

830 Power Building
TENNESSEE VALLEY AUTHORITY

CNETRAL FILES
50-391

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. 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,



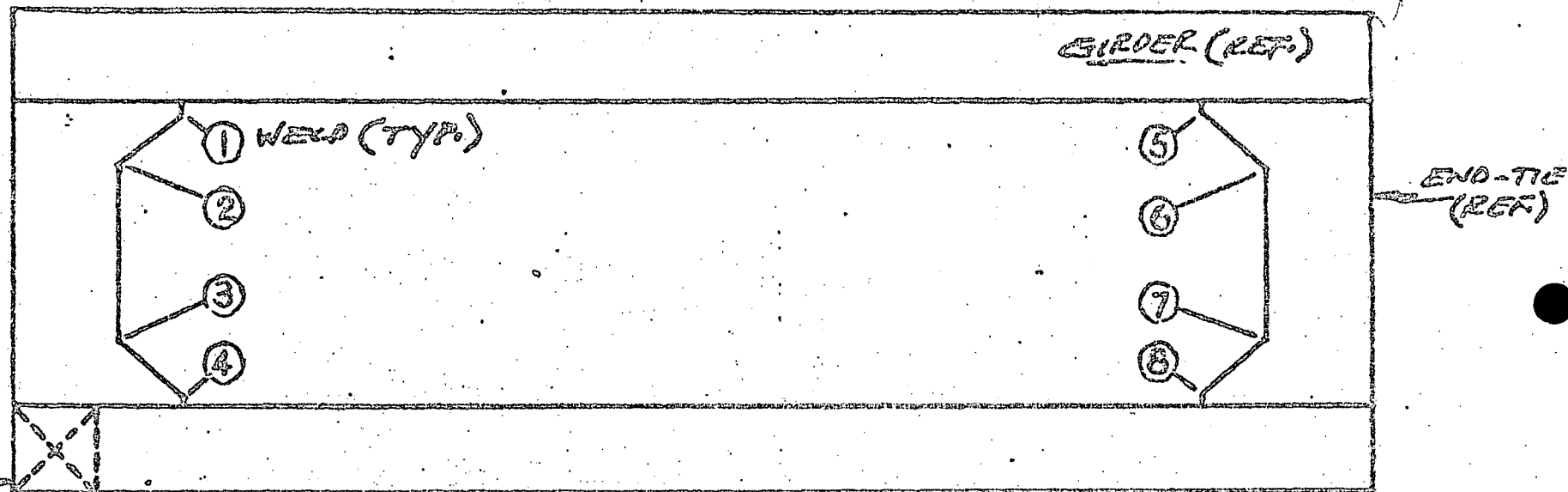
J. E. Gilleland
Assistant Manager of Power

Enclosure

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

MA 1
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POLOK 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" PL, C.S.

ATT. LTD. NCR 939R
 H. GRIMM - MEU
SEPT. 12, 1977