



UNITED STATES  
NUCLEAR REGULATORY COMMISSION  
REGION III  
799 ROOSEVELT ROAD  
GLEN ELLYN, ILLINOIS 60137

OCT 14 1977

Docket No. 50-263/77-19

Northern States Power Company  
ATTN: Mr. Leo Wachter  
Vice President  
Power Production and  
System Operation  
414 Nicollet Mall  
Minneapolis, MN 55401

Gentlemen:

This refers to the inspection conducted by Mr. E. W. K. Lee of this office on September 27-30, and October 3-6, 1977, of activities at Monticello Generating Station authorized by NRC Operating License No. DPR-22 and to the discussion of our findings with Mr. Eliason and others of your staff at the conclusion of the inspection.

The enclosed copy of our inspection report identifies areas examined during the inspection. Within these areas, the inspection consisted of a selective examination of procedures and representative records, observations, and interviews with personnel.

No items of noncompliance with NRC requirements were identified during the course of this inspection.

In accordance with Section 2.790 of the NRC's "Rules of Practice," Part 2, Title 10, Code of Federal Regulations, a copy of this letter and the enclosed inspection report will be placed in the NRC's Public Document Room, except as follows. If this report contains information that you or your contractors believe to be proprietary, you must apply in writing to this office, within twenty days of your receipt of this letter, to withhold such information from public disclosure. The application must include a full statement of the reasons for

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which the information is considered proprietary, and should be prepared so that proprietary information identified in the application is contained in an enclosure to the application.

We will gladly discuss any questions you have concerning this inspection.

Sincerely,

R. F. Heishman, Chief  
Reactor Construction and  
Engineering Support Branch

Enclosure: IE Inspection  
Report No. 50-263/77-19

cc w/encl:  
Mr. L. R. Eliason, Plant  
Manager  
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PDR  
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Anthony Roisman, Esq.,  
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OFFICE →	RIII	RIII <i>STH</i>	RIII <i>A</i>	RIII <i>M</i>		
SURNAME →	Lee/bk <i>or</i>	Danielson	Heishman	Choules		
DATE →	10/13/77	10/14/77	10/14	10/14/77		

U.S. NUCLEAR REGULATORY COMMISSION  
OFFICE OF INSPECTION AND ENFORCEMENT

REGION III

Report No. 50-263/77-19

Docket No. 50-263 License No. DPR-22

Licensee: Northern States Power Company  
414 Nicollet Mall  
Minneapolis, MN 55401

Facility Name: Monticello Nuclear Generating Station

Inspection at: Monticello Site, Monticello, MN

Inspection Conducted: September 27-30 and October 3-6, 1977

Inspector: *E. W. K. Lee*  
E. W. K. Lee

10/14/77

Approved by: *D. H. Danielson*  
D. H. Danielson, Chief  
Engineering Support Section 2

10/14/77

Inspection Summary

Inspection on September 27-30 and October 3-6, 1977 (Report No. 50-263/77-19)  
Areas Inspected: Documents and work activities relative to inservice inspection, pipe support and restraint systems; IE Bulletin No. 76-04 (cold work S.S. piping); removal of RPV feedwater nozzle cladding. The inspection involved 51 onsite hours by one NRC inspector.  
Results: No items of noncompliance or deviations were identified.

## DETAILS

### Persons Contacted

#### Principal Licensee Employees

- \*D. Antony, Plant Engineer, Operations
- \*D. Brosche, Assistant QC Engineer
- B. Day, Plant Engineer
- \*L. Eliason, Plant Manager
- \*D. Hanson, Assistant QC Engineer
- O. Iverson, Assistant Product Engineer
- \*P. Krumpas, QC Engineer
- \*W. Shamla, Plant Engineer, Technical

#### Other Personnel

- \*D. Arremony, Consultant, Arremony Associates

The inspector also contacted several other licensee and his contractor's employees, including, shift engineers and members of the technical and engineering staffs.

\*denotes those attending the exit interview.

#### Licensee Internal Audits

The inspector reviewed the licensee internal audit report covering ISI activities for this outage. No items of noncompliance or deviations were identified.

#### Licensee Action on IE Bulletins

The licensee has completed ultrasonic examinations for both loops A and B of the Core Spray System piping as committed by the licensee's letter dated December 20, 1976 in answering to IE Bulletin No. 76-04. No recordable indications were found. The inspector also randomly selected three UT reports for review. The inspector determined procedural requirements were met. No items of noncompliance and deviations were identified.

