ACCELERATED DISTRIBUTION DEMONSTRATION SYSTEM

REGULATORY INFORMATION DISTRIBUTION SYSTEM (RIDS)

ACCESSION NBR:9110250131 DOC.DATE: 91/10/15 NOTARIZED: NO DOCKET #
FACIL:50-263 Monticello Nuclear Generating Plant, Northern States 05000263
AUTH.NAME AUTHOR AFFILIATION
PARKER,T.M. Northern States Power Co.
RECIP.NAME RECIPIENT AFFILIATION
Document Control Branch (Document Control Desk)

SUBJECT: Forwards Relief Request 16 from second 10-yr inservice insp interval re volumetric exam of one circumferential & one longitudinal beltline region weld during successive Insp Intervals 2,3 & 4.

DISTRIBUTION CODE: A047D COPIES RECEIVED:LTR 1 ENCL 1 SIZE: 6
TITLE: OR Submittal: Inservice Inspection/Testing/Relief from ASME Code

NOTES:NRR/LONG,W. 05000263

	RECIPIENT ID CODE/NAME	COPIES LTTR	COPIES ENCL	RECIPIENT ID CODE/NAME	COPIES LTTR	COPIES ENCL
	PD3-1 LA	1	0	PD3-1 PD	1	1
	MASCIANTONIO	2	2			
INTERNAL:	NRR/DET/ECMB 9H	1	1	NRR/DET/EMEB 7E	1	1
	NUDOCS-ABSTRACT	1	1	OC/LFMB	1	0
	OGC/HDS1	1	0	REG FILE 01	1	1
	RES/DSIR/EIB	1	1			
EXTERNAL:	EG&G BROWN,B	1	1	EG&G RANSOME,C	1	1
	NRC PDR	1	1	NSIC	1	1

R I D S / A D D S

R I D S / A D D S

NOTE TO ALL "RIDS" RECIPIENTS:

PLEASE HELP US TO REDUCE WASTE! CONTACT THE DOCUMENT CONTROL DESK, ROOM P1-37 (EXT. 20079) TO ELIMINATE YOUR NAME FROM DISTRIBUTION LISTS FOR DOCUMENTS YOU DON'T NEED!

TOTAL NUMBER OF COPIES REQUIRED: LTTR 15 ENCL 12

MAY

Northern States Power Company

414 Nicollet Mall
Minneapolis, Minnesota 55401-1927
Telephone (612) 330-5500

October 15, 1991

10 CFR Part 50
Section 50.55a(g)

US Nuclear Regulatory Commission
Attn: Document Control Desk
Washington DC 20555

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

Revised Relief Request No. 16
Second Ten-Year Inservice Inspection Interval

We committed to provide the NRC Staff with a revised reactor vessel weld inspection relief request in a telephone conversation with our Project Manager, Mr W O Long, on September 24, 1991. This letter completes this commitment.

NRC Staff review and approval is being requested for revised Request for Relief No. 16, from the requirements of the ASME Boiler and Pressure Vessel Code, Section XI, Inservice Inspection, as specified in the Monticello Inservice Inspection and Testing Program for the Second Ten Year Interval, submitted to the Commission on March 27, 1981. The revised Relief Request is being submitted in accordance with 10 CFR Part 50, Section 50.55a(g)(6)(i).

Please contact us if you have any questions related to the revised Relief Request.

Thomas M Parker
Manager
Nuclear Support Services

c: Regional Administrator-III, NRC
NRR Project Manager, NRC
NRC Resident Inspector
State of Minnesota
Hartford Insurance
J Silberg

Attachment: Relief Request #16

A047
1/1

RELIEF REQUEST # 16

COMPONENT OR ITEM

Examination Category B-A, Pressure Retaining Welds In Reactor Vessel.

CODE ITEM

B1.10 Shell Welds

B1.11 Circumferential

B1.12 Longitudinal

CODE REQUIREMENT

Perform a volumetric examination of one circumferential and one longitudinal beltline region weld during successive inspection Intervals, 2nd, 3rd, and 4th.

BASIS FOR RELIEF REQUEST

The requirement to perform a volumetric examination of 100% of one circumferential and one longitudinal weld is impractical.

Only limited O.D. access to beltline welds is available through the shield wall nozzle openings. Accessibility from the I.D. is limited using the present technology because of reactor vessel internals such as; core spray piping, feedwater spargers, guide rods, and obstructions welded to the shroud.

