

June 9, 1980

Office of Inspection and Enforcement  
Region I  
Attn: Mr. Boyce H. Grier, Director  
U. S. Nuclear Regulatory Commission  
631 Park Avenue  
King of Prussia, PA 19406

Dear Mr. Grier:

Re: Nine Mile Point Unit 1  
Docket No. 50-220  
DPR-63

Your April 7, 1980 Inspection and Enforcement Bulletin 80-08 requested information regarding containment liner penetration welds at Nine Mile Point Unit 1. The attachment to this letter addresses the actions of that bulletin.

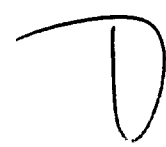
Very truly yours,

NIAGARA MOHAWK POWER CORPORATION

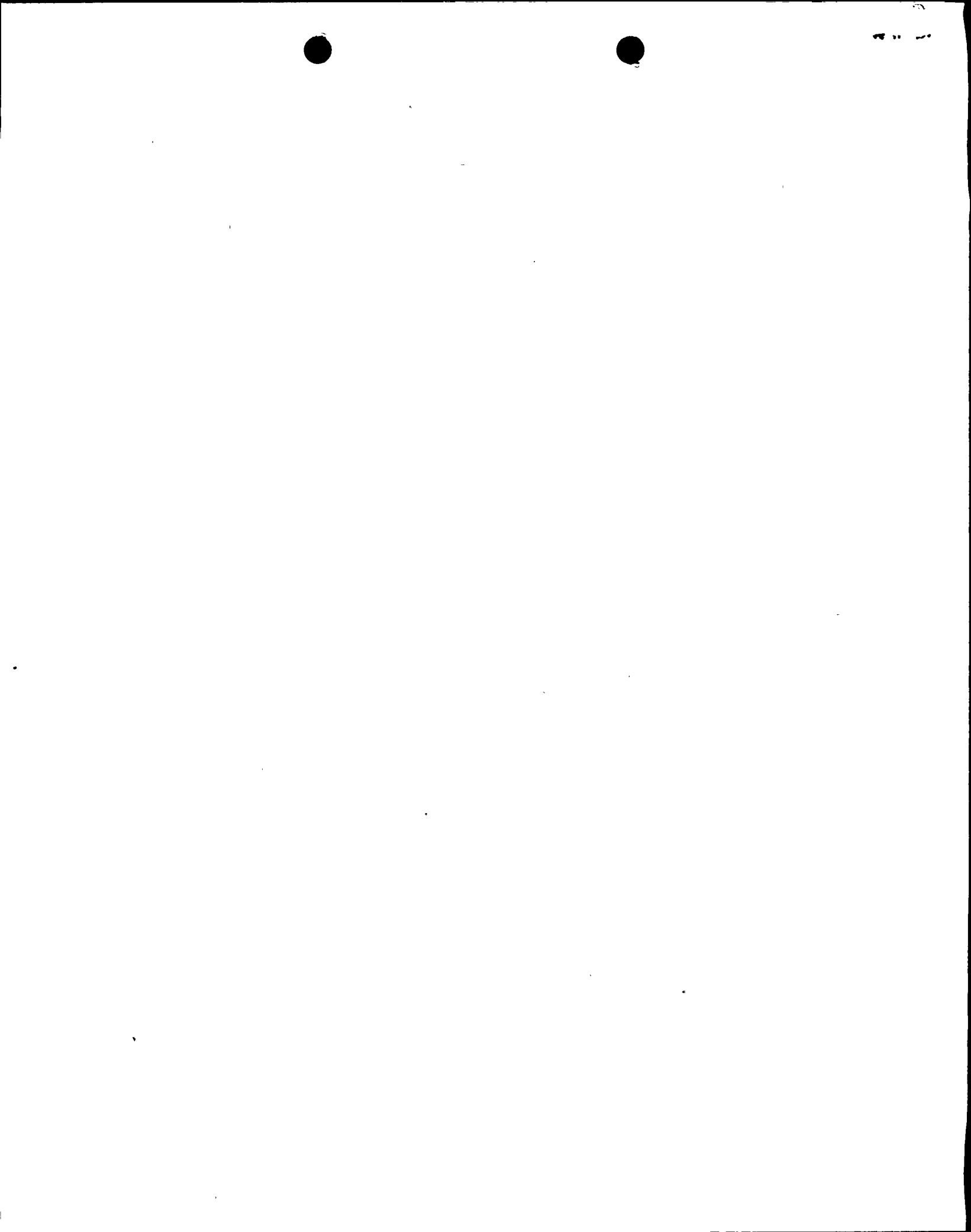


T. E. Lempges  
Vice President - Nuclear Generation

MGM:jk  
Attachment



8007180073



NINE MILE POINT UNIT 1

RESPONSE TO

INSPECTION AND ENFORCEMENT BULLETIN 80-08

1. Action

Determine if your facility contains the flued head design for penetration connections, or other designs with containment boundary butt weld(s) between the penetration sleeve and process piping as illustrated in Figure NE 1120-1, Winter 1975 Addenda to the 1974 and later editions of the ASME B&PV Code.

Response

There are no flued head design penetrations at Nine Mile Point Unit 1. However, certain penetrations are designed similar to item (b) on Figure NE-1120-1 of the Winter 1975 Addenda to the ASME Boiler and Pressure Vessel Code.

