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CONTROL NO: 50-263

FROM: Northern States Power Co. Minneapolis, Minn. 55401 L.O. Mayer	DATE OF DOC: 1-12-73	DATE REC'D 1-15-73	LTR X	MEMO	RPT	OTHER	FILE
TO: Mr. Donald J. Skovholt	ORIG 1 signed	CC 39	OTHER	SENT AEC PDR ✓ SENT LOCAL PDR ✓			
CLASS: (U) PROP INFO	INPUT	NO CYS REC'D 40		DOCKET NO: 50-263			

DESCRIPTION: Ltr re our 12-13-72 ltr... furnishing info relating to torus ring header supports re Monticello Plant.....

*PLEASE CIRCULATE-INSUFFICIENT CYS FOR FULL DISTRIBUTION

PLANT NAMES: Monticello Plant

ENCLOSURES:

ACKNOWLEDGED
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FOR ACTION/INFORMATION DL 1-15-73

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NSP

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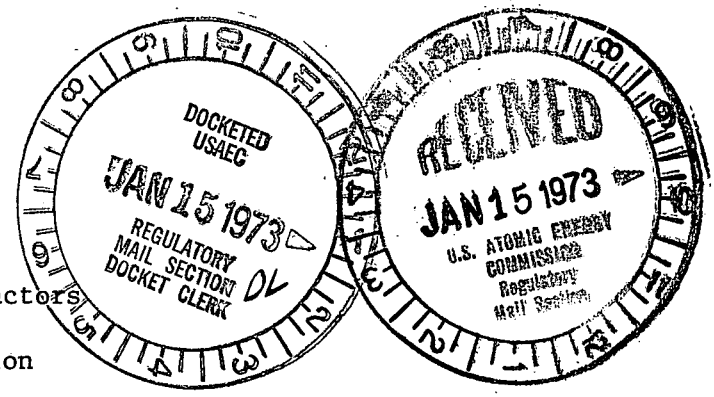
NORTHERN STATES POWER COMPANY

MINNEAPOLIS, MINNESOTA 55401



January 12, 1973

Mr. Donald J. Skovholt
Assistant Director for Operating Reactors
Directorate of Licensing
United States Atomic Energy Commission
Washington, D. C. 20545

Dear Mr. Skovholt:

MONTICELLO NUCLEAR GENERATING PLANT
Docket No. 50-263 License No. DPR-22
Information Relating to Torus Ring Header Supports

Your letter of December 13, 1972, requested five pieces of information concerning the adequacy of the Monticello torus ring header support design. In the event the specified information could not be obtained within 30 days, a schedule for submitting it to the Commission was to be provided.

Requested Items 1, 2, and 3 will be available in March, 1973 when analyses being conducted by the General Electric Company are scheduled to be completed. A reply will be prepared, including Items 4 and 5, following completion of this investigation.

The General Electric investigation is based on testing conducted in October, 1972 at the Quad Cities Plant. It is intended that conclusions will be reported on a generic basis. Results obtained to date indicate that there is no reason for concern over the design of the Monticello ring header. Indications of possible design deficiencies which may arise during the course of the investigation will be immediately made known to the Commission and the utilities involved. Furthermore, it is our understanding that members of the AEC staff have reviewed the status of this program and the content of the projected report.

Our own experience has indicated that the most likely source of problems experienced with torus ring header supports is improper fabrication and installation. As reported to the Directorate of Regulatory Operations, Region III, by letters of July 5, 1972, and December 6, 1972, the following repairs were necessary at Monticello to correct installation deficiencies in the system:

1. Ungraded, fully threaded bolts were replaced with ASME Grade A325 bolts with no threads in the load bearing region. Bolts were fitted with locking nuts.

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2. All torch-cut bolt holes were filled and replaced with drilled holes.

3. Torus butt plates and padeyes were welded all around with 1/4-inch fillet.

4. All hanger welds were subjected to magnetic particle inspection.

5. Static load analysis was conducted and all hanger loads were balanced.

These repairs restored the torus ring header support system to original design conditions. In addition, the substitution of the higher strength bolt (original design bolt was ASME Grade A307) has resulted in a substantial upgrading of the ability of the system to withstand dynamic loading.

Yours very truly,

L. O. Mayer

L. O. Mayer, P.E.
Director of Nuclear Support Services

LOM/DMM/vm

cc B. H. Grier