#### Functional or Program Areas Inspected

##### 1. Review of ISI Program

The inspector reviewed the licensee's ISI contractor (Lambert, MacGill, Thomas, Incorporated) QA Manual and verified that 10 CFR 50,

Appendix B requirements applicable to ISI were met. The inspector also reviewed the Fall, 1977 outage, ISI program and verified that the Technical Specifications and the ASME Section XI requirements were met. No items of noncompliance or deviations were identified.

2. Review of NDE Procedures

The inspector reviewed seven ultrasonic examination procedures, one visual examination procedure, one liquid penetrant examination procedure, one magnetic particle examination procedure, eight NDE personnel qualifications, three ultrasonic instrument certifications, two recorder certifications, three transducer certifications, ultrasonic couplant test reports and certifications of cleaner, penetrant and developer. It was determined that the above documents met the applicable code and procedural requirements. No items of noncompliance or deviations were identified.

3. Observation of ISI Work Activities

The inspector observed the following work activities:

- a. PT examinations of loop A core spray piping welds No. CSAF-3 and No. CSAF-2. Acceptable rounded indications were identified on Weld No. CSAF-3, no indication was identified on weld No. CSAF-2.
- b. UT examinations of loop B core spray piping weld No. CSBF-2 and Reactor Pressure Vessel to flange weld. No recordable indications were identified.

The inspector determined that the above examinations were conducted in accordance with the applicable procedures. It was further determined that personnel performing the examinations were qualified and that the equipment used were currently calibrated. No items of noncompliance or deviations were identified.

4. Review of ISI Records

The inspector reviewed two magnetic particle examination, one liquid penetrant examination, one visual examination and six ultrasonic examination reports. The reports reviewed were piping welds in the Main Steam, Feedwater, Residual Heat Removal, and Recirculation Bypass systems, Reactor Pressure Vessel to flange welds and Reactor Pressure Vessel ligaments. The inspector determined that the reports met the applicable procedural requirements and the reports did not indicate discontinuities were found during the examinations. Due to the fact that the outage is still

in progress, the reports reviewed by the inspector had not been reviewed by the licensee and the Authorized Inspector. The inspector has no further questions on this matter at this time. No items of noncompliance or deviations were identified.

5. Surveillance of Pipe Support and Restraint Systems

a. Review of Program and Procedures

The inspector reviewed two procedures relative to the operational testing and inspection of hydraulic snubbers. The inspector determined that the procedures are acceptable and met the Technical Specification requirements.

b. Observation

The inspector independently inspected three hydraulic snubbers outside the drywell, three hydraulic snubbers inside the drywell, six spring hangers inside the drywell and the associated supporting structures for the above items. The inspector determined that (1) items are physically acceptable, (2) bolts, nuts appeared to be tight and secure, (3) spring hangers were in their appropriate positions and (4) fluid in hydraulic snubbers does not appear to be leaking.

c. Review of Records

The inspector reviewed the hydraulic test and surveillance reports. The inspector determined the tests and inspections were conducted in accordance with Technical Specification and procedure requirements. The inspector further established from the reports that the fluid level, lock-up and bleed rates met the procedure requirements.

No items of noncompliance or deviations were identified.

6. Removal of RPV Feedwater Nozzle Cladding

a. Review of Procedures

The inspector reviewed twenty General Electric Company and licensee procedures. The procedures reviewed included assembly and installation of platform, cleanliness instructions, removal and installation of the feedwater spargers, material control, NDE, rigging and alignment of the cladding removal machine and machining. The inspector determined the procedures to be acceptable.

b. Observation of Work Activities

The inspector observed the alignment of the cladding removal machine to the 45<sup>o</sup> feedwater nozzle and determined that (1) work activities were in accordance with procedures, (2) travelers were signed-off at the proper sequence and (3) tools entering the RPV were controlled.

c. Review of Records

The inspector reviewed the pre-cladding removal PT records of the RPV feedwater nozzle inner radii. The reports indicated several indications (porosities, undercuts and previous grinding marks) were identified on all nozzles and one small (approximately 3/16" long) linear indication was identified in the 315<sup>o</sup> nozzle.

No items of noncompliance or deviations were identified.

Exit Interview

The inspector met with licensee representatives at the conclusion of the inspection on October 6, 1977. The inspector summarized the scope and findings of the inspection. The licensee acknowledged the information.