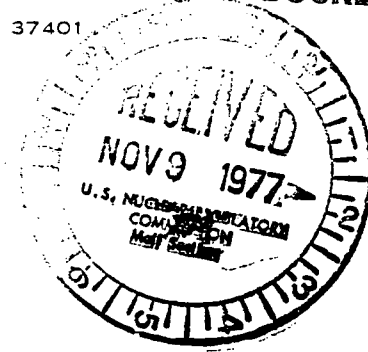


830 Power Building

TENNESSEE VALLEY AUTHORITY  
CHATTANOOGA, TENNESSEE 37401

REGULATORY DOCKET FILE COPY

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. Doc-  
umentation 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

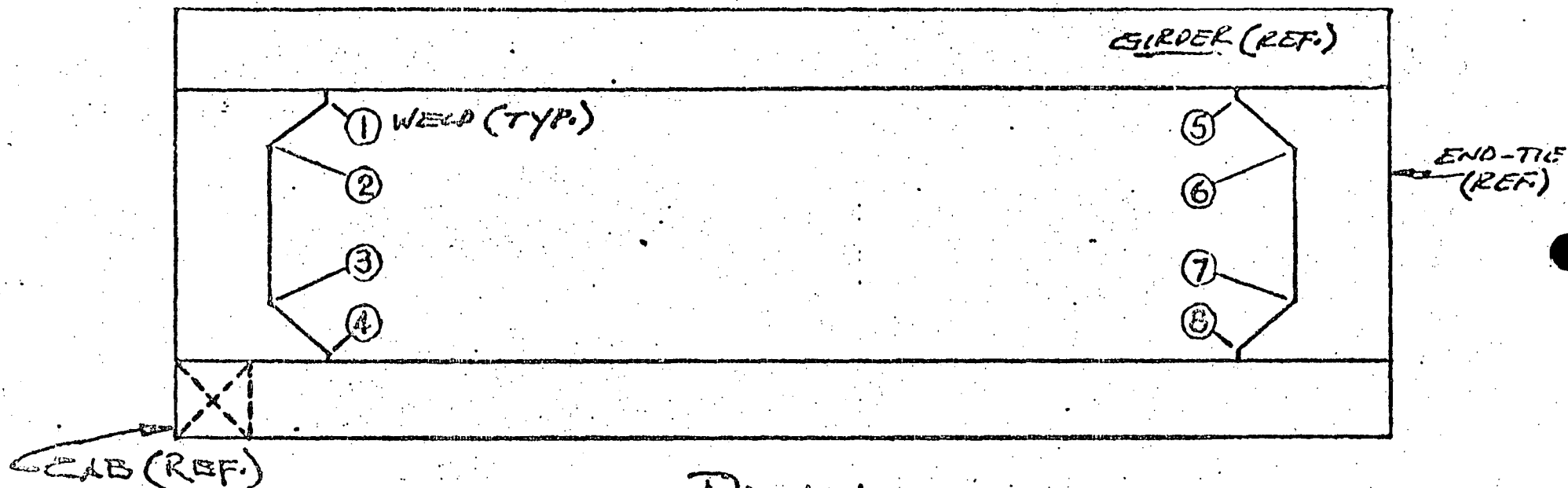
cc: Dr. Ernst Volgenau, Director (Enclosure) ✓  
Office of Inspection and Enforcement  
U.S. Nuclear Regulatory Commission  
Washington, DC 20555

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WBNP

POLAR CRANE - UNIT 2  
BRIDGE ASS'Y.



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" PL, C.S.

ATTN TO NCR 938R  
H. GRIMM - MEU  
SEPT. 12, 1977