

TENNESSEE VALLEY AUTHORITY

CHATTANOOGA, TENNESSEE 37401

5B Lookout Place

DEC 11 1990

U.S. Nuclear Regulatory Commission  
ATTN: Document Control Desk  
Washington, D.C. 20555

Gentlemen:

In the Matter of the Application of ) Docket Nos. 50-390  
Tennessee Valley Authority ) 50-391

WATTS BAR NUCLEAR PLANT (WBN) - RESPONSE TO REQUEST FOR ADDITIONAL  
INFORMATION - PRESERVICE INSPECTION (PSI) PROGRAM PLAN

Enclosure 1 contains the additional information on the WBN PSI program plan as  
requested in your October 9, 1990 letter. One copy has also been sent to  
Mr. Boyd W. Brown, EG&G Idaho, Inc. Enclosure 2 contains the commitment made  
in this submittal.

If there are any questions, please telephone P. L. Pace at (615) 365-1824.

Very truly yours,

TENNESSEE VALLEY AUTHORITY

*R. H. Shell*

for E. G. Wallace, Manager  
Nuclear Licensing and  
Regulatory Affairs

Enclosures  
cc: See page 2

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U.S. Nuclear Regulatory Commission

DEC 11 1990

cc (Enclosures):

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ENCLOSURE 1  
WATTS BAR NUCLEAR PLANT (WBN)  
REQUEST FOR ADDITIONAL INFORMATION ON THE  
PRESERVICE INSPECTION (PSI) PROGRAM PLAN

This enclosure is in response to your request for additional information/clarification on the WBN PSI Program. The identification of each response corresponds with your October 9, 1990 letter.

Request 2.A "Please provide copies of Revisions 19 and 21, and/or confirm that the April 30, 1990 submittal of Revision 22 is a complete revision (stand alone document) with all previous changes incorporated."

Response to request 2.A - The submittal of Revision 22 on April 30, 1990, was a complete revision (stand alone document) with all previous changes incorporated.

Request 2.B "Please provide a listing of all systems that have been modified or required rework since Revision 16 of the PSI Program was issued. Are modifications to these systems within the scope of the PSI Program?"

Response to request 2.B - The following systems are within the PSI boundary: Reactor Coolant, Chemical Volume Control, Residual Heat Removal, Safety Injection, Main Steam, Feedwater, and Auxiliary Feedwater. Within each of these systems some of the piping or piping supports within the scope of the PSI Program have been or are being modified, repaired, replaced since Revision 16 (dated 3/30/85) of the PSI Program.

Request 2.C "Confirm that, for the systems that have been modified or reworked for any reason, the PSI examinations will be repeated and new baseline data obtained."

Response to request 2.C - Corporate procedure Standard STD-10.3.707, "Repair/Replacement of ASME Section XI Components," and site procedure AI-9.15, "Preparation of Work Instructions For Repairs and Replacements of ASME Section XI Components," control the ASME Section XI repair and replacement activities at the site. These procedures, when applicable, require work plans or maintenance requests to be prepared for repair and replacement activities. When these activities are performed on components, which require PSI examinations, those components will be required to receive a new PSI examination.

The following are TVA's definitions of repair and replacement under ASME Section XI activities:

Repair - Those operations on a pressure boundary item or load-bearing member of a component support, involving welding, heat treatment, or defect removal which are required to restore an item to a safe and satisfactory operating condition.

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Replacement - Spare and renewal components, appurtenances, and subassemblies or parts of a component or system. Replacement also includes the addition of components, such as valves and system changes, such as rerouting of piping.

Request 2.D "In September 1989, an NRC Region II Inspector performed a routine inspection at WBN, Unit 1 (Report Nos. 50-390/89-15 and 50-391/89-15). This NRC inspection included, in part, a review of the Unit 1 PSI plan, reviews of the active requests for relief from required PSI examinations, and random field visual verifications to confirm that the relief requests were justified. Review of request for relief Inservice Inspection (ISI)-4 identified a total of 64 welds listed, of which 7 welds were reported to have been removed with 57 welds still remaining in systems. Revision 22 of ISI-4 shows 62 welds for which relief is still being requested. Confirm that relief is required for all welds listed in Revision 22 of ISI-4. Also, confirm that all request for relief have been revised, if applicable, with regard to updating to later Code editions and addenda for PSI and to reflect current plant configuration and/or PSI examinations."

