#### REGULATORY INFORMATION DISTRIBUTION SYSTEM (RIDS) DOCKET # ACCESSION NBR:8807260029 DOC.DATE: 88/07/12 NOTARIZED: NO FACIL:50-305 Kewaunee Nuclear Power Plant, Wisconsin Public Servic 05000305 AUTHOR AFFILIATION AUTH.NAME STEINHARDT, C.R. Wisconsin Public Service Corp. RECIP.NAME RECIPIENT AFFILIATION Document Control Branch (Document Control Desk) SUBJECT: Forwards documentation identifying ISI exams completed during annual refueling outage for 1988. DISTRIBUTION CODE: A047D COPIES RECEIVED:LTR ( ENCL SIZE: TITLE: OR Submittal: Inservice Inspection/Testing/Relief from ASME Code NOTES: RECIPIENT COPIES RECIPIENT COPIES LTTR ENCL ID CODE/NAME ID CODE/NAME LTTR ENCL PD3-3 LA 1 0 PD3-3 PD 5 5 CITTTER I

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WISCONSIN PUSLIC SERVICE CORPORATION

600 North Adams • P.O. Box 19002 • Green 8ay, WI 54307-9002

July 12, 1988

10 CFR 50.55a

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

Gentlemen:

Docket 50-305 Operating License DPR-43 Kewaunee Nuclear Power Plant ISI Examinations Completed During the Annual Kewaunee Refueling Outage of Year 1988

As required by Code and Regulation, various ISI examinations were performed during the past refueling outage (March 3, 1988 to April 14, 1988). This refueling outage constituted the first inspection year of the 2nd period of the 2nd interval. The examination requirements for this inspection year are listed in the 1980 Edition Through Winter 1981 Addenda of Section XI. These requirements were implemented in accordance with the "Kewaunee Nuclear Power Plant ISI Plan and Schedule - Second Ten Year Interval (1984-1994)" and Westinghouse Electric Corporation NDE procedures.

This past year, the reactor vessel internals, conoseal bolting, and closure head studs were nondestructively examined. Balance of plant components, main flange bolts from 1A Reactor Coolant Pump, and various welds on the pressurizer and 1A Steam Generator were also inspected. Other ASME Code Class I components were visually inspected during the reactor coolant system pressure test. Although not required by Section XI, eight (8) large bore snubbers (900 Kip) on 1A and 1B Steam Generators were functionally tested by Bergen-Paterson. Also, small bore snubber testing and eddy current testing of steam generator tubes were performed; these inspections were implemented in accordance with in-house surveillance procedures and the plant technical specifications.

During the refueling outage, no welded repairs were performed to correct conditions noted during the inservice inspection. However, welded repairs and alterations were performed over the last year (and during the refueling outage) due to design change work and replacements of components which had reached end

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Document Control Desk July 1.2, 1988 Page 2

of life, etc. In accordance with the requirements of the Wisconsin Administrative Code, Chapter ILHR 42, these welded repairs and alterations are approved/inspected by an authorized inspector and a record (Form SB-190) of each has been furnished to the State of Wisconsin.

In keeping with the reporting requirements of IWA-6230 of Section XI, the following summary documentation is attached:

- NIS-1 Form for 1st Outage, 2nd Period, 2nd Interval,
- NDE Summary Report of 1st Outage, 2nd Period, 2nd Interval,
- Owner's letter of Disposition for Items Reported During 1st Outage, 2nd Period, 2nd Interval,
- Summary of Steam Generator Tube Sleeving, Post Sleeving, Baseline Eddy Current Inspection, and Mechanical Plugging,

- Summary of Steam Generator 900 Kip Snubber Testing,

- Welded Repair Records (Form SB-190) .

The complete reports of these inspections are on file in the QA/QC Records Vault at the Kewaunee Nuclear Power Plant.

Sincerely,

law Stermander

C. R. Steinhardt Manager - Nuclear Power

CSS/jms

Attach.

cc - Mr. Robert Nelson, US NRC US NRC, Region III

SHEET <sup>1</sup> OF <sup>4</sup>

## FORM NIS-1, OWNER'S DATA REPORT FOR INSERVICE INSPECTIONS AS REQUIRED BY THE PROVISIONS OF THE ASME CODE RULES

- 1. OWNER WISCONSIN PUBLIC SERVICE CORPORATION, P.O. BOX 19002, GREEN BAY, WISCONSIN 54307
- 2. PLANT KEWAUNEE, ROUTE 1, P.O. BOX 4B, KEWAUNEE, WISCONSIN 54216
- 3. PLANT UNIT No. 1
- 4. OWNER CERTIFICATE OF AUTHORIZATION N/A
- 5. COMMERCIAL SERVICE DATE JUNE 16, 1974
- 6. NATIONAL BOARD NUMBER FOR UNIT N/A
- 7. COMPONENTS INSPECTED -

COMPONENT OR Appurtenance	MANUFACTURER O Or installer	ANUFACTURER R INSTALLER SERIAL NQ.	STATE OR PROVINCE NO.	NATIONAL BOARD NO.
Reactor Vessel	Combustion Engineeri	ng 69202	U114 <u>B</u> 0	21010
Pressurizer	Westinghouse	1151	U11402	ہ <b>68–23</b>
Steam Generator A	Westinghouse	1141	411400	6928
Steam Generator B	Westinghouse	1142	U 11 401	6929
Excess Letdown Heat Exchanger 1A	Sentry	3996-5 <b>E</b>	U 11407	364
Excess Letdown Heat Exchanger 1B	Sentry	3996-6E	U 11408	365
Class 1 Piping	Phillips Getschow			
Reactor Coolant Pump 1A	Westinghouse	RCPCPI-01		
Reactor Coolant Pump 18	Westinghouse	RCPCP1-02		

ID:0002b/40788:50-1

SHEET <sup>2</sup> OF <sup>4</sup>

## FORM NIS-1, OWNER'S DATA REPORT FOR INSERVICE INSPECTIONS AS REQUIRED BY THE PROVISIONS OF THE ASME CODE RULES

1. OWNER - WISCONSIN PUBLIC SERVICE CORPORATION, P.O. BOX 19002, GREEN BAY, WISCONSIN 54307

2. PLANT - KEWAUNEE, ROUTE 1, P.O. BOX 48, KEWAUNEE, WISCONSIN 54216

3. PLANT UNIT - No. 1

4. OWNER CERTIFICATE OF AUTHORIZATION - N/A

5. COMMERCIAL SERVICE DATE - JUNE 16, 1974

6. NATIONAL BOARD NUMBER FOR UNIT - N/A

7. COMPONENTS INSPECTED -

COMPONENT OR Appurtenance	MANUFACTURER OR INSTALLER	MANUFACTURER OR INSTALLER SERIAL NO.	STATE OR Province No.	NATIONAL BOARD NO.
Residual Heat Exchanger 1A	Joseph Oat & Sons	1817-1E	U <u>11</u> 406	344
Residual Heat Exchanger 1B	Joseph Oat & Sons	1817–1F	u11424	345
Letdown Heat Exchanger	Atlas	1206	U 11405	1031
Charging Pump Surge Vessel 1A	Greer Products	6576		
Seal Water Heat Exchanger	Atlas	734	U11404	596
Volume Control Tank	Joseph Oat & Sons	1787-1C	U11425	376
Regenerative Heat Exchanger	Joseph Oat & Sons	1831-13		413

SHEET 3 OF 4

# FORM NIS-1, OWNER'S DATA REPORT FOR INSERVICE INSPECTIONS AS REQUIRED BY THE PROVISIONS OF THE ASME CODE RULES

1. OWNER - WISCONSIN PUBLIC SERVICE CORPORATION, P.O. BOX 19002, GREEN BAY, WISCONSIN 54307

2. PLANT - KEWAUNEE, ROUTE 1, P.Q. BOX 48, KEWAUNEE, WISCONSIN 54216

3. PLANT UNIT - No. 1

4. OWNER CERTIFICATE QF AUTHORIZATION - N/A

5. COMMERCIAL SERVICE DATE - JUNE 16, 1974

6. NATIONAL BOARD NUMBER FOR UNIT - N/A

7. COMPONENTS INSPECTED -

COMPONENT OR Appurtenance	MANUFACTURER OR INSTALLER	MANUFACTURER OR INSTALLER SERIAL_NO	STATE OR PROVINCE NO.	NATIONAL BOARD NO.
Seal Water Injection Filter 1A	Commercial Filter	101072		<b>1172</b>
Seal Water Injection Filter 1B	Commercial Filter			1173
Class 2 Piping	Phillips Getschow			
Diesel Generator Cooling Water Heat Exchanger 1A	Young Radiator Co.	231093 231094		
Diesel Generator Cooling Water Heat Exchanger 1B	Young Radiator Co.	231095 231096		

