

U.S. NUCLEAR REGULATORY COMMISSION

REGION III

Report No. 50-263/81-23

Docket No. 50-263

License No. DPR-22

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

Facility Name: Monticello Nuclear Generating Plant

Inspection At: Monticello site, Monticello, MN

Inspection Conducted: November 9 and 10, 1981.

K. D. Ward
Inspector: K. D. Ward

D. H. Danielson
Approved By: D. H. Danielson, Chief
Materials and Processes Section

11/23/81
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Inspection Summary:

Inspection on November 9-10, 1981 (Report No. 50-263/81-23)

Areas Inspected: Inservice inspection (ISI) and torus structural modifications, QA/QC programs, implementing procedures, work activities, and review and evaluation of nondestructive examination (NDE) and welding data and reports; IE Bulletin 80-13 activities; core spray safe end replacement. This inspection involved a total of seven inspection-hours on site by one NRC inspector.

Results: No items of noncompliance or deviations were identified.

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DETAILS

Persons Contacted

Northern States Power Company (NSP)

- *W. Shamla, Plant Manager
- *P. Krumpas, Superintendent Materials Special Processes
- *D. Hansen, Associate, Materials Special Processes

Lambert - MacGill - Thomas Incorporated (LMT)

B. Thomas, Level III Examiner

Cherne Contracting Corporation (Cherne)

T. Hanson, QC Manager

Hartford Steam Boiler Engineering and Insurance Company

C. Lindstrom, Authorized Nuclear Inservice Inspector (ANII)

The inspector also contacted and interviewed other licensee and contractor employees.

*Denotes those present at the exit interview.

Licensee Action on IE Bulletins

(Closed) Unresolved Item (263/81-06-01). The inspector reviewed the final response to IE Bulletin 80-13 dated May 15, 1981, and the action taken to date including a review of NDE personnel certifications, procedures, and data for the remote underwater TV examinations of the core spray sparger systems, shroud support welds and feedwater sparger system. The inspector has no questions at this time.

Functional or Program Areas Inspected

1. General

a. ISI

Lamber, MacGill, Thomas, Incorporated (LMI) performed the inservice inspection (ISI) in accordance with ASME Section XI, 1974 Edition, Summer 1975 Addenda.

This is the last outage of the first ten year plan.

b. Torus

NUTECH will prepare the Project Analysis Report for the following torus modifications for NSP in accordance with ASME Section XI, 1977 Edition, Winter 1978 Addenda.

Catwalk Support
Monorail Stiffeners
Vacumm Breaker Stiffeners

Cherne Contracting Corporation performed the torus modifications, welding and NDE.

c. Core Spray Safe End

Crack like indications were first found by ultrasonic examinations (UT) February 1975, and were reported as linear geometry because of the configuration of the safe end. The area was also UT'd in September 1975, September 1977, March 1980 and October 1981. The indications did not propagate at any time. The safe end was radiographed October 31, 1981, and interpreted as cracks by NSP. A program is being prepared for the replacement of the transition piece of the safe end. The replacement may be completed in December 1981.

2. Procedure Review

The inspector reviewed the following procedures:

- . NSP, Magnetic Particle Examination, Yoke Method, MT-1, Revision 2,
- . NSP, Wet Magnetic Particle Examination, MT-2, Revision 0,
- . NSP, Liquid Penetrant Examination, PT-1, Revision 2,
- . NSP, Ultrasonic Examination of Pipe Welds, UT-1, Revision 1,
- . NSP, Automatic Data Recording, UT-2, Revision 1,
- . NSP, Ultrasonic Examination of Ferritic Vessels with Wall Thickness 2.5" and Greater, UT-3, Revision 1,
- . NSP, Ultrasonic Examination of Studs and Bolts, UT-4, Revision 1,
- . NSP, Axial Ultrasonic Examination of Studs and Bolts, UT-4B, Revision 1,
- . NSP, Ultrasonic Examination of Reactor Vessel Nozzle Forging Inner Radii, UT-5, Revision 2,
- . NSP, Ultrasonic Examination of Reactor Vessel Nozzle Bore, UT-6, Revision 2,

