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 AUTH. NAME: AUTHOR AFFILIATION
 MILLS, L.M. Tennessee Valley Authority
 RECIP. NAME: RECIPIENT AFFILIATION
 O'REILLY, J.P. Region 2, Atlanta, Office of the Director *MAI*

SUBJECT: Fourth interim deficiency report re lack of internal purge on welds in chemical addition & boron recovery sys, initially reported on 800417. Util will identify stainless steel welds requiring purge. Next report scheduled on 810624.

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 TITLE: Construction Deficiency Report (10CFR50.55E)

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TENNESSEE VALLEY AUTHORITY

CHATTANOOGA, TENNESSEE 37401

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December 1, 1980

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Mr. James P. O'Reilly, Director
Office of Inspection and Enforcement
U.S. Nuclear Regulatory Commission
Region II - Suite 3100
101 Marietta Street
Atlanta, Georgia 30303

Dear Mr. O'Reilly:

BELLEFONTE NUCLEAR PLANT UNITS 1 AND 2 - LACK OF INTERNAL PURGE ON TWO WELDS IN CHEMICAL ADDITION AND BORON RECOVERY SYSTEM - NCR 1171 - FOURTH INTERIM REPORT

The subject nonconformance was initially reported to NRC-OIE Inspector J. D. Wilcox on April 17, 1980, in accordance with 10 CFR 50.55(e). Interim reports were submitted on May 16, June 3, and July 23, 1980. Enclosed is our fourth interim report. We expect to submit our next written report by June 24, 1981.

If you have any questions concerning this matter, please get in touch with D. L. Lambert at FTS 857-2581.

Very truly yours,

TENNESSEE VALLEY AUTHORITY

L. M. Mills, Manager
Nuclear Regulation and Safety

Enclosure

cc: Mr. Victor Stello, Jr., Director (Enclosure) ✓
Office of Inspection and Enforcement
U.S. Nuclear Regulatory Commission
Washington, DC 20555

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ENCLOSURE

BELLEFONTE NUCLEAR PLANT UNITS 1 AND 2
LACK OF INTERNAL PURGE ON TWO WELDS IN CHEMICAL ADDITION
AND BORON RECOVERY SYSTEM

NCR 1171

10 CFR 50.55(e)

FOURTH INTERIM REPORT

Description of Deficiency

During routine rework operations of chemical addition and boron recovery (CA&BR) system, it was discovered that two welds (ONB-00367 and ONB-00368) had evidence of lack of sufficient internal purge. The apparent cause was inadequate maintenance of purge during root and/or subsequent filler passes. These welds were originally made in February and March of 1978.

In the course of reviewing the CA&BR system, TVA's investigation revealed sugaring of other stainless steel pipe welding that was not originally covered by the NCR. It appears that sugaring of welds on stainless steel pipe caused by lack of internal purge may be a generic concern at Bellefonte.

Interim Progress

After trying unsuccessfully to identify a common factor attributing to the lack of purge concern in stainless steel systems, TVA has opted to identify all stainless steel welds requiring purge made before January 15, 1980 (the date of inception of Bellefonte's spot radiography program). Using the sampling techniques for inspection of MIL-Standard 105D, the work of 221 welders responsible for making in excess of 5100 welds that comprise the sample space will be sampled by radiography for evidence of lack of purge.

To date 108 welders of the 221 identified have had their welds sample radiographed. A total of 487 spot radiographs for these 108 welders have been taken. Of the 487 welds inspected, 9 have been found rejectable because of lack of internal purge for a reject rate of 1.8 percent.

Welds having evidence of lack of purge will be reworked. Those welds embedded and inaccessible for inspection and rework will be nonconformed. Those welders with poor performance records with regards to lack of internal purge will have their certifications revoked.