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SHEET 4 OF 4

## FORM NIS-1, OWNER'S DATA REPORT FOR INSERVICE INSPECTIONS AS REQUIRED BY THE PROVISIONS QF THE ASME CODE RULES

1. OWNER - WISCONSIN PUBLIC SERVICE CORPORATION, P.O. BOX 19002, GREEN BAY, WISCONSIN 54307

2. PLANT - KEWAUNEE, ROUTE 1, P.O. BOX 48, KEWAUNEE, WISCONSIN 54216

3. PLANT UNIT - No. 1

4. OWNER CERTIFICATE OF AUTHORIZATION - N/A

5. COMMERCIAL SERVICE DATE - JUNE 16, 1974

6. NATIONAL BOARD NUMBER FOR UNIT - N/A

7. COMPONENTS INSPECTED -

COMPONENT OR Appurtenance	MANUFACTURER OR INSTALLER	MANUFACTURER OR INSTALLER SERIAL_NO	STATE OR PROVINCE NO.	NATIONAL BOARD NO.
Auxiliary Feed Pump Turbine Driven	Pacific Pump	46575		
Component Cooling Heat Exchanger 1A	Engineering Fabrication	15748-A	U11426	1139
Component Cooling Surge Tank	Sharpsville Steel Fab.	WPSACATCC-1	u <u>11</u> 421	714
Class 3 Piping	Phillips Getschow		` <u></u>	
Service Water Pump 1A1	Worthington Pump	VTP27736		
Containment Spray Pump 1A	Ingersoll Rand	0 <b>670</b> 74	<b></b>	
Spent Fuel Pool Heat Exchanger	Struther Wells	1-68-06-151	9 U <u>11</u> 445	13105
Residual Heat Removal Pump 1A	Byron Jackson Pump	APCAPRH-01		

#### FORM NIS-1 (back)

8.	Examination Datas	3-6-88	to _	4-10-88
9.	Inspection Interval from	6-16-84	to	6-16-94

10. Abstract of Examinations. Include a list of examinations and a statement concerning status of work required for current interval. Reference Tab C

1. Abstract of Conditions Noted	Reference	Tab	В	and	Tab	F	
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12. Abstract of Corrective Measures Recommended and Taken Reference Tab B and Tab F

We certify that the statements made in this report are correct and the examinations and corrective measures taken conform to the rules of the ASME Code, Section XI.

Date July 8 19 88 Signed Wisconsin Public Scruice By XHE vere N/A Expiration Date Certificate of Authorization No. (if applicable)

# CERTIFICATE OF INSERVICE INSPECTION

I, the undersigned, holding a valid commission issued by the National Board of Boiler and Pressure Vessel Inspectors and/or the Stete or Province of <u>Wisconsin</u> and employed by <u>Hartford Steam Boiler</u> of <u>Hartford CT</u>, have inspected the components described in this Owners Data Report during the period <u>3-6-88</u> to <u>4-10-88</u>, and state that to the best of my knowledge and belief, the Owner has performed examinations and taken corrective measures described in this Owners Data Report in accordance with the requirements of the ASME Code, Section XI.

By signing this cartificate neither the Inspector nor his employer mekes any warranty, expressed or implied, concerning the examinations and corrective measures described in this Owners Data Report. Furthermora, neither the Inspector nor his employer shall be liable in any manner for any personal injury or property damage or a loss of any kind arising from or connected with this inspection.

Date July 8 19 88				
loger Molquin	Commissions	NB7741	WIS #38	
Inspactors Signature		Nation	Board, State	, Provinca and No.

#### WISCONSIN PUBLIC SERVICE CORPORATION KEWAUNEE NUCLEAR POWER PLANT UNIT NO. 1 1ST OUTAGE; 2ND PERIOD; 2ND INTERVAL 1988

## INTRODUCTION

An Inservice Examination Program was performed at the Kewaunee Nuclear Power Plant Unit No. 1 from March 6, 1988 thru April 10, 1988 by Westinghouse Electric Corporation Nuclear Services Integration Division - Inspection Services and Wisconsin Public Service Corporation - Kewaunee Unit No. 1.

Examinations were performed to the requirements of ASME Boiler and Pressure Vessel Code Section XI - 1980 Edition up to and including Winter 1981 Addenda.

The Examination Program Plan located under Tab C was prepared by Kewaunee Nuclear Power Plant Unit No. 1 for the 1st Outage, 2nd Period, 2nd Interval as identified in the 2nd Ten-Year Plan (1984-1994).

The following items were examined (Reference Tab C):

- 1. Reactor Vessel
- 2. Pressurizer
- 3. Steam Generator A
- 4. Class 1 and Class 2 Piping
- 5. Reactor Coolant Pumps A and B
- 6. Class | Valves
- 7. Class 2 Components
- 8. Class 1, 2 and 3 Piping and Components Supports and Hangers
- 9. Class 1 System Leakage Test (Performed by Wisconsin Public Service Corporation - Kewaunee Unit No. 1 Nuclear Power Plant Personnel)

The examinations performed were in accordance with an approved Examination Program Plan located under Tab C of the Final Report. Examination procedures were approved prior to the start of examinations and certification documents relative to personnel, equipment and materials were reviewed and determined to be satisfactory.

Witnessing and surveillance of the examinations and related activities were conducted by personnel from: United States Nuclear Regulatory Commission, Hartford Steam Boiler Inspection and Insurance Company and Wisconsin Public Service Corporation Quality Assurance Department.

#### RESULTS

Examinations resulted in the following recordable indications being noted on the basis of procedure recording criteria, which generally are more critical than specified ASME Section XI Acceptance Standards.

 Recordable Ultrasonic Indications were noted on the Upper Transition to Shell Weld 1-5 (SG-W2) on Drawing WPS-2-1100 (M1206) utilizing 45° and 60° Ultrasonic Examination Angles. All indications recorded were either

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acceptable by ASME Boiler and Pressure Vessel Code Section XI - 1980 Edition thru Winter 1981 Addenda or by Fracture Analysis. Reference Tab F - Section F101 for complete evaluation of all Ultrasonic Indications for Steam Generator Weld 1-5 (SG-W2).

- 2. Six (6) Reactor Vessel Studs 18 (RV-S18), 20 (RV-S20), 21 (RV-S21), 23 (RV-S23), 27 (RV-S27) and 32 (RV-S32) on Drawing WPS-1-1400 (M1196) had nine (9) recordable surface indications of which seven (7) were noted visually in 1984. These indications were dispositioned and accepted by Kewaunee Unit No. 1 Nuclear Power Plant Personnel.
- 3. Nine (9) Recordable Indications on drawings WPS-1-4105 (M1146) 4WS (RSI-H62), WPS-1-4202 (M1152) 6 (SI-W58), WPS-1-4210 (M1156) 36 (CVC-W62S), WPS-1-4215 (M1158) 34 (CVC-W119S), WPS-2-1110 (M1207) 1A-1WS (AHRSI-SW1), WPS-2-2101 (M1166)-11 (FW-W15), WPS-2-2200 (M1167) 20BC (MS-W70BC), WPS-2-2531 (M1172) 4WS (RHR-H34A) and WPS-2-2531 (M1172) 51 (RHR-W241) were noted by surface examinations on Class 1 and Class 2 Piping and Welded Supports. These indications were dispositioned, accepted or repaired, reexamined and found to be acceptable.
- 4. Twenty-one (21) Recordable Indications on drawings WPS-1-1200 (M1199) -Flange to core barrel weld, WPS-1-1300 (M1197) - 35 (RV-CB2), WPS-1-4105 (M1146) - 7H (RSI-H104) and 8HS (RSI-H67), WPS-1-4111 (M1147) - 4R (CVC-H2010), WPS-1-4113 (M1150) - 2H (RCVC-H66) and 8H (RCVC-H60), WPS-1-4213 (M1157) - 3HS (RCVC-H32), WPS-1-4503 (M1159) - 8000A (PR-1A), 8000B (PR-1B) and 3SH (RC-H11), 2-1300 (M1212) 1A-2WS (AFSW-SW2), WPS-1-2542 (M1176) - 4CS (RHR-H16), WPS-3-1100 (M1224) - 1A Support, WPS-3-1140 (M1222) - Supports, WPS-3-3400 (M1177) - 3R (SW-H5), 5R (SW-H3) and 6R (SW-H1), WPS-3-3850 (M1180) - 10SH (SFP-H1) and WPS-3-3854 (M1191) - 1R (SFP-H2177) and 2R (SFP-H2178) were noted by visual examinations on Reactor Vessel Core Barrel, Reactor Vessel Closure Head and Class 1, Class 2 and Class 3 Valve Bolting or Piping and Component Supports and Hangers. These indications were dispositioned, accepted or repaired, reexamined and found to be acceptable.
- 5. Twenty-one (21) recordable indications were noted on values during the performance of the Class 1 System Leakage Test performed by Kewaunee Unit No. 1 Nuclear Power Plant personnel. These indications were dispositioned and repaired, reexamined and found to be acceptable by Kewaunee Unit No. 1 Nuclear Power Plant personnel.

