

DUANE ARNOLD ENERGY CENTER

DOCKET NO. 50-331

WELD SUMMARY

MAY 24, 1985

REGULATORY DOCKET FILE COPY

8505300348 850524
PDR ADDCK 05000331
Q PDR

DUANE ARNOLD ENERGY CENTER
INDICATIONS IN PIPING SUSCEPTIBLE TO IGSCC

| Weld No. | Pipe Size (in.) | Identified During | Orientation | Length (in.) | Calculated Through-Wall Depth (%) |
|-----------|-----------------|-----------------------------|--------------------------|----------------------|-----------------------------------|
| RRA-J4 | 10 | Visual Leakage Post-IHSI | Axial | -- | 100%* |
| RRA-J4A | 10 | Post-IHSI UT | Circum | 9" | 30% |
| RRB-J4A | 10 | Post-IHSI UT | Circum | 3-1/4" | 25% |
| RRD-J4A | 10 | Pre-IHSI UT | Circum | 6-1/2" | 40% |
| **RRD-J4 | 10 | Pre-IHSI UT | Axial Axial Circum | 7/8" 7/8" 1/4" | 60% 60% 15% |
| RRD-J7 | 10 | Pre-IHSI UT | Axial Lamination | 1/2" -- | 25% -- |
| RRE-J4A | 10 | Post-IHSI UT | Circum | 3-3/8" | 60% |
| RRF-J4A | 10 | Post-IHSI UT | Circum | 2" | 85% |
| RRG-J4A | 10 | Post-IHSI UT | Circum | 8" | 75% |
| RRH-J4A | 10 | Post-IHSI UT | Circum | 2-1/8" | 70% |
| ***RHB-J1 | 18 | Visual Leakage Post-IHSI | Presumed Axial | -- | 100%* |

*100% based on visual leakage.

**Three indications all in close proximity.

***Note: Ultrasonic Testing is restricted by physical constraints.

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WELD OVERLAY DESIGN

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WELD OVERLAY DESIGN
FOR RRD-J7