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SUBJECT: Provides addl info re eddy current insp to be performed to ensure acceptable sleeve & re-sleeve installation. Info provided to support review of proposed amend 146 re repair of SG tubes w/Combustion Engineering leak tight sleeves.

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May 15, 1997

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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 146 to the Kewaunee Nuclear Power Plant Technical Specifications:
Repair of SG Tubes with Combustion Engineering Welded Sleeves

Reference: Letter from C.R. Steinhardt (WPSC) to U.S. Nuclear Regulatory Commission dated April 24, 1997.

By letter dated April 27, 1997, Wisconsin Public Service Corporation (WPSC) submitted a proposed Technical Specification (TS) amendment request to allow repair of steam generator (SG) tubes with Combustion Engineering (CE) leak tight sleeves. The sleeves and re-sleeves are to be installed and inspected in accordance with the CE generic topical report CEN-629-P, Revision 2, "Repair of Westinghouse Series 44 and 51 Steam Generators Using Leak Tight Sleeves," and Kewaunee Nuclear Power Plant specific topical report CEN-632-P, "Repair of Kewaunee Steam Generator Tubes Using a Re-sleeving Technique." The proposed repair processes were discussed with the NRC staff in meetings on March 24, and April 21, 1997.

The purpose of this letter is to provide additional information regarding the eddy current (ECT) inspection that will be performed to ensure acceptable sleeve and re-sleeve installation. It is WPSC intent to use the +point probe to perform a post-installation ECT inspection of the CE welded sleeves. The eddy current data will be acquired using a probe pull speed of up to 0.45 inch/second axial travel. The data collected at 0.45 inch/second will be reviewed to determine if there are any indications in the new pressure boundary. If indications are found in the sleeve-to-tube weld, the weld area will be re-examined using a probe pull speed of no greater than 0.1 inch/second axial travel. The data collected from the second exam, i.e., at

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0.1 inch/second, will be used to determine location of any weld zone indications with respect to the center line of the weld. The use of the faster probe pull speed of up to 0.45 inch/second for detection has been shown by a series of tests performed by ABB CE to have comparable detection sensitivity and data quality as the ECT data acquired at slower probe pull speeds. The testing also showed that at a probe pull speed of up to 0.45 inch/second, the data density of 40 samples per inch used for the Appendix H qualification of the inspection technique continues to be satisfied.

WPSC appreciates the NRC staffs efforts to review this proposed TS amendment on a high priority basis. If you have any questions or require additional information please contact a member of my staff.

Sincerely,



M. L. Marchi
Manager-Nuclear Business Group

SLB/jmf

cc - US NRC - Region III
US NRC Senior Resident Inspector