



UNITED STATES
ATOMIC ENERGY COMMISSION
DIRECTORATE OF REGULATORY OPERATIONS
REGION III
799 ROOSEVELT ROAD
GLEN ELLYN, ILLINOIS 60137

TELEPHONE
(312) 858-2660

A. RO Inspection Report No. 050-263/74-09

Transmittal Date : December 4, 1974

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Regulatory Standards (3)
Licensing (13)
RO Files

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B. RO Inquiry Report No. _____

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C. Incident Notification From: _____
(Licensee & Docket No. (or License No.))

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DEC 4 1974

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

Docket No. 50-263

Gentlemen:

This refers to the inspection conducted by Messrs. Choules and Vandel of this office on November 10, 1974, of activities at the Monticello plant authorized by AEC Operating License DPR-22, and to the discussion of our findings with Messrs. Neils, Larsen and others of your staff at the conclusion of the inspection.

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

No violations of AEC requirements were identified within the scope of this inspection.

In accordance with Section 2.790 of the AEC'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 AEC's Public Document Room. If this report contains any information that you or your contractors believe to be proprietary, it is necessary that you make a written application to this office, within twenty days of your receipt of this letter, to withhold such information from public disclosure. Any such application must include a full statement of the reasons for which it is claimed that the information is proprietary, and should be prepared so the proprietary information identified in the application is contained in a separate part of the document. Unless we receive an application to withhold information or are otherwise contacted within the specified time period, the written material identified in this paragraph will be placed in the Public Document Room.

DEC 4 1974

Northern States Power Company - 2 -

Should you have any questions concerning this inspection, we will be glad to discuss them with you.

Sincerely yours,

Gaston Fiorelli, Chief
Reactor Operations Branch

Enclosure:
RO Inspection Rpt No.
050-263/74-09

bcc: RO Chief, FS&EB
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Licensing (4)
DR Central Files
RO Files
PDR
Local PDR
NSIC
TIC
OGC, Beth, P-506A
Anthony Roisman, Esq.

U. S. ATOMIC ENERGY COMMISSION
DIRECTORATE OF REGULATORY OPERATIONS

REGION III

Report of Operations Inspection

RO Inspection Report No. 050-263/74-09

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

Monticello Nuclear Generating Plant
Monticello, Minnesota

License No. DPR-22
Category: C

Type of Licensee: BWR (GE), 545 Mwe

Type of Inspection: Special, Announced

Date of Inspection: November 10, 1974

Dates of Previous Inspection: October 23-25, 1974 (Region IV, Joiner)

Principal Inspector: *N. C. Choules*
N. C. Choules

12/3/74
(Date)

Accompanying Inspector: *T. Vandell*
T. Vandell

12-3-74
(Date)

Other Accompanying Personnel; None

Reviewed By: *E. L. Jordan*
E. L. Jordan, Senior Reactor Inspector
Reactor Operations Branch

12/3/74
(Date)

SUMMARY OF FINDINGS

Enforcement Action

None

Licensee Action on Previously Identified Enforcement Matters

Not Applicable.

Unusual Occurrences

None

Other Significant Findings

A. Current Findings

1. The licensee performed ultrasonic testing of the 4-inch piping bypass recirculation line welds and found no cracks.
2. The licensee performed liquid dye penetrant testing of the welds on the 2-inch equalizing lines around the loop cross connect valves and found no cracks.

B. Unresolved Matters

None

C. Status of Previously Reported Unresolved Items

None

Management Interview

The following Northern States Power personnel were present at the management interview conducted at the conclusion of the inspection on November 10, 1974.

- G. H. Neils, General Superintendent of Nuclear Power Plant Production
- C. E. Larsen, Plant Manager
- M. H. Clarity, Superintendent Plant Engineering and Radiation Protection
- P. J. Krumpas, Quality Assurance Engineer

The inspectors stated that the purpose of the inspection was to review the licensee program and actions related to the inspection of the welds on the recirculation bypass lines and on the equalizing lines for the loop cross connect valves for cracks. The inspectors stated the following items were inspected and there were no apparent deficiencies.

- A. The drywell was entered with the licensee's representative and the piping welds which were inspected for cracks were identified.
- B. Records for the testing equipment calibrations and qualifications and for the testing personnel qualifications were reviewed.
- C. Testing procedures utilized were reviewed.
- D. Test data obtained was reviewed.

The inspectors stated it was their understanding from discussions with the licensee's representatives and from review of test data that no cracks were found in the welds. The licensee confirmed this statement.
(Report Details)

REPORT DETAILS

Persons Contacted

The following individuals, in addition to the individuals listed in the Management Interview section of this report, were contacted during the inspection:

Nuclear Services Corporation (NSC)

T. G. Lambert, Manager of Plant Testing
V. J. Lovelace, Level II Inspector
L. Thomas, Level II Inspector

Hartford Steam Boiler Insurance Company

T. F. Wotier, Authorized Inspector

Results of Inspection

The nondestructive examination of the recirculation system bypass piping welds performed by NSC under contract to Northern States Power Company was reviewed by the inspectors. The areas of review included:

1. Visual identification of welds

The inspectors entered the drywell containment vessel accompanied by the Northern States Power Company's Power Production Department Quality Assurance Engineer. The welds that were nondestructively inspected were visually examined by the RO Inspector and were noted to be sufficiently accessible for the inspection, were reasonably smooth and evenly contoured, and no deterrent to the inspection was identified.

2. Equipment utilized

The equipment utilized for the inspection was available for review and was reviewed by the RO Inspectors. Equipment identification tags and calibration tags (showing valid calibrations) were in evidence and were determined to be traceable to documentation of equipment acceptability available at the site office. A calibration standard was examined that was utilized for the ultrasonic testing (UT) equipment calibration as prescribed by the procedures. The equipment used appeared to be acceptable.

3. Records of Qualification

Records were reviewed by the RO inspector relative to the qualifications of the UT equipment used and the inspection personnel. The qualification records appeared to be adequate and included the following:

a. Inspection personnel

NSC provided certifications, results of testing, and eye examinations for 6 level II and level III UT inspectors, of which five were utilized in the performance of the UT inspection.

b. Equipment qualifications

Certifications and calibration information were available for the transducers, the wedge blocks (45° wedge), the scopes and recorders, and for the couplant fluid utilized for the longitudinal wave form inspection.

c. Licensee Review

The licensee representative stated, in response to questioning, that he had examined all of the certifications and qualifications information and had found everything in order.

4. Procedures

The licensee representative stated that the six NSC procedures utilized in the inspection had been reviewed and approved by NSP Co., that these procedures were the same procedures that were used for the Monticello facility inservice inspections, and that these procedures are responsive to the requirements of the ASME Section III and Section XI codes both through the summer 1973 addenda.

5. Inspection Results

The RO inspectors reviewed selected UT inspection chart records with the NSC Level III inspector. The charts selected included the welds adjacent to the weldolets of the 4-inch piping bypass tap from the recirculation piping. The results appeared to be satisfactory.

6. Liquid Penetrant (LP) Inspection

The qualifications were examined for the LP inspection personnel and it was found that the same personnel utilized for the UT examination were also qualified for the LP testing. In addition certifications were available that established that the penetrant materials met the applicable ASME requirements.