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SUBJECT: Application for amend to license DPR-43, allowing laser welded repair of Westinghouse hybrid expansion joint sleeved SG tubes.

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WISCONSIN PUBLIC SERVICE CORPORATION

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

January 23, 1997

10 CFR 50.90

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

Ladies/Gentlemen:

Docket 50-305
Operating License DPR-43
Kewaunee Nuclear Power Plant
Proposed Amendment 144a to the Kewaunee Nuclear Power Plant Technical Specifications:
Laser Welded Repair of Westinghouse HEJ Sleeved Steam Generator Tubes

Reference: Letter from Clark R. Steinhardt (WPSC) to U.S. Nuclear Regulatory Commission (NRC) dated September 6, 1996.

By letter dated September 6, 1996, Wisconsin Public Service Corporation (WPSC) submitted a Technical Specification (TS) amendment request to allow laser welded repair (LWR) of Westinghouse hybrid expansion joint (HEJ) sleeved steam generator (SG) tubes. WPSC discussed this proposed TS amendment request and the status of the LWR efforts with the NRC staff in meetings on October 10, 1996, December 17, 1996, and January 14, 1997. As discussed at the December 17 meeting, LWR efforts were put on hold by WPSC until the issues of weld quality improvements and resolution of the eddy current test results were adequately addressed. A plan for Westinghouse and WPSC to address these two issues was presented to the NRC staff at that same meeting.

The results of the weld quality improvement program and the proposed eddy current inspection technique were presented to the NRC staff on January 14, 1997. In summary, significant resources were expended by both Westinghouse and WPSC to resolve these two issues with close to 350 weld samples being prepared to support the program. As a result of this effort, weld process changes were made and a new welding specification was qualified in accordance with the requirements of the ASME Code for performing welded repairs in HEJ sleeved tubes. One of the changes to the welding process was to move the proposed weld location from the approximate mid-point of the upper hardroll expansion, to the upper hydraulic expansion region. Moving the proposed weld location requires revising WCAP-14685 which is currently being reviewed by the NRC staff in support of the proposed TS amendment.

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The primary WCAP change is to discuss the acceptability of placing the weld within either the upper hardroll or upper hydraulic expansion region with the allowance for an inboard repair weld. Changes are also being made to update the list of chemical contaminants found in the crevice region between the sleeve and the tube, to add an optional pre-heat step used to dry out the sleeve/tube interface prior to welding, and to reduce the required minimum distance between the weld and parent tube indication from 0.38 inch, to 0.125 inch. As discussed in the WCAP, the results of the corrosion tests for a LWR in the hardroll remain valid and may be conservative for a LWR in the hydraulic expansion. However, additional corrosion testing will be performed using the latest crevice contaminants with the weld location in the upper hydraulic expansion. This additional corrosion testing is expected to be completed by August 1997.

Proposed TS amendment number 144 and the associated basis section are being changed to reflect the WCAP revision. The revised TS and basis pages are contained in Attachment 1. The entire TS Section 4.2 and Basis have been included because of the number of recent amendments affecting this section. Attachment 2 contains WCAP-14685, Revision 1, "Laser Welded Repair of Hybrid Expansion Joint Sleeves for Kewaunee Nuclear Power Plant," (Proprietary) and WCAP-14686, Revision 1, "Laser Welded Repair of Hybrid Expansion Joint Sleeves for Kewaunee Nuclear Power Plant," (Non-Proprietary), both dated January 1997. Also included are the Westinghouse authorization letter, accompanying affidavit, Proprietary Information Notice, and Copyright Notice. This change to the proposed TS amendment request does not alter the information and conclusions of the significant hazards determination or environmental considerations as discussed in the previous submittal.

With regard to the eddy current inspection technique, we will be using the +point to inspect the welds to verify weld integrity and collect baseline exam information. Westinghouse is currently completing the Appendix H qualification package for the +point probe. This information will be available for NRC staff review when finalized.

WPSC appreciates the high priority that the NRC staff has placed on reviewing this proposed TS amendment request and is willing to meet with the staff to discuss the information provided in this submittal. Please contact a member of my staff if you have any questions or require additional information.

Sincerely,



M. L. Marchi
Manager-Nuclear Business Group

SLB/jmf
Attach.

cc - US NRC - Region III
US NRC Senior Resident Inspector
Mr. Lanny Smith, PSCW (w/o Attach. 2)

ATTACHMENT 2

Letter from M. L. Marchi (WPSC)

To

Document Control Desk (NRC)

Dated

January 23, 1997

Proposed Amendment 144a

WCAP-14685, Revision 1
WCAP-14686, Revision 1