Specific data relative to the above indications and their dispositons are located under Tab F of Volume 2 of the Final Report.

OWNER'S LETTER OF DISPOSITION WISCONSION PUBLIC SERVICE CORPORATION KEWAUNEE NUCLEAR POWER PLANT 1st Outage, 2nd Period, 2nd Interval 1988 Outage Core XIII - XIV

During the 1988 refueling outage, Westinghouse Electric Corporation personnel performed nondestructive examinations of selected components at the Kewaunee Nuclear Power Plant. These examinations resulted in seventy-one (71) indications being reported on the basis of Westinghouse NDE procedure recording criteria which is more restrictive than Section XI acceptance criteria. All seventy-one (71) of these indications have been evaluated and dispositioned (accepted, repaired/replaced, or monitored). Of the seventy-one (71) indications only twenty-one (21) of them were evaluated by Wisconsin Public Service Corporation as marginally exceeding the acceptance criteria of Section XI.

Fourteen (14) of the twenty one (21) indications which exceeded the acceptance criteria of Section XI were found on the upper shell to cone weld on steam generator 1A. Westinghouse Electric Corporation performed a detailed evaluation of all fourteen (14) of the girth weld indications in accordance with the requirements of IWB-3600 and Appendix A of Section XI. All of these girth weld indications have been shown to be acceptable as documented in the March 28, 1988 letter from D C Hintz to USNRC titled, "Steam Generator Girth Weld Fracture Analysis".

The remaining seven (7) indications which exceeded the acceptance criteria of Section XI were found on balance of plant components. All seven (7) of these indications were corrected and subsequently re-examined and found to be acceptable.

A brief summary of these seven (7) indications are provided below:

Identification	Description of Component	Type of Indication	Resolution
1. RCVC-H66	Rod Hänger	visual-not tensioned	readjusted setting
2. SI-W58	butt weld	surface-linear indication in base metal	mechanically removed indication
3. RHR-H34A	lugs welded to pipe	surface-linear indication on lugs	mechanically removed indication
4. ŔHR-W241	butt weld	surface-curved linear indication in base metal	mechanically - removed indication
5. FW-W15	butt weld	surface-linear indication in base metal	mechanically removed metal to reduce indica- tion to acceptable size
6. MS-W70BC	fillet weld on reinforcing pad	surface-linear indication in fillet weld	mechanically removed indication
7. AHRSI-SWI	fillet weld on support to heat exchanger	surface-linear indication in fillet weld	mechanically removed indication

In closing, Wisconsin Public Service Corporation acknowledges that all seventy-one (71) indications listed in the Westinghouse NDE Summary Report have been dispositioned in accordance with the 1980 Edition through Winter 1981 Addenda of Section XI and that the Authorized Nuclear Inservice Inspector has verified this activity.

Sincerely,

Charles A. Jomes

Charles A Tomes Plant Nuclear Engineer Wisconsin Public Service Corporation Kewaunee Nuclear Power Plant

HE vers

Kenneth H Evers Plant Manager Wisconsin Public Service Corporation Kewaunee Nuclear Power Plant

CUSTOMER: SITE: PERIOD OF SERVICE: FIELD SERVICE REPORT: WISCONSIN PUBLIC SERVICE COMPANY KEWAUNEE NUCLEAR POWER PLANT MARCH 5 TO APRIL 3, 1988 WPS-15

During the Spring 1988 maintenance and refueling outage, the Steam Generator Primary Services Department of the Westinghouse Energy Systems Service Division (ESSD) completed a program of steam generator tube sleeving, post sleeving baseline eddy current inspection, and mechanical plugging in the steam generators of Wisconsin Public Service Company's Kewaunee Nuclear Power Plant.

# STEAM GENERATOR TUBE SLEEVING

Wisconsin Public Service Company contracted Westinghouse to perform a preventative steam generator sleeving program over a two outage period. The program required that two sleeve lengths, 30" and 36" be installed to maximize tubesheet coverage. The 36" sleeves were installed in the central tubesheet regions while the 30" sleeves were installed in the peripheral regions extending the sleeving boundary. Approximately half of the total number of preventative sleeves were to be installed in 1988 with the balance in 1989. Additionally, all 30" sleeves were to be installed in 1988 to allow for only one sleeve length in 1989. Tubes which were identified as having pluggable indications within the established sleeving parameters were added to the sleeving program as corrective candidates.

As per the final preventative and corrective programs a total of 1940 sleeves were installed with the following distribution:

Steam Generator A Hot Leg - 990 Steam Generator B Hot Leg - 950

The majority of the sleeving processes were performed remotely and automatically with the Remotely Operated Service Arm (ROSA) delivery system and the Automatic Logic Integrated Sleeving II (ALIS II) computerized tool control system. The systems were operated from the Westinghouse Multi-Purpose Field Service Unit (MPFSU) which was staged outside of the Kewaunee Auxiliary Building. A limited number of processes were performed manually in situations where sleeving candidates were located outside of the automatic sleeving boundary but within the manual sleeving boundary.

Sleeving operations were completed according to manufacturing sequences that were prescribed for particular operations. All activities were monitored by Westinghouse Quality Services (QS) personnel for completion and to verify adherence to procedure. The role of the site QS group was extensive in all aspects of the sleeving program. QS duties included, but were not restricted to: receipt inspection and control of sleeves and mechanical plugs; distribution, control and approval of all controlled documents including manufacturing sequences and process control sheets; field procedures and field change notices; continuous monitoring of sleeving operations including the completion and maintenance of data records; issuance and control of nonconformance reports and concurrence upon their final disposition; maintenance of on-site personnel certifications; performance of visual and dimensional inspection; regular issuance of QS surveillance and housekeeping records; and generation of the final QS data package.

The final QS data package was presented to Wisconsin Public Service Company at the conclusion of site operations. Appendix I provides an index of items included in this data package. Although the QS data package is not duplicated as a part of this report, it is considered an integral part of the final report and is included in the microfiche copy of the report.

Appendix II contains the steam generator tube sleeving certificate of conformance.

A normal sleeve installation sequence of operations was followed in both steam generators. Candidate locations were wet honed prior to sleeve insertion, expansion, lower hard rolling, upper hard rolling, in-process eddy current inspection and post-operation baseline eddy current inspection. An anomalous, short tube to tubesheet roll was identified in a quantity of tubes in both Steam Generators A and B. As a result, a shorter than typical sleeve to tube lower hard roll was developed and tested in Westinghouse laboratories. The test results were presented to the NRC in Washington, DC by Wisconsin Public Service and Westinghouse representatives with favorable results. With NRC concurrence short lower hard roll was performed on the applicable sleeves. A WCAP detailing the final test results will be presented to formally conclude the issue.

Appendix III contains the Kewaunee Sleeving Information Management System II (SIMS II) Sleeving Report 3. This report presents a detailed summary of sleeving operations.

Periodically, sleeve installation condition deviations were encountered during the sleeving processes. Sleeved tube locations that did not comply with the prerequisite acceptance criteria for properly executed tube sleeve installations were cataloged by QS personnel in a Nonconformance Report (NR) for further evaluation and resolution. These reports for subject tube locations, the applicable source document requirements not met, the recommendations for resolving the situation, and the actual corrective action taken are all listed on QS generated documents.