Response to request 2.D - Attached is the revised request for relief ISI-4 that lists a total of 66 piping welds which have been identified to date that required a request for relief. The revised ISI-4 includes the addition of 35 welds and the deletion of 32 welds.

The following welds were removed from ISI-4 per the following:

Welds RCF-D234-3, RCF-D236-4, RCS-106, UHIF-D039-15A, UHIF-D039-17, UHIF-D043-5, UHIF-D043-6, UHIS-66, and UHIS-76A were removed due to upper head injection and the RTD modifications.

Weld RHRS-102 was removed because residual heat removal modification cut the weld out.

Welds RCS-1-4, RCS-1-5, RCS-2-4, RCS-2-5, RCS-3-4, RCS-3-5, RCS-4-4, and RCS-4-5 were removed due to reexamination to the extent of examination requirements of ASME Section XI 77 Edition Summer 78 Addenda.

Welds MSF-D001-1, MSF-D006-10, MSS-61A-LS, RHRF-D047-4, RHRF-D049-4, RHRF-D055-10, RHRS-132, and SIF-D088-9 were removed because of the use of Code Case N-460.

Welds RHRF-D051-12-LS, RHRS-132-LS, SIF-B-T059-2A, SIF-B-T059-2B, SIF-D080-1-LS, and SIS-40-LS were removed due to reexamination of the welds.

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Welds CVCW-01A, CVCW-02A, CVCW-03A, CVCW-04A, N15-SE, N16-SE, N17-SE, N18-SE, RCF-B1-2, RCF-B2-2, RCF-B3-2, RCF-B4-2, RCF-D1-2-SE, RCF-D2-1, RCF-D2-2-SE, RCF-D4-1, RCF-D4-2-SE, RCF-D5-1, RCF-D5-2-SE, RCF-F1-1, RCF-F1-1-SE, RCF-F1-4, RCF-F2-1-SE, RCF-F2-4, RCF-F3-1-SE, RCF-F3-4, RCF-F4-1-SE, RCF-F4-2, RCF-F4-4, RCS-1-6, RCS-2-6, RCS-3-6, RCW-01, RCW-02, and RHRS-022A have been added to ISI-4.

Piping diameter and percent of weld scanned information has also been added to ISI-4.

The remaining requests for relief in the previously submitted program except ISI-4 have not been revised since Revision 22 of the PSI Program. The revised ISI-4 will be included in the next revision (Revision 23) of the PSI Program.

Request 2.E "Verify that there are no additional relief requests, other than those submitted in Revision 22 of the PSI Program. If additional relief requests are required, the applicant should submit them for staff review."

Response to request 2.E - There are no additional requests for relief that have been identified at this time other than those included in the attached revision to request for relief ISI-4.

REQUEST FOR RELIEF ISI-4

Components: Pressure-retaining welds in piping (See List Below)

Class: ASME Class 1 and 2 (TVA Safety Class A and B)

Inspection Requirement: Volumetric examination of longitudinal, circumferential, and pipe branch connection welds, examination categories B-F, B-J, C-F, and C-G.

Basis for Relief: In some cases it will be impractical to ultrasonically examine all welds in accordance with paragraph T-532 of Article 5, Section V of the ASME Code or Appendix III, Subarticle III-4400 of Section XI of ASME Code 1977 Edition, Summer 1978 Addenda and achieve meaningful results, i.e., nonremovable hanger interference or valve and pump casings adjoining the welds.

Each weld had a construction radiographic examination performed in accordance with ASME Section III.

Alternate Inspection: Ultrasonic examinations will be performed to the extent practical and supplemented with Section XI surface examinations on all accessible areas of the weld.