Specifically, one of the two longitudinal beltline welds is totally inaccessible because of welded obstructions on the shroud. The welded obstructions on the shroud also prevent the examination of two thirds of the circumferential beltline weld. In addition, portions of the vessel I.D. cladding is very rough and is unsuitable for ultrasonic examination.

ALTERNATIVE

Volumetrically examine one circumferential and one longitudinal beltline region weld to the extent practical. This would be 12 % of the circumferential beltline weld and 40% partial examinations of the accessible longitudinal beltline welds. In addition, perform a sampling volumetric examination of other longitudinal and circumferential reactor vessel welds to the extent practical. This amounts to 47% of the remaining reactor vessel welds.

The examination extent we have already performed and limitations are shown on the attached charts and drawing.

NOTE:

Partial examination means the weld has not been scanned in all four directions.

SUMMARY OF REACTOR VESSEL BELTLINE WELD INSPECTION

WELD NO.	TOTAL LENGTH	LENGTH OF WELD IN BELTLINE AREA	LENGTH WITH FULL ASME EXAM	LENGTH EXAMINED IN BELTLINE AREA
LONG. WELD VLBA-1	102.5 IN.	85.2 IN.	0 IN. (0%)	0 IN. (0%)
LONG. WELD VLBA-2	102.5 IN.	85.2 IN.	0 IN. (0%)	68.1 IN. (79.9%) (PARTIAL EXAM)
CIRC. WELD VCBA-2	648.9 IN.	648.9 IN.	81.25 IN. (12.5%)	81.25 IN. (12.5%)
LONG. WELD VLAA-1	117.9 IN.	27 IN.	0 IN. (0%)	0 IN. (0%)
LONG. WELD VLAA-2	117.9 IN.	27 IN.	0 IN. (0%)	9.1 IN. (33.7%) (PARTIAL EXAM)

LIMITATIONS TO VOLUMETRIC EXAMINATION:

VLBA-1: Clip welded to outside of Shroud at 45 degrees prevent tool access to entire weld.

VLBA-2: Interference from Jet Pumps.

VCBA-2: Clips welded to outside of Shroud at 45, 75, 105 and 315 degrees, Guide Rods at 0 and 180 degrees.

VLAA-1: Clip welded to outside of Shroud at 75 degrees prevents tool access to upper nine inches of weld. Lower 108 inches of weld inaccessible from vessel ID with present technology available today.

VLAA-2: Lower 108 inches of weld inaccessible with present technology available today. Upper 9 inches is only part of weld accessible from ID.

ADDITIONAL REACTOR VESSEL WELDS EXAMINED

WELD NO.	TOTAL LENGTH	LENGTH WITH FULL ASME EXAM	LENGTH WITH PARTIAL EXAM	LENGTH OF WELD THAT IS INACCESSIBLE
VCBC-5	647.2 IN.	255.9 IN. (39.5%)	120.5 IN. (18.6%)	270.8 IN. (42%)
VLDB-1	131.6 IN.	94.4 IN. (82%)	0 IN. (0%)	37.2 IN (18%)
VLDB-2	131.6 IN.	94.4 IN. (82%)	0 IN. (0%)	37.2 IN. (18%)
VCBB-4	647.2 IN.	293.3 IN. (45.3%)	131.8 IN. (20.3%)	221.1 IN. (34.3%)
VLCB-1	131.7 IN.	19.2 IN. (14.5%)	0 IN. (0%)	49.8 IN. (37.8%)
VLCB-2	131.7 IN.	0 in. (0%)	0 IN. (0%)	131.7 IN. (100%)
VCBB-3	648.9 IN.	269.7 IN. (41.5%)	43 IN. (6.6%)	336.2 IN. (51.8%)

LIMITATIONS TO VOLUMETRIC EXAMINATION:

VCBC-5: Guide Rods at 0 and 180 degrees, Main Steam Line plugs and air hoses.

VLDB-1: Steam Dryer Support Brackets.