Resolution of a NR was at the initial direction of the on-site Westinghouse Technical Advisor, who would request assistance from Westinghouse Pittsburgh on an as-needed basis. Items that were enveloped in approved drawings, procedures, sleeving licensing report, and other available specifications were resolved on site. Those items that were outside of this envelope mandated written approval from the Westinghouse headquarters engineering staff. A total of 31 NRs were written for sleeving and plugging operations. All were dispositioned to the satisfaction of the cognizant Wisconsin Public Service Company representative, the Westinghouse Technical Advisor, the Westinghouse Site Sleeving Director, Westinghouse Quality Services, and Westinghouse headquarters in Pittsburgh.

Appendix IV contains the Kewaunee SIMS II Report 6 which provides a summary of all NRs generated.

# EDDY CURRENT INSPECTION

The following eddy current inspections were performed on all installed sleeves during the 1988 Kewaunee Sleeving Program.

- 1. An in-process dimensional verification of upper and lower joints, radial dimensions and any abnormal dimensional characteristics (if present).
- 2. A final baseline inspection of both the tube and sleeve wall thicknesses to provide a reference point for future inspection.

The in-process dimensional verification data and final baseline inspection eddy current data was evaluated by Westinghouse Level IIA evaluators. Results of the inspection are summarized in Appendix V - Kewaunee SIMS II Report 9.

## MECHANICAL PLUGGING

Mechanical plugs were installed in the hot and cold legs of both steam generators at Kewaunee. A total of 86 mechanical plugs were installed with the following distribution:

Steam Generator A Cold Leg - 17 Steam Generator A Hot leg - 17 Steam Generator B Cold Leg - 26 Steam Generator B Hot Leg - 26

Appendix VI contains SIMS-II Report 11. This report presents a detailed summary of plugging operations.

#### SUMMARY

A total of 1940 sleeves were installed in both steam generators with a manREM expenditure of 66.785 or 34.43 mR per sleeve. Steam Generator A was completed in 17 days, approximately 2.4 days ahead of the proposed schedule with an average production rate of 56.1 sleeves per day. Steam Generator B was

completed in 14.3 days, approximately 4.7 days ahead of the proposed schedule with an average production rate of 66.4 sleeves per day. Eighty-six mechanical plugs were installed in both steam generators with a total manREM expenditure of 4.661.

Prepared By

F<sup>U</sup> J. Klorczyk, Manager

Outage Management Programs Kewaunee Sleeving Director

Approved By

R. M. Clark, Manager Steam Generator Primary Services

Approved By

1

C. A. Meyers, Manager Operations, Q.A.

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June 22, 1988

Green Bay

#### Steam Generator 900 Kip Snubber Test Results

C A Tomes

Each of the Kewaunee steam generators was originally designed with four (4) 900,000 lb. hydraulic snubbers located at the upper lateral support, acting in the direction of the horizontal section of the main steam line at the steam generator nozzel.

These snubbers were designed to limit deflection of the steam generators during postulated ruptures of the main steam, feedwater, or reactor coolant piping, or during the postulated design basis earthquake.

Due to NRC acceptance of new analysis techniques, many of the previously postulated loads on the snubbers were eliminated, allowing removal of three snubbers from each steam generator. WPSC applied to the NRC for approval of this design change on February 5, 1988. Approval was received on March 18, 1988, prior to restart from cycle 13-14 refueling outage.

Visual and functional testing was performed on all eight snubbers to verify that lockup velocity, bleedrate velocity and drag forces were within specifications. All eight passed the velocity and visual tests but failed their drag test. It was subsequently learned that there was a significant difference in the technique of measuring drag force between the original and current testing procedures. To resolve this inconsistency, WPSC contracted Westinghouse to provide acceptable drag force limits which could be correlated to present testing techniques. When compared to the revised acceptance criteria, all snubbers were considered acceptable with sufficient margin.

All eight snubbers were disassembled and the seals and O-rings removed for examination. All O-rings and seals were considered acceptable.

Four of the eight snubbers were then reassembled using replacement O-rings and seals and then filled with new hydraulic fluid. The control valve assembly was replaced with a new design to improve reliability and to increase the lockup velocity to that which was assumed in the current analysis. The remaining four snubbers were disposed of.

The four rebuilt snubbers were then functionally tested, and one was installed on each steam generator and the other two were placed in storage.

WPSC representatives have reviewed and accepted the test results prior to unit startup.

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**DWSauer** 

sam

State of Wisconsin <b>WELDED</b> Department of Industry,	REPAI 🗩	Safety & Buildings Divisic P.O. Box 7969
Labor and Human Relations R E C	ORD	Madison, Wiscosnin 53707 Telephone: (608) 266-1904
Repair completed on:	Wisconsin Reg. No:	· · ·
Power Boiler Heating Boiler	National Board No:	
🗌 Pressure Vessel 🔲 Miniature Boiler	Serial No:	
Manufacturer:	Other No:	Piping System
WORK COMPLETED BY		
Name:	I TH TH	E PLANT OF:
Phillips, Getschow Co.	Owner's Name:	•
Street Address	Location of Repair.	ervice Corp.
431 N. Dearborn St	Kewaunee Nuclear P	wer Plant
City/Town/Village: Zip Code:		
Chicago, IL 60610	Route 1, Box 48	
Repair Hogram No:	Koupunge UT 5/01/	
Description of Repair - attach additional page	if peoded:	)
(use reverse side of this page for sketch)		3/4" check valve
RHR-44 per Work Request 37183. Valve is in	an ASME Soction VI	
	an Abne Section AI,	Class 2 System as
shown on Flow Drawing XK100-18 and Physical	Drawing M-361.	
·		
Hydrostatic Test PSI <u>470 (Inservice-4/9/88)</u>	NDE VT and LPT 100%	
Repair made in accordance with the requireme		of completed valde
Lauor and Human Relations Discovery	nts of the Wisconsin	of completed welds · Department of Industry
and human heracions, wisconsin Adminis	nts of the Wisconsin trative Code Chapters	of completed welds . Department of Industry, 41-42.
The welding was completed by R. Leonowicz, RL,	nts of the Wisconsin trative Code Chapters 393-70-2833	of completed welds Department of Industry, 41-42.
The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41 42	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u>	of completed welds Department of Industry, 41-42. _,who has met the test
The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42.	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u>	of completed welds Department of Industry, 41-42. _,who has met the test
The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: WPS CMP 102 2	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u>	of completed welds Department of Industry, 41-42. ,who has met the test
The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u>	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS	of completed welds Department of Industry, 41-42. ,who has met the test
The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPC_mbbook</u>	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Date	of completed welds Department of Industry, 41-42. ,who has met the test
The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPlankan</u>	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Date	of completed welds Department of Industry, 41-42. ,who has met the test ed: 5-5-88
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPlankan</u> I, the undersigned, have inspected the work of	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Date described in this rep	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u>
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPC-phron</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Date described in this rep has been done in ac	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-83</u> Fort and state that this cordance with the
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u><u>RPCapture</u></u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector per bio	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Bate described in this rep has been done in ac 41-42. By signing th	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPC-phron</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this mapping	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Bate described in this rep has been done in ac 41-42. By signing th ranty, expressed or i	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPC-process</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, resolutions	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Date described in this rep has been done in ac 41-42. By signing th anty, expressed or i heither the inspector	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u><u>RPCapture</u></u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with the	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Date described in this rep has been done in ac 41-42. By signing th ranty, expressed or i neither the inspector and injury or property	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer damage or a loss of any
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>CPlenders</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance	nts of the Wisconsin trative Code Chapters 393-70-2833 393-56-7389 88 TGS bescribed in this rep has been done in ac 41-42. By signing th canty, expressed or i beither the inspector injury or property bection. The only exc	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer damage or a loss of any eption is for such
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u><u>RPlephene</u></u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance company may issue for the object, and then or	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS <u>Bate</u> bescribed in this rep has been done in ac 41-42. By signing th canty, expressed or i neither the inspector in injury or property pection. The only exc the policy which the i	of completed welds Department of Industry, 41-42. ,who has met the test d: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer damage or a loss of any eption is for such nspector's insurance
R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>RPCapture</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance company may issue for the object, and then or Autforized Inspector Signature: Cert. No:	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Base Date described in this rep has been done in ac 41-42. By signing th ranty, expressed or i heither the inspector and injury or property pection. The only exc repolicy which the i by in accordance wit	of completed welds Department of Industry, 41-42. ,who has met the test ed: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer damage or a loss of any eption is for such nspector's insurance h terms of that policy.
R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u>Cleandrace</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance company may issue for the object, and then or Authorized Inspector Signature: Cert. No: Median State	nts of the Wisconsin trative Code Chapters 393-70-2833 393-56-7389 88 TGS Bate described in this rep has been done in ac 41-42. By signing th canty, expressed or i beither the inspector anity or property bection. The only exc the policy which the i ly in accordance wit Employed By:	of completed welds Department of Industry, 41-42. , who has met the test d: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer damage or a loss of any eption is for such nspector's insurance h terms of that policy. Dated:
R. Leonowicz, RL, R. Leonowicz, RL, The welding was completed by <u>A. Michalek, AMM</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS_GMP_102-3</u> Contractor rep. signature: <u><u>RPleyboon</u></u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance company may issue for the object, and then or Authorized Inspector Signature: Cert. No: May Mayum 38	nts of the Wisconsin trative Code Chapters 393-70-2833 <u>393-56-7389</u> 88 TGS Bate bescribed in this rep has been done in ac 41-42. By signing th canty, expressed or i heither the inspector al injury or property bection. The only exc re policy which the i by in accordance wit Employed By: Hartford Steam is	of completed welds Department of Industry, 41-42. , who has met the test d: <u>5-5-88</u> Fort and state that this cordance with the is certificate, neither mplied, concerning the nor his/her employer damage or a loss of any eption is for such nspector's insurance h terms of that policy. Dated: Jar

