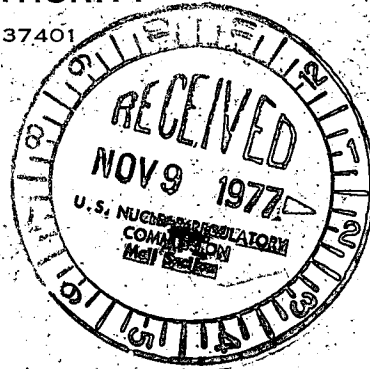


TENNESSEE VALLEY AUTHORITY

CHATTANOOGA, TENNESSEE 37401

NOV 2 1977



Mr. James P. O'Reilly, Director
 Office of Inspection and Enforcement
 U.S. Nuclear Regulatory Commission
 Region II - Suite 1217
 230 Peachtree Street, NW.
 Atlanta, Georgia 30303

Dear Mr. O'Reilly:

WATTS BAR NUCLEAR PLANT UNIT 2 - REPORTABLE DEFICIENCY - BROADLINE
 CORPORATION POLAR CRANE ASSEMBLY - REJECTABLE WELDS (NCR 938R)

The subject deficiency was initially reported to NRC-OIE Project
 Section Branch Chief J. C. Bryant on October 3, 1977. The following
 is our first interim report on this deficiency:

During the assembly of unit 2 polar crane bridge, the bolt
 holes for one of the two end ties would not line up. Site
 employees contacted the Division of Engineering Design
 (EN DES) and it was decided to cut out welds Nos. 1 and 4
 (see enclosed sketch), align the members with bolt holes,
 and reweld.

When these welds were cut out, slag inclusions and lack
 of fusion were discovered. EN DES was again contacted,
 and the remaining welds were examined using UT. Four of
 the six were rejectable, and NCR 938R was issued. Docu-
 mentation of repair for welds Nos. 1 and 4 was made on
 NCR 947R. The crane bridge was assembled, and the two
 welds which had been cut out were rewelded, MT examined,
 and found acceptable. The bridge with the 600-ton con-
 struction hoist was tested successfully and used to install
 unit 2 major components.

Our final report on this deficiency will be transmitted by December 9,
 1977.

Very truly yours,

J. E. Gilleland
 Assistant Manager of Power

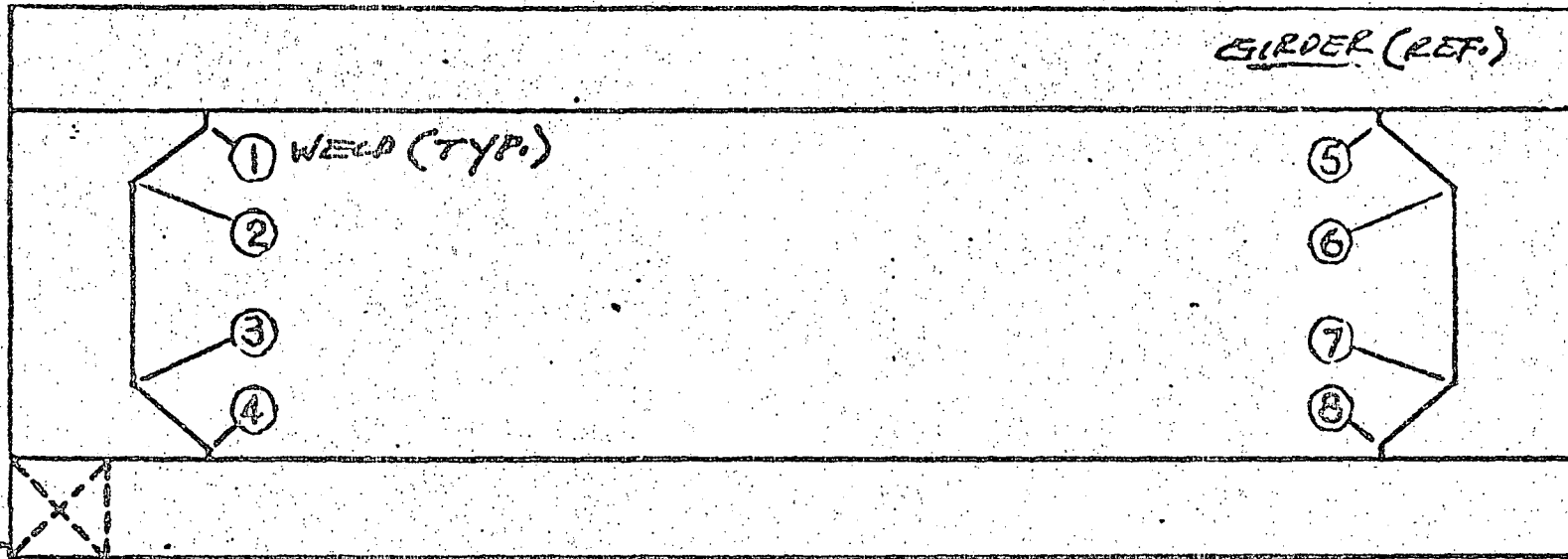
Enclosure

cc: Dr. Ernst Volgenau, Director (Enclosure) ✓
 Office of Inspection and Enforcement
 U.S. Nuclear Regulatory Commission
 Washington, DC 20555

773140136

WB NP

POLAR CRANE - UNIT 2
BRIDGE ASSY.



PLAN

WELD No.

COMMENT

①, ④

— NOT INCLUDED IN THIS NCR. (REF. ONLY)

② ③ ⑤ ⑦

— WELDS REJECTED BY UT EXAMINATION.

⑥ ⑧

— WELDS APPROVED BY UT EXAMINATION.

NOTES:

WELDS APPROX. 30" IN LENGTH
MAT'L. WELDED - 3/4" TH, C.S.

ATT. ITO, NCR 938R
H. GRIMAC - MEU
SEPT. 12, 1977