REQUEST FOR RELIEF ISI-4

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
CVCW-01A 1-1/2" Diameter	B-J	ISI-0050-C Sheet 1	F/P	No scan	0%	No ultrasonic examination performed on this weld because PSI Program was updated to ASME Section XI, 1977 Edition, Summer 1978 Addenda, for Class 1 pressure retaining welds for piping examinations after 7/1/89 (Note 8)
CVCW-02A 1-1/2" Diameter	B-J	ISI-0050-C Sheet 2	F/P	No scan	0%	No ultrasonic examination performed on this weld because PSI Program was updated to ASME Section XI, 1977 Edition, Summer 1978 Addenda for Class 1 pressure retaining welds for piping examinations after 7/1/89 (Note 8)
CVCW-03A 1-1/2" Diameter	B-J	ISI-0050-C Sheet 3	F/P	No scan	0%	No ultrasonic examination performed on this weld because PSI Program was updated to ASME Section XI, 1977 Edition, Summer 1978 Addenda, for Class 1 pressure retaining welds for piping examinations after 7/1/89 (Note 8)
CVCW-04A 1-1/2" Diameter	B-J	ISI-0050-C Sheet 4	F/P	No scan	0%	No ultrasonic examination performed on this weld because PSI Program was updated to ASME Section XI, 1977 Edition, Summer 1978 Addenda, for Class 1 pressure retaining welds for piping examinations after 7/1/89 (Note 8)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
FWF-D001-6 16" Diameter	C-G	CHM-2671-C Sheet 1	E/V	3/No Scan. 4,5,6/Limited	71%	No scan 3 due to valve. Scan 4, 5, and 6 limited from 0530 to 0630, 0830 to 0930, and 1130 to 0100 due to permanent support. Bi-Directional coverage achieved from scan 4 side in accessible areas utilizing 12/8 V scan. (Notes 5 and 6)
FWF-D372-8 6" Diameter	C-G	CHM-2671-C Sheet 6	R/R	3/No scan 4/No scan	50%	No scans 3 and 4 due to reducer weld configuration.
FWS-4B 16" Diameter	C-G	CHM-2671-C Sheet 1	Pen F/ Pen P	No scan	0%	No examination due to weld inside penetration.
FWS-41 16" Diameter	C-G	CHM-2671-C Sheet 4	R/P	4,5,6/Limited	81%	Scans 4, 5, and 6 limited from 0300 to 0500 due to permanent welded lug brace. (Note 5)
FWS-63 6" Diameter	C-G	CHM-2671-C Sheet 7	Pen F/ Pen P	No scan	0%	No examination due to weld inside penetration
MSF-D006-15 6" Diameter	C-G	CHM-2669-C Sheet 4	V/F	3/No scan 4/No scan	50%	No scans 3 and 4 due to valve to flange weld configuration
MSS-8 32" Diameter	C-G	CHM-2669-C Sheet 1	E/P	All/Limited	83%	All scans limited from 0500 to 0700 (Approx. 17") due to permanent support (Note 5)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
MSS-55A 32" Diameter	C-G	CHM-2669-C Sheet 4	Pen P/ Pen F	No scan	0%	No examination due to weld inside penetration
MSS-61B-LS 30" Diameter	C-G	CHM-2669-C Sheet 4	P	All/Limited	85%	All scans limited due to 8"x8" permanent support spacer interference. (weld length 53")
N15-SE 29" ID	B-F	CHM-2547-B Sheet 1	N/Safe end	3/No scan 4,5,6/Limited	42%	No scan 3 due to nozzle transition. Scans 4,5, and 6 limited due to weld concavity preventing transducer coupling (Note 10)
N16-SE 29" ID	B-F	CHM-2547-B Sheet 1	N/Safe end	3/No scan 5,6/Limited	73%	No scan 3 due to nozzle transition. Scan 5 and 6 limited due to weld concavity preventing transducer coupling (Note 10)
N17-SE 29" ID	B-F	CHM-2547-B Sheet 1	N/Safe end	3/No scan 4,5,6/Limited	42%	No scan 3 due to nozzle transition. Scans 4, 5, and 6 limited due to weld concavity preventing transducer coupling (Note 10)
N18-SE 29" ID	B-F	CHM-2547-B Sheet 1	N/Safe end	5,6/Limited	58%	Scan 5 and 6 limited due to weld concavity preventing transducer (Note 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCF-A-T129-7 3" Diameter	B-J	ISI-0017-C Sheet 1	V/P	3/No scan 4/Limited	82%	No scan 3 due to flange. Scan 4 limited to (4) integral attachment lugs. Bi - directional coverage achieved in accessible areas from scan 4 side utilizing 12/8 V scan. (Notes 6 and 8)
RCF-B1-2 27.5" ID	B-J	CHM-2547-B Sheet 1	N/P	3,4/Limited	74%	Scan 3 limited due to pump nozzle transition. Scan 4 limited due to branch connection (Note 10)