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State of Wisconsin WELDED Department of Industry, Labor and Human Relations REC	REPAI 🗩 ORD	Safety & Buildings Div P.O. Box 7969 Madison, Wiscosnin 537 Telephone: (608) 266-1
Repair completed on:	Wisconsin Reg. No	:
🗌 Power Boiler 🗌 Heating Boiler	National Board No	
🗌 Pressure Vessel 🗌 Miniature Boiler	Serial No:	•
Manufacturer:	Other No:	
WORK COMPLETED BY:	Thi Th	
Name:	Owner's Name.	HE PLANT OF:
Phillips, Getschow Co.	Wisconsin Public Se	ervice Corp.
Street Address	Location of Repair	
<u>431 N. Dearborn St.</u>	Kewaunee Nuclear Po	wer Plant
City/Town/Village: Zip Code:		
<u>Chicago, IL 60610</u> Repair Program No:	Route 1, Box 48	
	Kewauneo WT 5/016	
Description of Repair - attach additional page	if needed.	
(use reverse side of this page for sketch)	Replaced 3	/4" Rockwell Edwards
<u>Globe Valve SI 37A with a 3/4" Kerotest glo</u>	be valve per WR 3870	4. Valve is in a ASME
· · · · · · · · · · · · · · · · · · ·	······································	
<u>Sto ion XI. Class 2 System.</u>	n	
Hydrostatic Test PSI <u>2245 psig</u> 5/3/88	NDE LPT of all com	pleted welds
Hydrostatic Test PSI <u>2245 psig 5/3/88</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis	NDE LPT of all com nts of the Wisconsin trative Code Chapter	pleted welds Department of Industry s 41-42.
Hydrostatic Test PSI <u>2245 psig 5/3/88</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>C. Schaefer, VGP</u> requirements of Chapters 41-42.	NDE LPT of all com nts of the Wisconsin trative Code Chapter , 393-34-6322	pleted welds Department of Industry s 41-42. _,who has met the test
Hydrostatic Test PSI <u>2245 psig 5/3/88</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>C. Schaefer, VGP</u> requirements of Chapters 41-42. Welding procedure specification: <u>WPS GMP 102-</u>	NDE LPT of all com nts of the Wisconsin trative Code Chapter , 393-34-6322 388 TGS	pleted welds Department of Industry s 41-42. _,who has met the test
Hydrostatic Test PSI <u>2245 psig 5/3/88</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>C. Schaefer, VGP</u> requirements of Chapters 41-42. Welding procedure specification: <u>WPS GMP 102-</u> Contractor rep. signature: <u>Rflaphas</u>	NDE LPT of all com nts of the Wisconsin trative Code Chapter , 393-34-6322 388 TGS	pleted welds Department of Industry s 41-42. _,who has met the test ed: <u>5-12-88</u>
Hydrostatic Test PSI <u>2245 psig 5/3/88</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>C. Schaefer, VGP</u> requirements of Chapters 41-42. Welding procedure specification: WPS GMP 102- Contractor rep. signature: <u>Allophas</u> I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance company may issue for the object, and then or Antherized Inspector Signature: Cert. No: Martine 33	NDE LPT of all com nts of the Wisconsin trative Code Chapter , 393-34-6322 388 TGS Date described in this rep , has been done in ac 41-42. By signing th ranty, expressed or in heither the inspector al injury or property pection. The only exc the policy which the in all in accordance with Employed By: Luther Store A	pleted welds Department of Industry s 41-42. ,who has met the test ed: <u>5-12-88</u> port and state that this cordance with the his certificate, neither implied, concerning the nor his/her employer damage or a loss of an eption is for such inspector's insurance h terms of that policy. Dated:
Hydrostatic Test PSI 2245 psig 5/3/88 Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by C. Schaefer, VGP requirements of Chapters 41-42. Welding procedure specification: WPS GMP 102- Contractor rep. signature: Allowing I, the undersigned, have inspected the work of work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any warr work described in this report. Furthermore, r shall be liable in any manner for any persona kind arising from or connected with this insp liability that may be provided in an insurance company may issue for the object, and then or Atherized Inspector Signature: Cert. No: May Maynin 38 SB 0000 pd 2821	NDE LPT of all com nts of the Wisconsin trative Code Chapter , 393-34-6322 388 TGS Date described in this rep , has been done in ac 41-42. By signing th ranty, expressed or in heither the inspector al injury or property bection. The only exc ce policy which the in hy in accordance with Employed Ey: Hartford Steam Br	pleted welds Department of Industry s 41-42. _,who has met the test ed: $5 \cdot 12 \cdot 83$ bort and state that this cordance with the his certificate, neither implied, concerning the nor his/her employer damage or a loss of an ception is for such inspector's insurance h terms of that policy. Dated: Jun Lin Lin Lin Lin Lin Lin Lin Li

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State of Wisconsin WELDED Department of Industry, Labor and Human Relations REC	O REPAI 🛡 CORD	Safety & Buildings P.O. Box 7969 Madison, Wiscosnin Telephone: (608) 26
Repair completed on:	Wisconsin Reg. No	:
Power Boiler Heating Boiler	National Board No	
🗌 Pressure Vessel 🗌 Miniature Boiler	Serial No:	•
Manufacturer:	Other No:	
WORK COMPLETED BY	Th	
Name:		HE PLANT OF:
Phillips, Getschow Co	Owner's Name:	
Street Address	Wisconsin Public	Service Corp.
431 N Dearborn St	Location of Repair	:
City/Toum/Villago	Kewaunee Nuclear	Power Plant
Clinic village: Zip Code:		
Unicago, IL 60610	Route 1, Box 48	
Neparr Program No:		······································
	<u>Kewaunee</u> , WI 542	16
Description of Repair - attach additional pag	e if needed:	
(use reverse side of this page for sketch)	Replaced	$\frac{3}{441}$ and the set of the s
		STODE VALVE
shown on Flow Drawing XK100-10 and Physical	Drawing M-365.	
shown on Flow Drawing XK100-10 and Physical	Drawing M-365.	
shown on Flow Drawing XK100-10 and Physical	Drawing M-365.	
<u>Shown on Flow Drawing XK100-10 and Physical</u> Hydrostatic Test PSI <u>2335 per SP-087 4/10/38</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>P. Hirst, PGH,</u> requirements of Chapters 41-42.	NDE LPT End Prep, V ents of the Wisconsin strative Code Chapter 395-46-1389	<u>T and LPT completed</u> n Department of Indus rs 41-42. ,who has met the t
<u>Shown on Flow Drawing XK100-10 and Physical</u> Hydrostatic Test PSI <u>2335 per SP-087 4/10/38</u> Repair made in accordance with the requirement Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>P. Hirst, PGH</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS GMP 102-</u>	NDE L <u>PT End Prep, V</u> ents of the Wisconsin strative Code Chapter 395-46-1389	<u>T and LPT completed</u> n Department of Indus rs 41-42. ,who has met the t
Hydrostatic Test PSI <u>2335 per SP-087 4/10/38</u> Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>P. Hirst, PGH,</u> requirements of Chapters 41-42. Welding procedure specification: <u>WPS GMP 102-7</u> Contractor rep. signature: <u>RPR phase</u>	<u>NDE LPT End Prep, V</u> nDE L <u>PT End Prep, V</u> ents of the Wisconsin strative Code Chapter <u>395-46-1389</u> <u>388 TGS</u> Dat	<u>T and LPT completed</u> n Department of Indus rs 41-42. ,who has met the t ed: <u>5-5-88</u>
Hydrostatic Test PSI 2335 per SP-087 4/10/38 Repair made in accordance with the requireme Labor and Human Relations, Wisconsin Adminis The welding was completed by <u>P. Hirst, PGH</u> , requirements of Chapters 41-42. Welding procedure specification: <u>WPS GMP 102-</u> Contractor rep. signature: <u>CPCepheae</u> I, the undersigned, have inspected the work work, to the best of my knowledge and belief requirements of Wis. Adm. Code Chapters ILHR the inspector nor his employer makes any war work described in this report. Furthermore, shall be liable in any manner for any person kind arising from or connected with this ins liability that may be provided in an insuran company may issue for the object, and then of Authorized Inspector Signature: Cert. No:	NDE LPT End Prep, V ents of the Wisconsin strative Code Chapter 395-46-1389 388 TGS Dat described in this re , has been done in a 41-42. By signing t ranty, expressed or neither the inspecto al injury or propert pection. The only ex ce policy which the nly in accordance wi Employed By:	<u>T and LPT completed</u> Department of Indus s 41-42. , who has met the t ed: <u>5-5-88</u> port and state that ccordance with the his certificate, nei implied, concerning r nor his/her employa y damage or a loss of ception is for such inspector's insurance th terms of that pol: 



