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 MARCHI, M.L. Wisconsin Public Service Corp. *See Report.*
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SUBJECT: Application for amend to license DPR-43, revising plugging
 limit for W mechanical HEJ sleeve & for laser welded sleeve.
 Proprietary TRs WCAP-13088 & WCAP-14685 & non-proprietary
 TRs WCAP-14686 & WCAP-13089, encl. Proprietary info withheld.

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(a subsidiary of WPS Resources Corporation)
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1-920-433-5544 fax

October 27, 1998

10 CFR 50.90

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

Ladies/Gentlemen:

Docket 50-305
Operating License DPR-43
Kewaunee Nuclear Power Plant
Proposed Amendment 158 to the Kewaunee Nuclear Power Plant Technical Specifications:
Changes to the Plugging Limit for Westinghouse Mechanical Hybrid Expansion Joint Sleeves and Laser Welded Sleeves

- References:
- 1) Letter from R.J. Laufer (NRC) to M.L. Marchi (WPSC) dated June 7, 1997.
 - 2) Letter from R.J. Laufer (NRC) to M.L. Marchi (WPSC) dated September 24, 1996.

Wisconsin Public Service Corporation (WPSC) is submitting this Technical Specification (TS) amendment request to revise the plugging limit for the Westinghouse mechanical hybrid expansion joint (HEJ) sleeve and for the Westinghouse laser welded sleeve (LWS). The plugging limit will change from 24 percent to 23 percent sleeve wall degradation for the HEJ sleeve and from 25 percent to 23 percent sleeve wall degradation for the LWS.

This request is being made to resolve two issues related to HEJs and LWSs. During a review, WPSC identified that the plugging limit calculations for HEJs and LWSs were inconsistent with the design operating primary-to-secondary differential pressure. Note that the plugging limits for HEJs are based upon the more restrictive limit assuming a laser weld repair (LWR) of the HEJ. To resolve this concern, the plugging limits have been recalculated to bound the design primary-to-secondary differential pressure of 1600 psi. Additionally, Westinghouse informed WPSC that for LWS and LWR of HEJs the finite element model used to initially qualify the 0.015 inch laser weld width acceptance criteria had under predicted the shear stress in the welds. A verification program using experimental analysis was performed by Westinghouse to show the 0.015 inch weld remains in compliance with ASME Boiler and Pressure Vessel Code requirements. This information on weld width is also being transmitted with this request.

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Although WPSC had completed an assessment of the primary-to-secondary differential pressure issue several months ago, this request was delayed awaiting Westinghouse resolution of the weld width issue to provide this more complete amendment request. As discussed in Attachment 1, this delay had no safety significance.

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This proposed TS amendment affects TS section 4.2.b, "Steam Generator Tubes." Attachment 1 contains background information, a description of the proposed TS changes, a safety evaluation, significant hazards determination, and environmental considerations. Attachment 2 and 3 contain the affected TS pages. A proprietary and non-proprietary version of WCAP-14685, Revision 4, "Laser Welded Repair of Hybrid Expansion Joint Sleeves for Kewaunee Nuclear Power Plant," with the accompanying affidavit statement are included as Attachment 4. A proprietary and non-proprietary version of WCAP-13088, Revision 4, Addendum 1, "Westinghouse Series 44 and 51 Steam Generators Generic Sleeving Report, Laser Welded Sleeves," with the accompanying affidavit statement are included as Attachment 5.

Since WPSC does not intend to implement either the LWR or the LWS during the current refueling outage which began October 18, 1998, this is not considered a high priority for review. However, the LWR information does correct a design inaccuracy. Further, WPSC will keep the Nuclear Regulatory Commission Kewaunee Project Manager apprised of any changes in the need for this amendment. The LWS repair is considered a contingency repair and although it is not expected to be used, KNPP may have to ask for expedited review if conditions appear likely that LWS will be necessary.

In accordance with the requirements of 10 CFR 50.36(b), this submittal has been signed and notarized. A copy of this submittal has been transmitted to the State of Wisconsin as required by 10 CFR 50.91(b)(1). Please contact a member of my staff if we can be of any assistance regarding the review of this amendment request.

Sincerely,



for

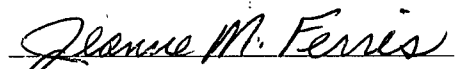
Mark L. Marchi
Site Vice President-Kewaunee Plant

DLR/jmf

Attach.

cc - US NRC - Region III
Senior Resident Inspector, US NRC
Electric Division, PSCW

Subscribed and Sworn to
Before Me This 27th Day
of October 1998


Notary Public, State of Wisconsin

My Commission Expires:
June 13, 1999