RCF-B2-2 27.5" ID	B-J	CHM-2547-B Sheet 1	N/P	3/No scan 4,5,6/Limited	51%	No scan 3 due to nozzle transition. Scan 4 limited due to branch connection. Scans 5 and 6 limited due to weld concavity preventing transducer coupling. (Note 10)
RCF-B3-2 27.5" ID	B-J	CHM-2547-B Sheet 1	N/P N/P	3/No scan 5,6/Limited	60%	No scan 3 due to nozzle transition. Scans 5 and 6 limited due to weld concavity preventing transducer coupling (Note 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCF-B4-2 27.5" ID	B-J	CHM-2547-B Sheet 1	N/P	3/No scan 5,6/Limited	60%	No scan 3 due to nozzle transition Scans 4,5, and 6 limited due to weld concavity preventing transducer coupling (Note 10)
RCF-B4-4 1-1/2" Diameter	B-J	CHM-2758-B Sheet 13	Boss/P	No scan	0%	No examination due to boss and pipe configuration (Note 8)
RCF-D1-2 29" ID	B-F	CHM-2547-B Sheet 1	E/N	4/No scan	50%	Manual examination 77/S78. No scan 4 due to nozzle transition. Scans 5 and 6 limited to upstream side due to nozzle transition and weld taper. (Note 10)
RCF-D1-2-SE 29" ID	B-F	CHM-2660-B Sheet 1	Safe end/N	4,5,6/No scan	25%	No scan 4 due to nozzle transition. No scans 5 and 6 due to nozzle transition and weld taper preventing transducer coupling (Note 10)
RCF-D2-1 29" ID	B-F	CHM-2547-B Sheet 1	Nozzle Safe End/P	3,4,5,6/Limited	76%	Scan 3 limited due to nozzle transition. Scan 4,5,6 limited due to weld concavity preventing transducer coupling. (Note 10)
RCF-D2-2 29" ID	B-F	CHM-2547-B Sheet 1	E/N	4/No scan	50%	Manual examination 77/S78. No scan 4 due nozzle transition. Scans 5 and 6 limited to upstream side due to nozzle transition and weld taper (Note 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCF-D2-2-SE 29" ID	B-F	CHM-2660-B Sheet 1	Safe end/N	4,5,6/No scan	25%	No scan 4 due to nozzle transition. No scans 5 and 6 due to nozzle transition and weld taper preventing transducer coupling (Note 10)
RCF-D4-1 29" ID	B-F	CHM-2547-B Sheet 1	Nozzle Safe End/P	5,6 Limited	87%	Scans 5 and 6 limited due to weld concavity Preventing transducer coupling (Note 10)
RCF-D4-2 29" ID	B-F	CHM-2547-B Sheet 1	E/N	4/No scan	50%	Manual examination 77/S78. No scan 4 due to nozzle transition. Scans 5 and 6 limited to upstream side due to nozzle transition and weld taper (Note 10)
RCF-D4-2-SE 29" ID	B-F	CHM-2660-B Sheet 1	Safe end/ N	4,5,6/No scan	25%	No scan 4 due to nozzle transition. No scans 5 and 6 due to nozzle transition and weld taper preventing transducer coupling (Note 10)
RCF-D5-1 29" ID	B-F	CHM-2547-B Sheet 1	Nozzle safe end/P	4,5,6/Limited	76%	Scans 4, 5, and 6 limited due to weld concavity preventing transducer coupling (Note 10)
RCF-D5-2 29" ID	B-F	CHM-2547-B Sheet 1	E/N	4/No scan	50%	Manual examination 77/S78. No scan 4 due to nozzle transition. Scans 5 and 6 limited to upstream side due to nozzle transition and weld taper (Note 10)
RCF-D5-2-SE 29" ID	B-F	CHM-2660-B Sheet 1	Safe end/ N	4,5,6/No scan	25%	No scan 4 due to nozzle transition. No scans 5 and 6 due to nozzle transition and weld taper preventing transducer coupling (Note 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCF-D232-2 3" Diameter	B-J	ISI-0017-C Sheet 1	V/R	All limited	50%	All scans limited by 50% due to valve to reducer weld configuration (Note 8)
RCF-F1-1 31" ID	B-J	CHM-2547-B Sheet 1	E/N	3/No scan 4,5,6/Limited	31%	No scan 3 due to nozzle transition. Scan 4,5, and 6 limited due to nozzle transition and weld taper preventing transducer coupling. (Note 10)
RCF-F1-1-SE 31" ID	B-F	CHM-2660-B Sheet 1	N/Safe end	3/No scan 4,5,6/Limited	23%	No scan 3 due to nozzle transition. Scan 4,5, and 6 limited due to nozzle transition and weld taper preventing transducer coupling. (Note 10)
RCF-F1-4 31" ID	B-J	CHM-2547-B Sheet 1	E/Pump	4/No scan 3/Limited	73%	No scan 4 due to pump taper. Scan 3 limited due to pump weld taper preventing transducer coupling. (Note 10)
RCF-F2-1 31" ID	B-F	CHM-2547-B Sheet 1	Nozzle Safe end/E	3/No scan 5,6/Limited	44%	Automated examination. No scan 3 and limited scans 5 and 6 due to nozzle transition. (Note 10)
RCF-F2-1-SE 31" ID	B-F	CHM-2660-B Sheet 1	N/Safe end	3,5,6/No scan	25%	No scans 3, 5, and 6 due to nozzle transition (Note 10)