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Department of Industry,	ED REPAI	Safety & Buildings P.O. Box 7969
Labor and Human Relations R	ECORD	Madison, Wiscosnin Telephone: (608) 2
Repair completed on:	Wisconsin Reg. No:	
🗌 Power Boiler 🗌 Heating Boiler	National Board No:	
🗌 Pressure Vessel 🔲 Miniature Boiler	Serial No:	· · · · · · · · · · · · · · · · · · ·
Manufacturer:	Other No:	Piping System
WORK COMPLETED BY	~	
Name:		IE PLANT OF:
Phillips, Getschow Co	Owner's Name:	
Street Address	Wisconsin Public S	ervice Corp.
431 N. Dearborn St.	Location of Repair:	
City/Town/Village: Zip Code:	Kewaunee Nuclear P	<u>ower Plant</u>
Chicago II 60610		_
Repair Program No:	Route 1, Box 48	
Description of Repair _ attach additional -	<u>Kewaunee, WI 54210</u>	<u>.</u>
(use reverse side of this page for skatch)	Dage 11 needed:	
(add leverse side of this page for sketch)	Modified (	Containment penetra
number 43N for use as a refueling cablewa	av per Work Request 3980	6 and Decise Cha
•		<u>v and besten onang</u>
* NDE included; - LPT of weld preps, VT of	of root pass and complet	ed welds, RT and M
* NDE included; - LPT of weld preps, VT of completed welds	of root pass and complet	ed welds, RT and M
* NDE included; - LPT of weld preps, VT of of completed welds	of root pass and complet	ed welds, RT and M
* NDE included; - LPT of weld preps, VT of completed welds Hydrostatic Test PSI at closing per SP-090	of root pass and complet	ed welds, RT and M
* NDE included; - LPT of weld preps, VT of completed welds Hydrostatic Test PSI at closing per SP-090 Repair made in accordance with the required	NDE * see above	ed welds, RT and M
<ul> <li>* NDE included; - LPT of weld preps, VT of completed welds</li> <li>Hydrostatic Test PSI <u>at closing per SP-090</u> Repair made in accordance with the require Labor and Human Relations, Wisconsin Admin</li> </ul>	NDE <u>* see above</u> ements of the Wisconsin nistrative Code Chapters	ed welds, RT and M Department of Indu s 41-42.
<ul> <li>* NDE included; - LPT of weld preps, VT of completed welds</li> <li>Hydrostatic Test PSI at closing per SP-090 Repair made in accordance with the require Labor and Human Relations, Wisconsin Admin</li> <li>The welding was completed by see back</li> </ul>	NDE <u>* see above</u> ements of the Wisconsin nistrative Code Chapters	ed welds, RT and M Department of Indu s 41-42. ,who has met the
<ul> <li>* NDE included; - LPT of weld preps, VT of completed welds</li> <li>Hydrostatic Test PSI at closing per SP-090 Repair made in accordance with the require Labor and Human Relations, Wisconsin Admin</li> <li>The welding was completed by see back requirements of Chapters 41-42.</li> </ul>	of root pass and complet NDE <u>* see above</u> ements of the Wisconsin nistrative Code Chapters	ed welds, RT and M Department of Indu s 41-42. _,who has met the
<ul> <li>* NDE included; - LPT of weld preps, VT of completed welds</li> <li>Hydrostatic Test PSI at closing per SP-090 Repair made in accordance with the require Labor and Human Relations, Wisconsin Admin The welding was completed by see back requirements of Chapters 41-42.</li> <li>Welding procedure specification</li> </ul>	NDE <u>* see above</u> ements of the Wisconsin nistrative Code Chapters	ed welds, RT and M Department of Indu s 41-42. ,who has met the
<ul> <li>* NDE included; - LPT of weld preps, VT of completed welds</li> <li>Hydrostatic Test PSI at closing per SP-090 Repair made in accordance with the require Labor and Human Relations, Wisconsin Admin The welding was completed by see back requirements of Chapters 41-42.</li> <li>Welding procedure specification: WPS GMP 10</li> </ul>	NDE <u>* see above</u> ements of the Wisconsin nistrative Code Chapters	ed welds, RT and M Department of Indu s 41-42. _,who has met the
<ul> <li>* NDE included; - LPT of weld preps, VT of completed welds</li> <li>Hydrostatic Test PSI at closing per SP-090 Repair made in accordance with the required Labor and Human Relations, Wisconsin Admin The welding was completed by see back requirements of Chapters 41-42.</li> <li>Welding procedure specification: WPS GMP 10 Contractor rep. signature 2000 1</li> </ul>	NDE <u>* see above</u> ements of the Wisconsin nistrative Code Chapters	ed welds, RT and M Department of Indu 41-42. _,who has met the
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Welders -

R. Leonowicz, RL, 393-70-2833
A. Michalek, AMM, 393-56-7389
J. Barzeau, JRB, 391-46-4218
P. Hirst, PGH, 3°5-46-1389



Human Relations       R E C O R D       Maidson, Missing Telephone: (mailson, Missing Telephone: (mailson, Missing Telephone: (mailson, Missing Telephone: (mailson), Missing Telephone, Missing Telephone: (mailson), Missing Tele	State of Wisconsin WE Department of Industry,	LDED REPAI Safety & Buildin
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redure specification: WPS GMP 102-388TGS rep. signature: <u>Cleandres</u> Dated: <u>5-5-88</u> ersigned, have inspected the work described in this report and state he best of my knowledge and belief, has been done in accordance with ts of Wis. Adm. Code Chapters ILHR 41-42. By signing this certificat tor nor his employer makes any warranty, expressed or implied, conce ibed in this report. Furthermore, neither the inspector nor his/her iable in any manner for any personal injury or property damage or a ng from or connected with this inspection. The only exception is for that may be provided in an insurance policy which the inspector's in y issue for the object, and then only in accordance with terms of th d Inspector Signature: Cert. No: Employed By: Jumn 25	ydrostatic Test PSI <u>2335 per SP-037</u> Repair made in accordance with the pe	LPT weld preps, VT, root pass, 4/10/88 NDE of completed weld.
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	ostatic Test PSI <u>2335 per SP-037</u> pair made in accordance with the re- bor and Human Relations, Wisconsin A. Pagel, welding was completed by <u>P. Hirst</u> , irements of Chapters 41-42. ing procedure specification: <u>WPS GM</u> ractor rep. signature: <u>CCC</u> the undersigned, have inspected th rk, to the best of my knowledge and quirements of Wis. Adm. Code Chapters inspector nor his employer makes k described in this report. Further all be liable in any manner for any d arising from or connected with the bility that may be provided in an ipany may issue for the object, and thorized Inspector Signature: Cert	LPT weld LPT weld 4/10/88 NDE of comple equirements of the Wisc Administrative Code CF RP, 393-32-2502 PGH, 395-46-1389 4P 102-388TGS Administrative Code CF RP, 395-46-1389 Administrative Code CF RP, 395-46-1389 Administ

