Change made to ensure security of samples, consistent with the recent revision to Supplement 2 (Reference BC 00-755).
(b) For the remaining flaws, the regions of each specimen containing a flaw to be sized shall be identified to the candidate. The candidate shall determine the maximum depth of the flaw in each region.	(b) **When the depth sizing test is conducted in conjunction with the detection test, and less than ten flaws are detected, additional specimens shall be provided to the candidate such that at least ten flaws are sized.** The regions of each specimen containing a flaw to be sized **may** be identified to the candidate. The candidate shall determine the maximum depth of the flaw in each region.	Change made to be consistent with the recent revision to Supplement 2 (Reference BC 00-755). Changes made to ensure security of samples, consistent with the recent revision to Supplement 2 (Reference BC 00-755).
	(c) Examination procedures, equipment, and personnel are qualified for depth sizing when the RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in. **(3 mm).**	Moved from old paragraph 3.2(b). Metricated.
3.0 ACCEPTANCE CRITERIA		Delete as a separate category. Moved to new paragraph detection (3.1) and sizing 3.2 and 3.3
3.1 Detection Acceptance Criteria. Examination procedures, equipment, and personnel are qualified for detection when the results of the performance demonstration satisfy the acceptance criteria of Table VIII-S2-1 for both detection and false calls.		Moved to new paragraph 3.1(b), reference changed to Table S10 from S2 because of the change in the minimum number of flaws and the reduction in unflawed grading units from 2X to 1.5X.
3.2 Sizing Acceptance Criteria		Deleted as a separate category. Moved to new paragraph on length 3.2 and depth 3.3
(a) Examination procedures, equipment, and personnel are qualified for length sizing the RMS error of the flaw length measurements, as compared to the true flaw lengths, is less than or equal to 0.75 inch.		Moved to new paragraph 3.2(d), included word "when" as an editorial change.

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**
(b) Examination procedures, equipment, and personnel are qualified for depth sizing when the RMS error of the flaw depth measurements, as compared to the true flaw depths, is less than or equal to 0.125 in.		Moved to new paragraph 3.3(c)
	4.0 PROCEDURE QUALIFICATION	New
	Procedure qualifications shall include the following additional requirements. **(a) The specimen set shall include the equivalent of at least three personnel sets. Successful personnel demonstrations may be combined to satisfy these requirements.** **(b) Detectability of all flaws within the scope of the procedure shall be demonstrated. Length and depth sizing shall meet the requirements of paragraph 3.2 and 3.3.** **(c) At least one successful personnel demonstration has been performed.** **(d) To qualify new values of essential variables, at least one personnel qualification set is required.**	New. Based on experience gained in conducting qualifications, the equivalent of 3 personnel sets (i.e., a minimum of 30 flaws) is required to provide enough flaws to adequately test the capabilities of the procedure. Combining successful demonstrations allows a variety of examiners to be used to qualify the procedure. Detectability of each flaw within the scope of the procedure is required to ensure an acceptable personnel pass rate. The last sentence is equivalent to the previous requirements and is satisfactory for expanding the essential variables of a previously qualified procedure

SUPPLEMENT 10 – QUALIFICATION REQUIREMENTS FOR DISSIMILAR METAL PIPING WELDS		
Current Requirement	**Proposed Change**	**Reasoning**

10

TABLE VIII-S2-1
PERFORMANCE DEMONSTRATION DETECTION TEST ACCEPTANCE CRITERIA

Detection Test Acceptance Criteria		False Call test Acceptance Criteria	
No. of Flawed Grading Units	Minimum Detection Criteria	No. of Unflawed Grading Units	Maximum Number of False Calls
~~5~~	~~5~~	~~10~~	~~0~~
~~6~~	~~6~~	~~12~~	~~1~~
~~7~~	~~6~~	~~14~~	~~1~~
~~8~~	~~7~~	~~16~~	~~2~~
~~9~~	~~7~~	~~18~~	~~2~~
10	8	~~20~~ 15	~~3~~ 2
11	9	~~22~~–17	~~3~~–3
12	9	~~24~~ 18	~~3~~ 3
13	10	~~26~~–20	4 3
14	10	~~28~~ 21	5 3
15	11	~~30~~ 23	5 3
16	12	~~32~~ 24	6 4
17	12	~~34~~ 26	6 4
18	13	~~36~~ 27	~~7~~ 4
19	13	~~38~~–29	~~7~~ 4
20	14	~~40~~–30	~~8~~ 5