RCF-F2-4 31" ID	B-J	CHM-2547-B Sheet 1	E/Pump	4/No scan 3,5,6/Limited	70%	No scan 4 due to nozzle transition. Scans 3, 5, and 6 limited due to nozzle transition and weld taper preventing transducer coupling (Note 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCF-F3-1 31" ID	B-F	CHM-2547-B Sheet 1	Nozzle Safe End/E	3/No scan 5,6/Limited	42%	Automated examination 77/S78. No scan 3 and limited scans 5 and 6 due to nozzle transition (Note 10)
RCF-F3-1-SE 31" ID	B-F	CHM-2660-B Sheet 1	N/Safe end	3,5,6/No scan 4/Limited	24%	No scans 3, 5, and 6 due to nozzle transition. Scan 4 limited due to nozzle taper (Note 10)
RCF-F3-4 31" ID	B-J	CHM-2547-B Sheet 1	E/Pump	4/No scan 3,5,6/Limited	69%	No scan 4 and scans 3, 5, and 6 limited due to nozzle transition and weld taper preventing transducer coupling (Note 10)
RCF-F4-1 31" ID	B-F	CHM-2547-B Sheet 1	Nozzle Safe End/E	3/No scan 5,6/Limited	25%	Automated examination 77/S78. No scan 3 due to nozzle transition. Limited scans 5 and 6 due to weld contour O.D. configuration. (Note 10)
RCF-F4-1-SE 31" ID	B-F	CHM-2660-B Sheet 1	N/Safe end	3/No scan 4,5,6/Limited	22%	No scan 3 and limited scan 4, 5, and 6 due to nozzle transition/weld taper preventing transducer coupling (Note 10)
RCF-F4-2 31" ID	B-J	CHM-2547-B Sheet 1	E/P	All/Limited	75%	All scans limited due to weld contour O.D. configuration (Note 10)
RCF-F4-4 31" ID	B-J	CHM-2547-B Sheet 1	E/Pump	4/No scan 3/Limited	73%	No scan 4 and limited scan 3 due to nozzle transition/weld taper preventing transducer coupling (Note 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCS-1-6 6" Diameter	B-J	CHM-2547-B Sheet 1	Branch connection	3/No scan 5,6/Limited	50%	No scan 3 and limited scans 5 and 6 due to branch connection nozzle transition (Notes 9 and 10)
RCS-2-6 6" Diameter	B-J	CHM-2547-B Sheet 1	Branch Connection	3/No scan 5,6/Limited	50%	No scan 3 and limited scans 5 and 6 due to branch connection nozzle transition (Note 9 and 10)
RCS-3-6 6" Diameter	B-J	CHM-2547-B Sheet 1	Branch Connection	3/No scan 5,6/Limited	50%	No scan 3 and limited scans 5 and 6 due to branch connection nozzle transition (Notes 9 and 10)
RCS-4-6 14" Diameter	B-J	CHM-2547-B Sheet 1	Branch Connection	4/No scan 5,6/Limited	50%	Manual examination 77/S78. No scan 4 and limited scans 5 and 6 due to branch connection nozzle transition (Note 10)
RCS-P-1 14" Diameter	B-J	CHM-2547-B Sheet 1	Branch Connection	4/No scan 5,6/Limited	50%	Manual examination 77/S78. No scan 4 and limited scans 5 and 6 due to branch connection nozzle transition (Note 10)
RCW-01 4" Diameter	B-J	ISI-0017-C Sheet 2	Branch Connection	3,5,6/No scan	25%	No scans 3, 5, and 6 due to branch connection nozzle transition (Notes 9 and 10)
RCW-02 4" Diameter	B-J	ISI-0017-C Sheet 2	Branch Connection	3,5,6/No scan	25%	No scan 3, 5, and 6 due to branch connection nozzle transition (Note 9 and 10)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
RCW-14 3" Diameter	B-J	ISI-0017-C Sheet 1	F/V	No scan	0%	No examination due to component geometry (Note 8)
RCW-15 3" Diameter	B-J	ISI-0017-C Sheet 1	F/V	No scan	0%	No examination due to component geometry (Note 8)
RHRS-022A 14" Diameter	C-F	CHM-2636-C Sheet 2	Pen F/ Pen P	No scan	0%	No examination due to weld inside penetration
RHRS-35A 14" Diameter	C-F	CHM-2636-C Sheet 3	Pen P/ Pen F	No scan	0%	No examination due to weld inside penetration
RHRS-159A 12" Diameter	C-F	CHM-2636-C Sheet 6	Pen P/ Pen F	No scan	0%	No examination due to weld inside penetration
SIF-D089-6 10" Diameter	B-J	CHM-2758-C Sheet 7	V/T	3/No scan 4/No scan	50%	No scan 3 and 4 due to valve to tee weld (Note 7)
SIF-D090-5 10" Diameter	B-J	CHM-2758-C Sheet 8	V/T	3/No scan 4/No scan	50%	No scan 3 and 4 due to valve to tee weld configuration (Note 7)
SIF-D090-6 6" Diameter	B-J	CHM-2758-C Sheet 8	P/V	3/No scan 4/Limited	84%	No scan 3 due to valve. Scan 4 limited between 0200 to 0500 due to weldolet. Scan 4 utilized 12/8 V scan for Bi-directional coverage (Notes 5, 6, and 7)