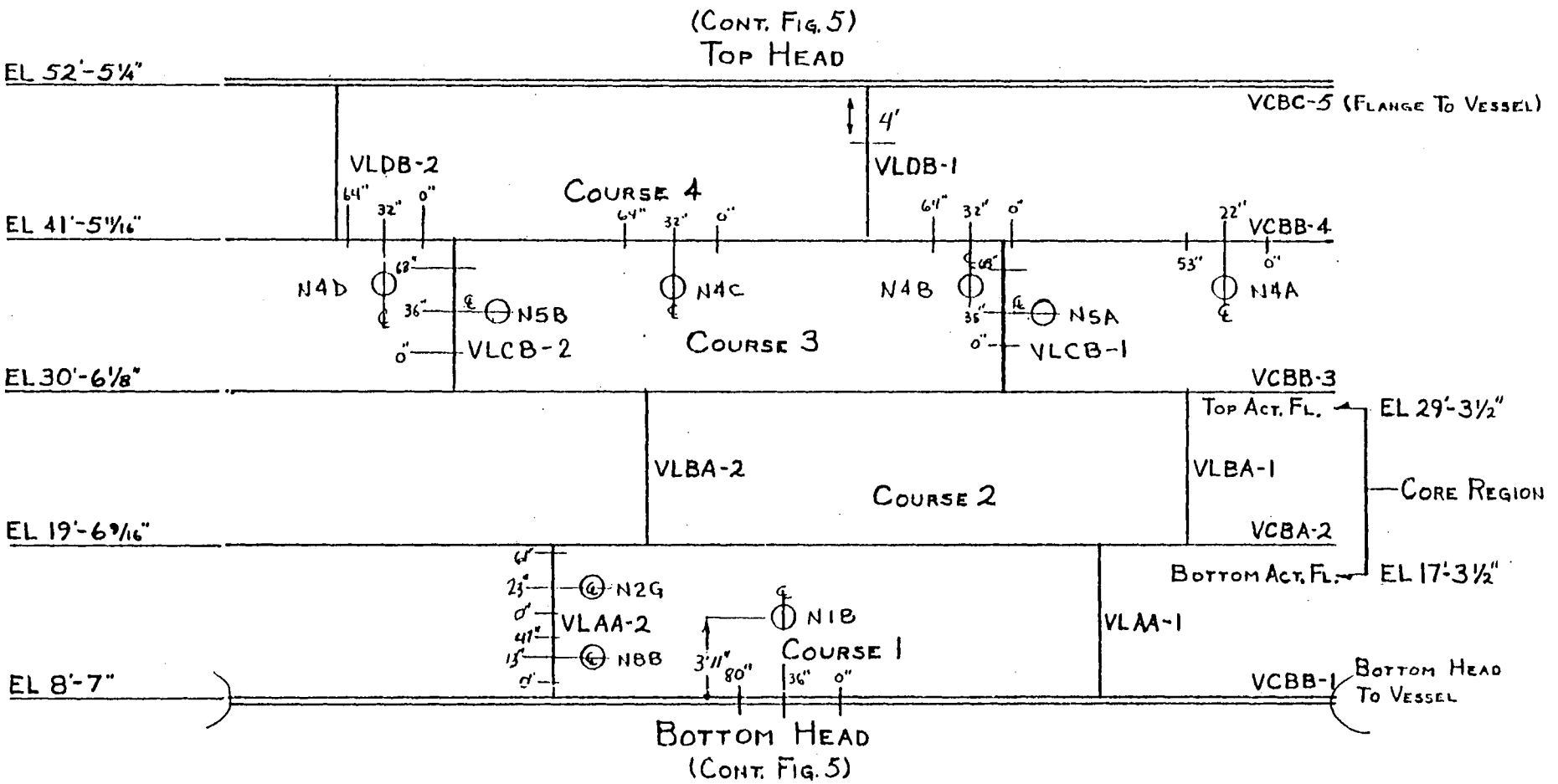
VLDB-2: Steam Dryer Support Brackets.

VCBB-4: Guide Rods at 0 and 180 degrees, Main Steam Line plugs and air hoses.

VLCB-1: Main Steam Line plugs and air hoses, Feedwater Sparger, Core Spray Piping.

VLCB-2: Main Steam Line plugs and air hoses, Feedwater Sparger, Core Spray Piping.

VCBB-3: Guide Rods at 0 and 180 degrees, Core Spray Piping, Feedwater Spargers, Surveillance Specimen basket. Rough cladding consisting of ground and unground areas limit the extent this weld can be examined.



MONTICELLO UNIT 1

CIRCUMFERENTIAL AND LONGITUDINAL VESSEL WELDS

DWN: R. THORNE	FIGURE 2 REV. 1
CHK'D: GC	