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ACCESSION NBR: 8504300266 DOC. DATE: 85/04/22 NOTARIZED: NO DOCKET #
 FACIL: 50-263 Monticello Nuclear Generating Plant, Northern States 05000263
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 Office of Nuclear Reactor Regulation, Director

SUBJECT: Provides addl info re feedwater sparger replacement & insp performed during 1984 refueling & maint outage. Sparger failures caused by high weld residual stresses & normal thermal cycling. Corrective actions listed.

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NOTES: 05000263
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April 22, 1985

Director
Office of Nuclear Reactor Regulation
U S Nuclear Regulatory Commission
Washington, DC 20555

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

Supplemental Information Related to the Inservice Inspection
Examination Summary - Refueling Outage No. 10

The purpose of this letter is to provide, for the information of the NRC staff, additional information related to the feedwater sparger replacement and inspection performed during the 1984 refueling and maintenance outage at the Monticello plant. This information supplements our submittal of April, 1985.

All four feedwater sparger segments were replaced during the 1984 Monticello outage after cracks were found on several of the top mounted elbow extension welds during normal in-service-inspection. The causes of the failures were high weld residual stresses and normal thermal cycling. The following corrective actions were taken.

- A. The new sparger segments were solution annealed to remove any weld residual stresses. This enhanced the spargers ability to withstand normal cyclical stresses.
- B. The number of welds used to fabricate and install the top mounted elbows was reduced through the use of a one piece adapter.
- C. The new sparger segments were fabricated of 316 NG stainless steel instead of the lower yield strength 304 L previously used.
- D. The weld techniques and post weld inspections were improved to reduce residual weld stresses.

The last feedwater nozzle surface inspection was performed during the 1981 refueling/maintenance outage. The total number of start-up/shutdown cycles since that time was nine.

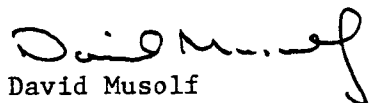
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An on-line feedwater nozzle thermal sleeve leak detection system has been used to monitor feedwater nozzle thermal sleeve bypass flow. This system indicates that there is no significant bypass flow and there is no increasing trend on any of the nozzles.

Please contact us if you have any questions related to the information we have provided.


David Musolf
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DMM/MMV/jk

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