REQUEST FOR RELIEF ISI-4 (Continued)

Weld Number <sup>1</sup>	Code Category <sup>2</sup>	Drawing Number	Physical Configuration <sup>3</sup>	Scan <sup>4</sup> /Limitation	Approximate Percent Code Examined	Remarks
SIF-D091-4 6" Diameter	B-J	CHM-2758-C Sheet 9	E/V	3/No scan 4/Limited	84%	No scan 3 due to valve. Scan 4 limited between 0500 to 0800 due to elbow introdose. Scan 4 utilized 12/8 V scan for Bi-directional coverage (Notes 5, 6, and 7)
SIF-D091-6 10" Diameter	B-J	CHM-2758-C Sheet 9	V/T	3/No scan 4/No scan	50%	No scans 3 and 4 due to valve to tee weld configuration (Note 7)
SIS-76A 8" Diameter	C-F	CHM-2758-C Sheet 6	Pen P/ Pen F	No scan	0%	No examination due to weld inside penetration

REQUEST FOR RELIEF ISI-4 (Continued)

- NOTES:
1. LS following seam number indicates longitudinal seam.
  2. Categories determined in accordance with ASME XI 74S75.
  3. P = Pipe, V = Valve, E = Elbow, T = TEE, R = Reducer, F = Flange, N = Nozzle, Pen P = Penetration Process Pipe, and Pen F = Penetration Flued Head.
  4. Scans 3 and 4 are perpendicular to circumferential welds.  
Scans 5 and 6 are parallel to circumferential welds.  
Scans 7 and 8 are perpendicular to longitudinal welds.  
Scans 9 and 10 are parallel to longitudinal welds.
  5. Limitations are expressed in o'clock references. In general, the exact limitation is noted rather than a percentage of the required examinations.
  6. Examinations conducted from one side of the weld provide full coverage within the variable limits of weld penetrability and opposite surface conditions.
  7. This weld can be exempt from examination to the later code since the stress level and usage factor were below the limits under loads associated with specific seismic events and operational conditions. [1977 Edition, Summer 1978 Addenda, Table IWB-2500-1, Category B-J, Noted (1)(b)]
  8. This weld can be exempt from volumetric examination by the later code since the nominal pipe size is less than four inches. (1977 Edition, Summer 1978 Addenda, Table 2500-1, Category B-J)
  9. This weld was added to the request because the program was updated to later requirement (1977 Edition, Summer 1978 Addenda) on Class 1 piping weld examinations performed after 7-1-89. The exemption size on branch connections decreased from 74S75 (welds exceeding 6") to 77S78 (welds exceeding 2") for welds requiring volumetric examination.
  10. The examination was performed from the O.D. surface to the extent of examination requirements of ASME Section XI 1977 Edition, Summer 1978 Addenda.

ENCLOSURE 2

LIST OF COMMITMENTS

The revised Inservice Inspection (ISI)-4 will be included in the next revision (Revision 23) of the Preservice Inspection (PSI) program.