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Repair completed on:       Wisconsin Reg. No:            Power Boiler        Pressure Vessel Miniature Boiler             Pressure Vessel Miniature Boiler        National Board No:            Manufacturer:        Other No:             Mane:        Other No:             Name:        Ditter Month Stress             Name:        Ditter Stress             Name:        Ditter Stress             Street Address        Location of Repair: Month Stress             Chicago, LL 60010        Reveaumee, WI 54216             Description of Repair - attach additional page if Greeded:        Replaced 3/4" globe valve PR 50A             (use reverse side of this page for oketch)        Replaced 3/4" globe valve PR 50A             per MR 37078, vlave is an ASME Section XI. Class I system as shown on Flow Drawing         XK100-10 and Physical Drawing M365.             Wisconsin Addinistrative Code Chapters 41-42.             Per WR 30078, vlave is an ASME Section XI. Class I system as shown on Flow Drawing             Wisconsin Addinistrative Code Chapters 41-42.             Perulirements of Kash             Wisconsin Addininstrative Code Chapters 41-42.	State of Wisconsin Department of Industr Labor and Human Rela	WELDE Ty, ations RE	D REPAI	Safety & Buildings Divis P.O. Box 7969 Madison, Wiscosnin 53707 Telephone: (608) 266-190
Power Boiler       Heating Boiler         Pressure Vessel       Miniature Boiler         Serial No:       Serial No:         Manufacturer:       Other No:         WORK COMPLETED N:       Other No:         Name:       Owner's Name:         Phillips, Cetschow Co.       Wisconsin Public Service Corp.         Street Address       Location of Repair:         431 N. Dearborn St.       Kewaunee Nuclear Power Plant         Chicago, IL 60610       Route 1, Box 48         Repair Program No:       Kewaunee, WI 54216         Description of Repair - attach additional page if needed:       Replaced 3/4" globe valve PR 50A         (use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASNE Section XI, Class I system as shown on Flow Draving         XX100-10 and Physical Drawing M365.         "-PT existing wed preps and final completed wolds, RT to verify gap and Visual of all         completed walds.         Per welding was completed by A. Michalek, AMM, 393-56-7389         who has met the test         requirements of Kin Adv. Code Chapters 41-42.         Yelding procedure specification: MPS GMP 102-388TGS         Contractor rep. signature:       Cetters any varranty, expressed or inplied, concersing the work described in this report and state that	Repair completed on:		Wisconsin Reg. No:	·
Pressure Vessel       Miniature Boiler       Serial No:         Manufacturer:       Other No:         Mame:       Owner's Name:         WORK COMPLETED BY:       IN THE PLANT OF:         Name:       Owner's Name:         Phillips, Getschow Co.       Wisconsin Public Service Corp.         Street Address       Location of Repair:         Kevaumes Nuclear Power Plant       Kevaumes Nuclear Power Plant         Chicago, IL 60610       Route 1, Box 48         Repair Program Ro:       Kewaumes, WI 54216         Description of Repair - attach additional page if needed:       In the second of the page for sketch)         Pet NR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Draving XK100-10 and Physical Drawing M365.         *LFT existing end preps and final completed welds, RT to verify gap and Visual of all completed welds.         Repair made in accordance with the requirements of the Misconsin Department of Industry, Labor and Human Relling, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PGR, 395-46-1389         Heyding was completed by A. Michalek, AMM, 393-56-7389         requirements of Chapters 41-42.         P. Hirst, PGR, 395-46-1389         I, the undersigned, nave inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Kin Am. Coce Chapters 41-42.	🗌 Power Boiler	Heating Boiler	National Board No:	
Manufacturer:       Other No:         WORK COMPLETED EV:       IN THE PLANT OF:         Name:       Wisconsin Public Service Corp.         Street Adgress       Location of Repair:         431 N. Dearborn St.       Location of Repair:         Chicago, IL 00610       Zip Code:         Repair Program No:       Kewaunee, WI 54216         Description of Repair - attach additional page if needed:       Replaced 3/4" globe valve FR 50A         ger WR 37078, vlave is an ASME Section XI, Class I system as shown on Flow Drawing       XK100-10 and Physical Drawing M365.         *LPT existing end preps and final completed welds, RT to verify gap and Visual of all       completed welds.         completed welds.       P. Hirst, PCH, 395-46-1389       , who has met the test         requirements of Chapters H1-32.       P. Hirst, PCH, 395-46-1389       , who has met the test         work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis employen makes any warranty, expressed or implied, concerning the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of iso property damage or aloss of an liability that may be provided in an insurance policy which the inspector nor his employen makes any warranty, expressed or implied, concerning the work described in this report and state that this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector is for such liability	Pressure Vessel	Miniature Boiler	Serial No:	
WORK COMPLETED BY:         IN THE PLANT OF:           Name:         Owner's Name:           Phillips, Getschow Co.         Misconsin Public Service Corp.           Street Address         Location of Repair:           411 N. Dearborn St.         Location of Repair:           Chicago, IL 60610         Repair Program No:           Repair Program No:         Route 1, Box 48           Kewaunee, WI 54216         Repair - attach additional page if needed:           (use reverse side of this page for sketch)         Replaced 3/4" globe valve PR 50A           per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Drawing         XK100-10 and Physical Drawing M365.	Manufacturer:		_ Other No:	
Name:       Owner's Name:       Dut out of the pair:         Phillips, Getschow Co.       Wisconsin Public Service Corp.         Street Address       Location of Repair:         431 N. Dearborn St.       Kewaunee Nuclear Power Plant         Chizgo, IL 60610       Route 1, Box 48         Repair Program No:       Replaced 3/4" globe valve PR 50A         Description of Repair - attach additional page if needed:       Replaced 3/4" globe valve PR 50A         (use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Draving         XK100-10 and Physical Drawing M365.         *         *         PT existing end preps and final completed welds, RT to verify gap and Visual of all         completed welds.         *         PT existing end preps and final completed welds, RT to verify gap and Visual of all         completed welds.         *         PT existing end preps and final completed welds, RT to verify gap and Visual of all         completed welds.         *         PT existing end preps and final completed welds, RT to verify gap and Visual of all         completed welds.         *         PT existing end preps and final completed welds, RT to verify gap and Visual of all	WORK CC	MPIETED BY	m	
Phillips, Getschow Co.       Under's Name:         Street Address       Location of Repair:         All N. Dearborn St.       Eventorial Street Address         City/Town/Village:       Zip Code:         Chicago, IL 60610       Route 1, Box 48         Repair Program No:       Kewaunee Nuclear Power Plant         Description of Repair - attach additional page if needed:       Replaced 3/4" globe valve PR 50A         (use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per NR 37078, vlave is an ASNE Section XI, Class 1 system as shown on Flow Drawing       XK100-10 and Physical Drawing M365.	Name ·			IE PLANT OF:
Street Address       Location of Repair: Number of the offer o	Phillips, Getschow C	0.	Wisconsin Public S	ervice Corp
431 N. Dearborn St.       Construction of Repair:         City/Town/Village:       Zip Code:         Chicago, IL 60610       Route 1, Box 48         Repair Program No:       Revalue Nuclear Power Plant         Cuse reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Drawing         XK100-10 and Physical Drawing M365.         **LPT existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **LPT existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **LPT existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **Left existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **Left existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **Left existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **Left existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.         **Left existing end preps and final completed welds, RT to verify gap and Visual of all         Completed welds.	Street Address	-	Location of Density	ervice corp.
City/Town/Willage:       Zip Code:       Route 1, Box 48         Repair Program No:       Revalue, WI 54216         Description of Repair - attach additional page if needed:       Replaced 3/4" globe valve PR 50A         (use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Draving         XK100-10 and Physical Drawing M365.         *         Completed welds.         Bydrostatic Test PSI 2335 per SP-087         NDE *See above         Repair made in accordance with the requirements of the Misconsin Department of Industry, Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hist, PCH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389	431 N. Dearborn St.		Kewaunee Nuclear P	ower Plant
Chicago, IL 60610       Repair Program No:       Route 1, Box 48         Repair Program No:       Revaunce, WI 54216         Description of Repair - attach additional page if needed:       (use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Drawing       XX100-10 and Physical Drawing M365.         **LPT existing end preps and final completed welds, RT to verify gap and Visual of all         completed welds.         Hydrostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Misconsin Department of Industry         Labor and Human Relations, Misconsin Administrative Code Chapters 41-82.         P. Hirst, PCH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         requirements of Chapters 41-82.         Velding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       Refigure makes any varranty, expressed or implied, concerning the work described in this report, Furthermore, neither the inspector nor his employer makes any varranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her enployer shall be in any manner for any personal injury or property damage or a loss of an liability that may be provided in an insurance policy which the inspector's insurance with lability that may be provided in an insurance policy which the inspector's insurance yend with thermos of that policy.	City/Town/Village:	Zip Code·	- Active Muchar P	