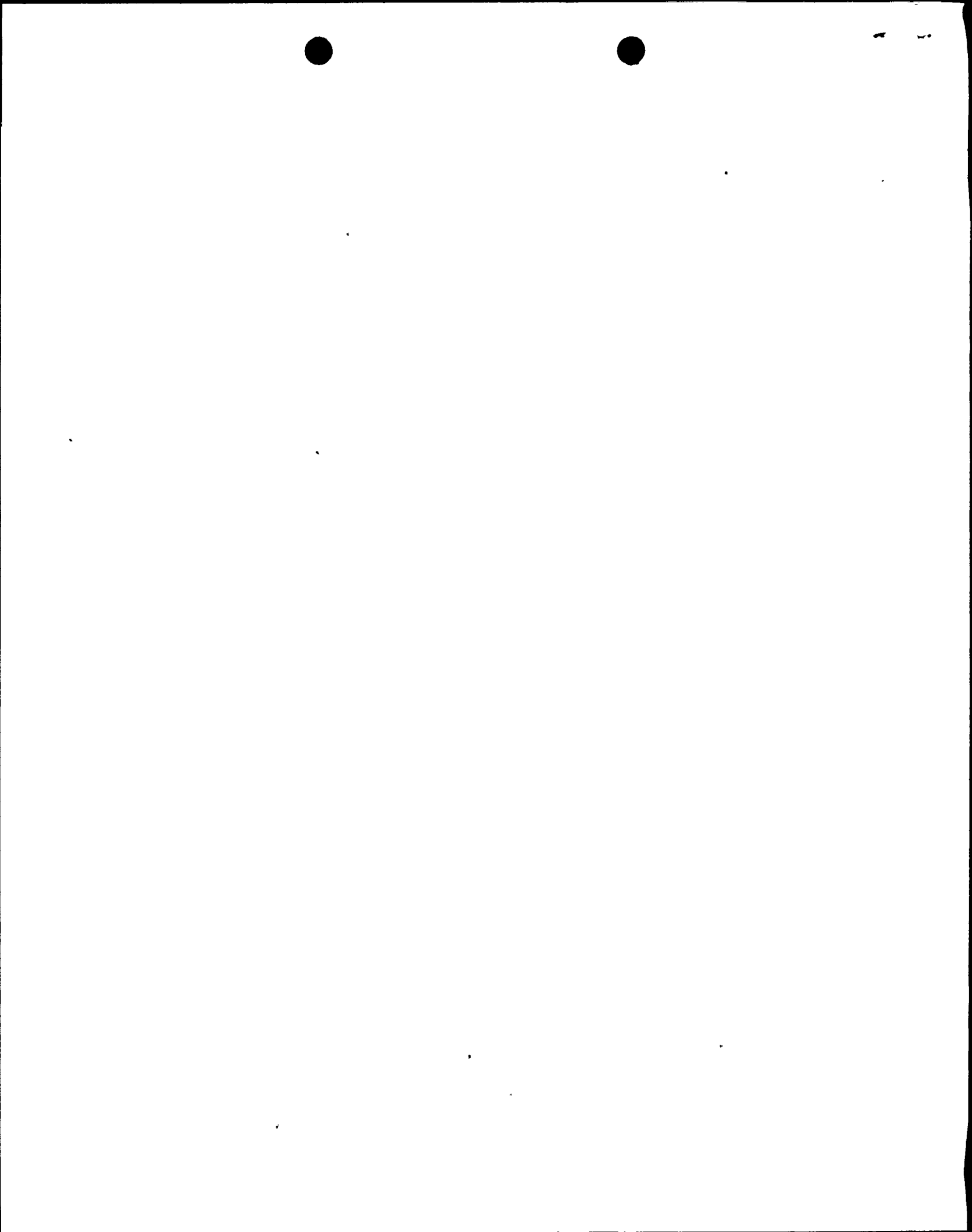
2. Action

If an affirmative answer is reached for Item 1, determine the following:

- a. Applicability of the ASME Code including year and addenda and/or Regulatory Guide 1.19,
- b. Type of nondestructive examinations performed during construction,
- c. Type of weld joint (including pipe material and size) and whether or not backing bars were used,
- d. Results of construction nondestructive examinations, i.e., if repairs were required, this should be identified including extent of repairs and description of defects encountered during repair, if known.

Response

- a. 1955-ASA B31.1 Power piping, including latest addenda and nuclear interpretations and also 1965-ASME, Section III, Subsection B, Articles 11, 12, 13, and 14 were used for the design, construction and testing of penetrations. 1965-ASME Section III, Par. N-624 and 1965-ASME, Section VIII UW-51 were used for radiography.
- b. Full radiography examination was performed on all full penetration butt welds during construction.
- c. No backing bars or rings were used. Table 1 contains a summary of the butt welded penetration sleeve materials and sizes.
- d. Results of all radiography examination indicated that specified codes requirements were met.



3. Action

For those facilities committed during construction to perform volumetric examination of such penetrations through SAR commitments which have not performed radiography, justify not performing radiography or submit plans and schedules for performing radiographic examinations.

Response

All such penetration welds at Nine Mile Point Unit 1 were radiographed during construction.

