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 KNIGHTON, G.W.      Licensing Branch 3

SUBJECT: Proposes method of insp of low pressure turbine discs for ultrasonic indications. Discs will be inspected prior to startup following second refueling outage, per License Condition 2.C.(15) & 2.C.(13).

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August 1, 1984

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Director, Office of Nuclear Reactor Regulation  
Attention: Mr. George W. Knighton, Branch Chief  
Licensing Branch No. 3  
U. S. Nuclear Regulatory Commission  
Washington, D.C. 20555

Gentlemen:

Subject: Inspection of Low-Pressure Turbine Discs  
Docket Nos. 50-361 and 50-362  
San Onofre Nuclear Generating Station  
Units 2 and 3

License Condition 2.C.(15) for Unit 2 and License Condition 2.C.(13) for Unit 3 state that prior to startup following the second refueling outage, the bores of the low-pressure turbine disc shall be inspected for ultrasonic indications. These license conditions are consistent with the discussion in Section 10.2.2 of the SER for San Onofre Units 2 and 3. The turbine generator units for San Onofre Units 2 and 3 were fabricated by General Electric Company of England which provided information regarding minimum material properties and minimum critical crack size of the low-pressure turbine discs. This information was submitted to the NRC during the Operating License review process. The data was evaluated by the Staff utilizing the most conservative approach because the Staff had no service experience with the design or the turbine vendor. The Staff determined that the low-pressure turbines could operate in excess of ten years before inspection. However, because the NRC had no service experience with the design or the turbine vendor, the Staff requested that the bores of the low-pressure turbine disc be inspected for any ultrasonic indications before the turbine had operated for three years (e.g., prior to startup following the second refueling outage).

During the upcoming first refueling outage for San Onofre Unit 2, the second stage low-pressure turbine rotor and inner shell will be removed for maintenance, inspection and warranty purposes. SCE plans to inspect the low pressure turbine disc bores during this outage. Based on the duration of the outage and the opportunity available, SCE may inspect one, two or all three of the low-pressure turbine disc bores during the outage. In the event that inspection of all three low-pressure turbine disc bores is not completed during the first refueling outage, the remaining bore inspection(s) will be performed prior to startup following the second refueling outage. SCE plans to inspect the Unit 3 low-pressure turbine disc bores in a similar manner. Specifically, SCE may inspect one, two or all three of the low-pressure turbine disc bores during the first refueling outage for Unit 3 also and any remaining bore inspection(s) will be completed prior to startup following the second refueling outage. In the unlikely event that none of the low-pressure turbine disc bores are inspected during the first refueling outage of either Unit, all three low pressure turbine disc bores would be inspected prior to startup following the second refueling outage.

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Mr. G. W. Knighton

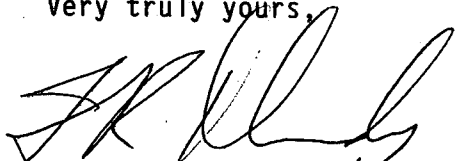
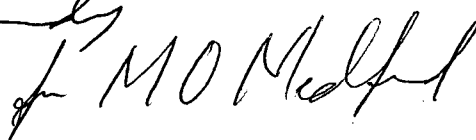
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August 1, 1984

This proposed approach toward satisfaction of the San Onofre Units 2 and 3 License Conditions was the subject of a recent phone discussion between SCE (F. R. Nandy and G. P. van Noordennen) and the NRC (G. W. Knighton); the purpose of this letter is to document the discussion of our plans to inspect the low-pressure turbine disc bores as discussed above. We consider that this approach constitutes a satisfactory method for inspecting the San Onofre Units 2 and 3 low-pressure turbine disc bores in accordance with the above License Conditions.

If you have any questions or comments, please contact me.

Very truly yours,

cc: H. Rood, Project Manager, Licensing Branch No. 3  
A. E. Chaffee, Senior Resident Inspector