

AEC DISTRIBUTION FOR PART 50 DOCKET MATERIAL
(TEMPORARY FORM)

CONTROL NO: 9313

FILE:

FROM: Northern States Power Co Minneapolis, Minn 55401 L O Mayer		DATE OF DOC 9-6-74	DATE REC'D 9-10-74	LTR XX	TWX	RPT	OTHER
TO: Mr. O'Leary		ORIG 1 signed	CC	OTHER	SENT AEC PDR XXXX SENT LOCAL PDR XXX		
CLASS.	UNCLASS XXXXXX	PROP INFO	INPUT	NO CYS REC'D 1	DOCKET NO: 50-263		

DESCRIPTION:

Ltr re Abnormal Occurrence submitted on 5-31-74 re additional information concerning cracked studs on recirculation pumps.

ENCLOSURES:

ACKNOWLEDGED

DO NOT REMOVE

PLANT NAME: Monticello

FOR ACTION/INFORMATION

9-10-74

ehf

BUTLER (L)	SCHWENCER (L)	✓ZIEMANN (L)	REGAN (E)
W/ CYS	W/ CYS	W/ 4 CYS	W/ CYS
CLARK (L)	STOLZ (L)	DICKER (E)	LEAR
W/ CYS	W/ CYS	W/ CYS	W/ CYS
FAER (L)	VASSALLO (L)	KNIGHTON (E)	
W/ CYS	W/ CYS	W/ CYS	W/ CYS
KNIEL (L)	PURPLE (L)	YOUNGBLOOD (E)	
W/ CYS	W/ CYS	W/ CYS	W/ CYS

INTERNAL DISTRIBUTION

✓ REG FILE	TECH REVIEW	DENTON	✓ LIC ASST	A/T IND
✓ AEC PDR		GRIMES	✓ DIGGS (L)	BRAITMAN
✓ OGC	✓ SCHROEDER	GAMMILL	GEARIN (L)	SALTZMAN
✓ MUNTZING/STAFF	✓ MACCARY	KASTNER	GOULBOURNE (L)	B. HURT
✓ CASE	✓ KNIGHT	BALLARD	KREUTZER (E)	
GIAMBUSSO	✓ PAWLICKI	SPANGLER	LEE (L)	PLANS
BOYD	✓ SHAO		MAIGRET (L)	MCDONALD
MOORE (L)(LWR-2)	✓ STELLO	ENVIRO	REED (E)	CHAPMAN
DEYOUNG (L)(LWR-1)	✓ HOUSTON	MULLER	SERVICE (L)	DUBE w/input
SKOVHOLT (L)	✓ NOVAK	DICKER	SHEPPARD (L)	E. COUPE
GOLLER (L)	✓ ROSS	KNIGHTON	SLATER (E)	
P. COLLINS	✓ IPPOLITO	YOUNGBLOOD	SMITH (L)	✓ D. THOMPSON (2)
DENISE	✓ TEDESCO	REGAN	TEETS (L)	✓ KLECKER
✓ REG OPR	✓ LONG	PROJECT MGR	WILLIAMS (E)	✓ EISENHUT
✓ FILE & REGION (2)	✓ LAINAS		WILSON (L)	
✓ MORRIS	✓ BENAROYA	HARLESS		
✓ STEELE	✓ VOLLMER			

EXTERNAL DISTRIBUTION

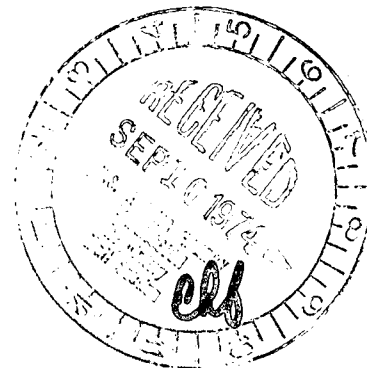
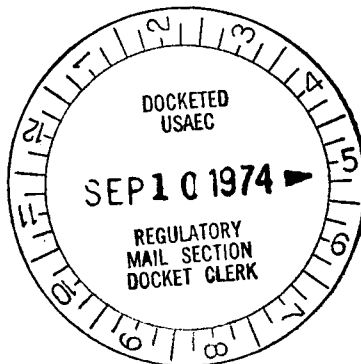
✓ 1 - LOCAL PDR n Minneapolis, MN	(1)(2)(10)-NATIONAL LABS	1-PDR-SAN/LA/WT
✓ 1 - TIC (ASERNATHY)	1-ASLBP(E/W Bldg, Rm 529)	1-BROOKHAVEN NAT LAB
✓ 1 - NSIC (BUCHANAN)	1-W. PENNINGTON, Rm E-201 GT	1-G. ULRIKSON, ORNL
✓ 1 - ASLB	1-B&M SWINEBROOK, Rm E-201 GT	1-AGMED (RUTH GUSMAN)
✓ 1 - Newton Anderson	1-CONSULTANTS	Rm B-127 GT
✓ 5 - ACRS SENT TO LIC ASST Diggs	NELMAY/BLUM/COBARTAN	

NSP**NORTHERN STATES POWER COMPANY**

MINNEAPOLIS, MINNESOTA 55401

September 6, 1974

Mr. J F O'Leary, Director
Directorate of Licensing
Office of Regulation
U S Atomic Energy Commission
Washington, DC 20545



Dear Mr. O'Leary:

MONTICELLO NUCLEAR GENERATING PLANT
Docket No. 50-263 License No. DPR-22

Additional Information Concerning Cracked Studs on Recirculation Pumps

Following submittal of our May 31, 1974 letter, additional information became available concerning reactor recirculation pump stuffing box holddown cover studs. This information was subsequently reviewed by Regulatory Operations inspectors during an inspection conducted on July 16-18, 1974. At that time it was agreed to submit the information to your office.

The following information is submitted in accordance with that agreement:

1. Abnormal sensitivity to stress corrosion can result if the stud material, ASTM A 193, Grade B6 Type 410 martensitic stainless steel, is improperly heat treated or tempered. Characteristic data from material suppliers indicate that the hardness for hardened and tempered (1100°F) 410 martensitic stainless steel should range from Rockwell C20 to C28. The hardness readings for the failed studs were in the range of Rockwell C31 to C32.
2. Two sets of stuffing box holddown cover studs have been ordered from the manufacturer having the following specifications:
 - a. Maximum hardness Rockwell C25.
 - b. Rolled threads.
 - c. 110 Kpsi minimum tensile strength.
 - d. No elongation hole.
 - e. Material heat number to be indicated on the end of each stud.

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3. Hardness value of each stud will be verified by NSP upon receipt.
4. It is planned to replace the existing studs during the Fall 1975 refueling outage. It is also planned at that time to subject the existing studs to non-destructive examination to detect any deterioration.

Yours very truly,



L O Mayer, PE
Director of Nuclear Support Services

LOM/kn

cc: J G Keppler
G Charnoff
Minnesota Pollution Control Agency
Attn. E A Pryzina