



COLUMBIANA HI TECH LLC

Nuclear Manufacturing Excellence

September 20, 2013

US Nuclear Regulatory Commission
One White Flint North
11555 Rockville Pike
Rockville, MD 20852

Attention: Document Control Desk

Subject: Supplemental Information #01 to CHT's Request for a Revision to UX-30
Certificate of Compliance, Certificate #9196, Rev 26, Docket #71-9196

Reference: CHT Letter dated August 27, 2013

Please find attached a copy of Supplemental Information #01 which lists the changes in the ANSI Specification N14.1-2001 to the new revision N14.1-2012. Only the changes effecting the contents of the UX-30 are noted.

Should you have any questions and/or need any additional information, please do not hesitate to call me at your convenience.

Sincerely,

A handwritten signature in black ink, appearing to read 'D Olson'.

Donald W. Olson
President
Columbiana Hi Tech, LLC

KIMSS01
NM25

Supplemental Information #01 to Support Request for a Revision to UX-30
Certificate of Compliance Certificate #9196, Rev 26, Docket #71-9196

ANSI N14.1 – 2012 Changes: Compared to ANSI N14.1 – 2001)

Paragraph 5.2.1:

- Adds requirements (acceptance criteria) for fillet welds to be in accordance with 3.6 of AWS D1.1 and the code.
- Adds coupling installation instructions to include screwing in an appropriate sized national pipe thread (NPT) plug into the coupling before any welding. After welding is completed, the coupling should be allowed to cool before removal of the plug.
- Added requirements for ASTM A131 Grade – E Steel. The charpy V-notch impact test and acceptance criteria shall be as specified in ASTM A131.

Paragraph 5.2.3

- Changed entire paragraph to read:

“5.2.3 Testing

A qualified inspector shall witness all testing.

1. Hydrostatic Strength Test: Cylinders shall be subjected to a hydrostatic strength test of the type set forth in the Code. No leaks shall be permitted. The test pressure shall be twice the MAWP. Prior to inspection for leaks the pressure shall be lowered to 1.5 times the MAWP or 200 psig, whichever is the greater. Defects, if any, shall be repaired as permitted in the Code, and a retest shall follow.
2. Pneumatic Leak Test: A pneumatic leak test at 100 psig shall be carried out on all connections, fittings, and valve seats (and packing where provided) using an appropriate leak-testing fluid. The sensitivity of this test shall be at least 10^{-3} atmospheres • cm³/s. No leakage shall be permitted.”

Note: The requirement for a qualified inspector to witness all testing is an addition to this paragraph. The balance of changes to this paragraph are considered enhancements/clarifications to the existing ANSI N14.1 – 2001 text.

Paragraph 6.6.2:

- Changed coupling description to read:
“2. Couplings. Modified half-coupling per Figure 14, forged ASTM A-105.
Note: ASTM A106 Grade C may be used in lieu of ASTM A-105”
- Modified Seal Loop description to read:
“5. Seal Loop(s). Rod, ASTM A36”

Paragraph 6.6.6:

- Plug description is modified to allow (add) the use of socket head plugs in lieu of hex head plugs. (Ref: Para. 8.4.2 for materials description)

Paragraph 6.6.7:

- Changes were made to the valve and plug installation instructions to include the use of socket head plugs along with adding specific requirements for use of torque wrenches and specifying minimum thread engagement of fittings. (Ref: Para 7.2)

Paragraph 6.6.10:

- Changed paragraph to add allowance for the use of filtered dry air or nitrogen to a maximum dew point of -30° F for the purposes of purging the cleaned cylinders. (Ref: Para 5.3.1).

Paragraph 6.5.11:

- Added specific requirements for documenting water weight/capacity on certifications and cylinder name plates, etc. Also delineates specific records required (certifications, as-built drawings, manufacturer's data report, etc.) and records retention requirements for the same. (Ref: Para 5.2.5)

Paragraph 7.1.9:

- Paragraph has been modified to change "Test for Seat Leakage" method and added reference to details for types of test found in standards API Std 527 and FCI 70-2. Additionally, the pressure-test minimum time of 1 minute has been added to this paragraph.
- Added the requirement that the NGT thread shall be covered with a cap or similar fitting to protect the threads and to keep the valve inlet clean during shipment and storage.

Paragraph 7.1.10:

- Deletes requirement to send one "untinned valve" with each lot of fifty valves or less. (Ref: This requirement was Para 6.15.9 in ANSI N14.1-2001).

Paragraph 7.3:

- Added "Valve Maintenance on Cylinders in Use" requirements to ANSI N14.1-2012. This subject matter is not addressed in ANSI N14.1-2001 edition. This paragraph provides specific requirements to "retighten packing nut", "packing and/or stem replacement", and "packing nut replacement" instructions for cylinder valves.