- . NSP, Ultrasonic Examination of Flange Ligaments, UT-7, Revision 1,
- . NSP, Ultrasonic Examination of Vessel to Flange Welds, UT-8, Revision 1,
- . NSP, Ultrasonic Examination of Reactor, UT-13, Revision 0,
- . NSP, Visual Examination, VT-1, Revision 2,
- . NSP, Visual Examination of Assembled Hanger Assemblies, VT-2, Revision 2,
- . NSP, Visual Examination of Pump and Valve Internal Pressure Boundary Surfaces, VT-3, Revision 0,
- . NSP, Construction Requirements for 1981 Torus Internal Modifications, 60-103, Revision 1,
- . Magnaflux Quality Services, (MQA) Test and Inspection Procedure, Radiographic Examination of Welds, 20.A.1-3, Revision 3,
- . Cherne, Nondestructive Examination Personnel Qualification and Certification Program Manual, 14.1, Revision 2,
- . Cherne, Visible Dye, Solvent Removed Liquid Penetrant Examination, 14.3, Revision 0,
- . Cherne, Magnetic Particle Yoke Examination, 14.4, Revision 0,
- . Cherne, Ultrasonic Examination, 14.6, Revision 0.

No items of noncompliance or deviations were identified.

3. Material and Equipment Certification

The inspector reviewed the certification documents relative to the following items:

- . Ultrasonic instruments, calibration blocks, transducers and couplant,
- . Liquid penetrant, magnaflux materials, penetrant, cleaner and developer,
- . Magnetic particle, Magnaflux materials and equipment.

No items of noncompliance or deviations were identified.

4. NDE and Welding Personnel Certifications

The inspector reviewed the following NDE personnel certifications in accordance with SNT-TC-1A, 1975 Edition.

LMT

<u>Name</u>	<u>UT</u>	<u>PT</u>	<u>VT</u>	<u>MT</u>
E. Thomas	III	III	II	III
C. Homler	II	II	II	II
R. Kellerhali	II	II	II	II
R. Pechaceic	II	II	II	II
W. Tighe	II	I		II

Cherne

<u>Name</u>	<u>UT</u>	<u>PT</u>	<u>VT</u>	<u>MT</u>
M. Anderson	III	III	III	III
D. Corbesia			III	
S. Scott		II	II	II
G. Tintes		II	II	II
J. Jacobs	II	II	II	II

Magnaflux Quality Services

<u>Name</u>	<u>RT</u>
J. Cox	II
D. Kane	II
R. Klemann	II
J. Laws	II

The inspector reviewed the following Cherne welder qualifications in accordance with ASME Section IX, 1981 Edition, Summer 1981 Addenda.

<u>Name</u>	<u>Symbol No.</u>	<u>Name</u>	<u>Symbol No.</u>
J. Olofson	"KK"	R. Woodland	"NN"
R. Curl	"LL"	C. Hummel	"OO"
D. Johnson	"MM"	D. Jans	"pp"

No items of noncompliance or deviations were identified.

5. Observation of Work Activities

a. ISI

The inspector observed the work and had discussions with personnel during review of the following activities:

- . Liquid penetrant examination of hanger RMAK-13.
- . Ultrasonic examination calibration for hanger RMAK-13.

b. Torus

- . Visual examination of torus in general, catwalk, monorail, etc.

c. Core Spray

- . Visual examination of core spray safe end and radiographs.

No items of noncompliance or deviations were identified.

6. Data and Audit Review

Review of the data files indicate that the QA/QC and technical requirements were met.

The inspector also reviewed a Cherne audit of work in the torus 81-16, dated August 18, 1981.

No items of noncompliance or deviations were identified.

Exit Interview

The inspector met with site representatives (denoted in Persons Contacted paragraph) at the conclusion of the inspection. The inspector summarized the scope and findings of the inspection noted in this report.