

Dominion Nuclear Connecticut, Inc.  
Millstone Power Station  
Rope Ferry Road  
Waterford, CT 06385



June 2, 2005

U. S. Nuclear Regulatory Commission  
Attention: Document Control Desk  
One White Flint North  
11555 Rockville Pike  
Rockville, MD 20852-2738

Serial No. 05-331  
NLOS/PRW Rev. 0  
Docket No. 50-336  
License No. DPR-65

**DOMINION NUCLEAR CONNECTICUT, INC.**  
**MILLSTONE POWER STATION UNIT 2**  
**NRC BULLETIN 2004-01, "INSPECTION OF ALLOY 82/182/600 MATERIALS**  
**USED IN THE FABRICATION OF PRESSURIZER PENETRATIONS AND STEAM**  
**SPACE PIPING CONNECTIONS AT PRESSURIZED WATER REACTORS"**  
**60 DAY REPORT**

In a letter dated May 28, 2004, the NRC issued Bulletin 2004-01. The bulletin requested that within 60 days of plant restart following the next inspection of the Alloy 82/182/600 pressurizer penetrations and steam space piping connections that a report be submitted to the NRC. This report was to confirm that the inspections described in the response to item (1)(c) of the Bulletin had been completed and to provide a description of the as-found condition of the pressurizer shell, any findings of relevant indications of through-wall leakage, followup NDE performed to characterize flaws in leaking penetrations or steam space piping connections, a summary of all relevant indications found by NDE, a summary of the disposition of any findings of boric acid, and any corrective actions taken and/or repairs made as a result of the indications found.

The attachment to this letter provides the Dominion Nuclear Connecticut, Inc. 60 day report described above for Millstone Power Station Unit 2.

Should you have any questions regarding the report, please contact Mr. Paul R. Willoughby at (804) 273-3572.

Very truly yours,

Eugene S. Grecheck  
Vice President – Nuclear Support Services

Attachment

Commitments: None

cc: U.S. Nuclear Regulatory Commission  
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Mr. S. M. Schneider  
NRC Senior Resident Inspector  
Millstone Power Station

COMMONWEALTH OF VIRGINIA   )  
  )  
COUNTY OF HENRICO         )

The foregoing document was acknowledged before me, in and for the County and Commonwealth aforesaid, today by Eugene S. Grecheck, who is Vice President - Nuclear Support Services of Dominion Nuclear Connecticut, Inc. He has affirmed before me that he is duly authorized to execute and file the foregoing document in behalf of those companies, and that the statements in the document are true to the best of his knowledge and belief.

Acknowledged before me this 2<sup>nd</sup> day of June, 2005.

My Commission Expires: May 31, 2006.

Vicki L. Hull  
Notary Public

(SEAL)

**ATTACHMENT**

**NRC BULLETIN 2004-01**  
**INSPECTION OF ALLOY 82/182/600 MATERIALS USED IN THE FABRICATION**  
**OF PRESSURIZER PENETRATIONS AND STEAM SPACE PIPING**  
**CONNECTIONS AT PRESSURIZED WATER REACTORS**

**60 DAY REPORT**

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The Dominion Nuclear Connecticut, Inc. (DNC) 60 day report described above for Millstone Power Station Unit 2 (MPS2) is provided below:

**Response**

During the most recent MPS2 outage (2R16), completed May 18, 2005, a bare metal visual examination was made of the 120 pressurizer heater sleeves, 8 instrumentation nozzles and the 5 steam space piping connections. The pressurizer heater sleeve penetrations and instrumentation nozzles are made from Alloy 600 and are joined to the pressurizer with J-groove welds made with Alloy 82/182. The five steam space piping connections have welds made with Alloy 82/182. The bare metal examination of the welds and penetrations covered 360° of the weld surface or the penetration to pressurizer interface.

The examinations found one pressurizer heater sleeve, B-2, with indication of primary water on the surface. The annulus between the heater sleeve and the pressurizer was wet and there was a small amount of gummy white material present. Analysis of the water from this location determined that the water was reactor coolant. The heater was removed from this penetration and an eddy current inspection of the sleeve performed. The eddy current inspection identified one axial through wall indication about 1/2" long from the bottom of the J-groove weld. The pressurizer heater was reinstalled and a mechanical nozzle seal assembly (MNSA) was installed to seal the leakage consistent with Relief Request RR-89-43 which was approved by the NRC on October 28, 2003.

This was the fifth MNSA clamp installed on the Millstone Unit 2 pressurizer. DNC plans to replace the MPS2 pressurizer at the next refueling outage, 2R17, currently scheduled for the fall, 2006.