Repair Program No:       Kewaunee, WI 54216         Description of Repair - attach additional page if needed:       (use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Drawing       XK100-10 and Physical Drawing M365.         **LPT existing end preps and final completed welds, RT to verify gap and Visual of all completed welds.         Wugnostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Wisconsin Department of Industry Labor and Suman Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PCH, 395-66-1389       ,who has met the test requirements of Chapters 41-42.         P. Hirst, PCH, 395-66-7389       ,who has met the test state that this report and state that this vork, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters LHR 41-42. By signing this certificate, neither work described in this report. Purthermore, neither the inspector nor his/her enployer shall be liable in any manner for any personal injury or property damage or a loss of an kind arising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the opject, and then only in accordance with terms of that policy.         Wugnor Tree Stignature: Cert. No:       Employed By:         Wagnor Tree Stignature: Stignature: Cert. No:       Employed By:	Chicago, IL 60610	21p 0000.	Route 1, Box 48	
Kewaunee, WI 54216         Description of Repair - attach additional page if needed:         (use reverse side of this page for sketch)	Repair Program No:			
Description of Repair - attach additional page if needed: (use reverse side of this page for sketch) <u>Replaced 3/4" globe valve PR 50A</u> per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Drawing XK100-10 and Physical Drawing M365. *LPT existing end preps and final completed welds, RT to verify gap and Visual of all completed welds. Hydrostatic Test PSI 2335 per SP-087 NDE *See above Repair made in accordance with the requirements of the Wisconsin Department of Industry Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42. P. Hirst, PCH, 395-46-1389 requirements of Chapters 41-42. Welding vas completed by A. Michalek, AMM, 393-56-7389 ,who has met the test requirements of Chapters 41-42. Welding procedure specification: WPS CMP 102-388TGS Contractor rep. signature: <u>Refugites</u> Dated: <u>5.11-88</u> I, the undersigned, have inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the the inspector nor his employer makes any varranty, expressed or implied, concerning the work described in this report. Purthermore, neither the inspector nor his/her employer what darising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with therms of that policy. Authorized Inspector Signature: Cert. No:			Kewaunee, WI 54216	
(use reverse side of this page for sketch)       Replaced 3/4" globe valve PR 50A         per WR 37078, vlave is an ASME Section XI, Class 1 system as shown on Flow Drawing         XK100-10 and Physical Drawing M365.         **LPT existing end preps and final completed welds, RT to verify gap and Visual of all         completed welds.         Hydrostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Wisconsin Department of Industry         Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PCH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         velding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       Refigure and belief, has been done in accordance with the requirements of NS. Adm. Code Chapters ILHR 41-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his semployer makes any warranty, expressed or implied, concerning the work described in any maner for any personal injury or property damage or a loss of an liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy.         Authorized Inspector Signature: Cert. No:       Employed By:	Description of Repair	· - attach additional pa	ge if needed:	
completed welds.         Hydrostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Wisconsin Department of Industry         Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PGH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         Prequirements of Chapters 41-42.         Velding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       Reparks         Dated:       5.11-88         I, the undersigned, have inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters TLHR 41-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of an liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy. Authorized Inspector Signature: Cert. No: Employed By:         Mather Markunn       38	ARIOU-IU and Physic	cal Drawing M365.		
Hydrostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Wisconsin Department of Industry         Labor and Human Relations, Wisconsin Administrative Code Chapters #1-42.         P. Hirst, PGH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         requirements of Chapters #1-42.         Welding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       RMights         Dated:       5.11-88         I, the undersigned, have inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters ILHR #1-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of an kind arising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy.         Authorized Inspector Signature:       Cert. No:         Employed By:       Dated:         Authorized Inspector Signature:       Cert. No:         Employed By:       Dated:	*LPT existing end pre	eps and final completed	welds. RT to verify a	an and Visual of all
Hydrostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Wisconsin Department of Industry         Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PGH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         requirements of Chapters 41-42.         Welding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       Regimes         Dated:       5-11-88         I, the undersigned, have inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters ILHR 41-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of an kind arising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy.         Autorized Inspector Signature:       Cert. No:         Employed By:       Dated:         Autorized Inspector Signature: Cert. No:       Employed By:         Dated:       5-49-48	*LPT existing end pre completed welds.	eps and final completed	welds, RT to verify g	ap and Visual of all
Hydrostatic Test PSI 2335 per SP-087       NDE *See above         Repair made in accordance with the requirements of the Wisconsin Department of Industry         Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PGH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         requirements of Chapters 41-42.         Welding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       Repaire         More the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters ILHR 41-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of an kind arising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy.         Authorized Inspector Signature: Cert. No:       Employed By:         Market       Dated:         5-49-3%       State	*LPT existing end pro	eps and final completed	welds, RT to verify g	ap and Visual of all
Repair made in accordance with the requirements of the Wisconsin Department of Industry Labor and Human Relations, Wisconsin Administrative Code Chapters 41-42.         P. Hirst, PCH, 395-46-1389         The welding was completed by A. Michalek, AMM, 393-56-7389         requirements of Chapters 41-42.         Welding procedure specification: WPS GMP 102-388TGS         Contractor rep. signature:       Refigure         Dated:       5.11-88         I, the undersigned, have inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters ILHR 41-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of an kind arising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy. Authorized Inspector Signature: Cert. No:       Employed By:       Dated:         Muthorized Inspector Signature:       Cert. No:       Employed By:       Dated:	*LPT existing end pro	eps and final completed	welds, RT to verify g	ap and Visual of all
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Contractor rep. signature: RPGippins Dated: 5-11-88 I, the undersigned, have inspected the work described in this report and state that this work, to the best of my knowledge and belief, has been done in accordance with the requirements of Wis. Adm. Code Chapters ILHR 41-42. By signing this certificate, neither the inspector nor his employer makes any warranty, expressed or implied, concerning the work described in this report. Furthermore, neither the inspector nor his/her employer shall be liable in any manner for any personal injury or property damage or a loss of an kind arising from or connected with this inspection. The only exception is for such liability that may be provided in an insurance policy which the inspector's insurance company may issue for the object, and then only in accordance with terms of that policy. Authorized Inspector Signature: Cert. No: Employed By: May Mayum 38 Mathality that may be	*LPT existing end pro completed welds. Hydrostatic Test PSI Repair made in acco Labor and Human Rela The welding was compl requirements of Chapt	2335 per SP-087 rdance with the require ations, Wisconsin Admin P. Hirst, PGH, eted by <u>A. Michalek, Al</u> ers 41-42.	welds, RT to verify g NDE <u>*See above</u> ments of the Wisconsin istrative Code Chapter 395-46-1389 MM, 393-56-7389	ap and Visual of all Department of Industry, s 41-42. _,who has met the test
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1D 100(D 01(00)	*LPT existing end pro- completed welds. Hydrostatic Test PSI Repair made in acco Labor and Human Rel. The welding was comple- requirements of Chapt Welding procedure spect Contractor rep. signal I, the undersigned, work, to the best of requirements of Wis the inspector nor have work described in the shall be liable in a kind arising from or liability that may the company may issue for Authorized Inspector	2335 per SP-087 rdance with the require ations, Wisconsin Admin P. Hirst, PGH, eted by A. Michalek, Al ers 41-42. cification: WPS GMP 102- ture: <u>Reciphus</u> have inspected the world f my knowledge and belie Adm. Code Chapters IL is employer makes any wants report. Furthermore any manner for any person connected with this in the object, and then or Signature: Cert. Not	<pre>welds, RT to verify g NDE *See above ments of the Wisconsin istrative Code Chapter 395-46-1389 MM, 393-56-7389 -388TGS</pre>	ap and Visual of all Department of Industry, s 41-42. , who has met the test ed: <u>5.11-88</u> port and state that this cordance with the his certificate, neither implied, concerning the nor his/her employer y damage or a loss of any ception is for such inspector's insurance th terms of that policy. Dated:

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