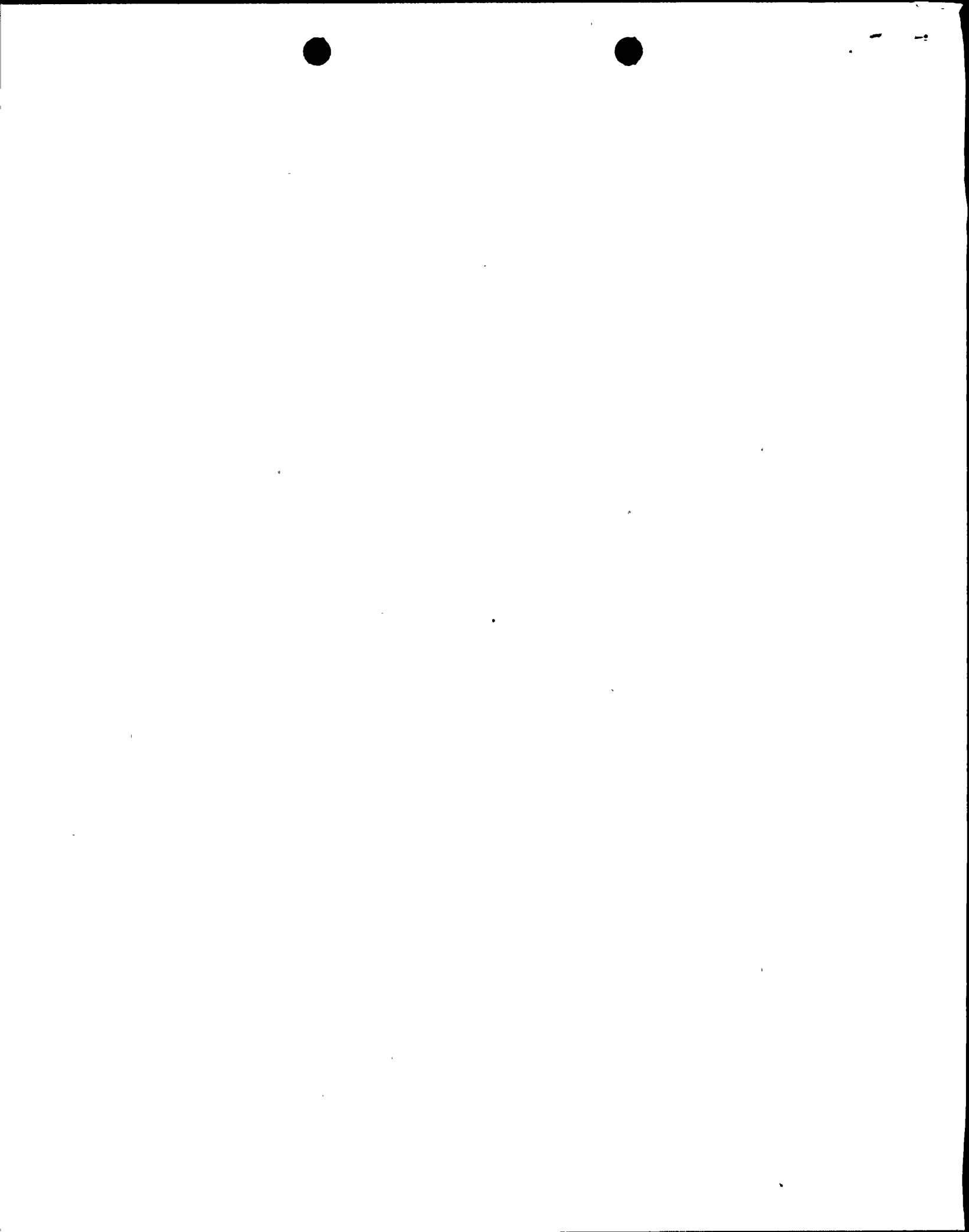


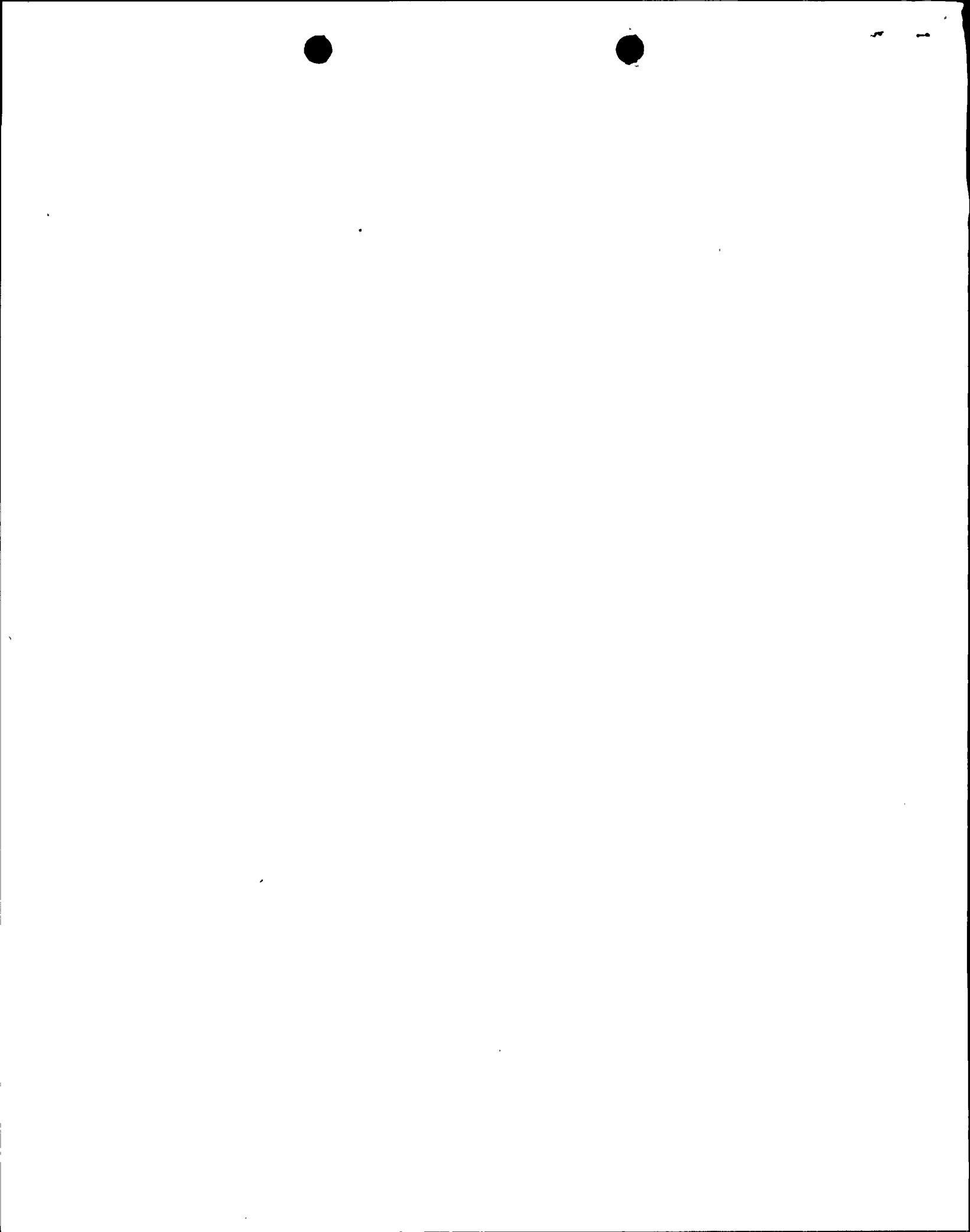
Table 1  
Penetration Details

Drywell

<u>Penetration Number</u>	<u>Pipe System</u>	<u>Penetration Sleeve Size</u>	<u>Penetration Sleeve Material</u>
X-19	Drywell Vent and Purge Air and N <sub>2</sub>	20" O.D. x 1-7/32" wall welded pipe	ASTM A-201-B FBX to A-300
X-18		24" O.D. x 1-7/32" wall welded pipe	ASTM A-201-B FBX to A-300
X-327 X-340	Reactor Containment Purge and Fill N <sub>2</sub>	20" O.D. x 1-1/8" wall welded pipe	ASTM A-201-B FBX to A-300

Suppression Chamber

<u>Penetration Number</u>	<u>Pipe System</u>	<u>Penetration Sleeve Size</u>	<u>Penetration Sleeve Material</u>
XS-332 XS-333 XS-336 XS-337	Core Spray	12" Sch. 80 seamless pipe	ASTM A-333 Gr.0
XS-334 XS-335	Core Spray	8" Sch. 80 seamless pipe	ASTM A-333 Gr.0
XS-324 XS-325 XS-341 XS-342	Containment spray	12" Sch. 80 seamless pipe	ASTM A-333 Gr.0
XS-313 thru XS-320	Drywell and torus vacuum relief	30" O.D. x 1/2" wall welded pipe	ASTM A-201-B FBX to A-300
XS-362 XS-363 XS-364	Torus Drain	4" Sch. 80 seamless pipe	ASTM A-333-0





<u>Penetration Number</u>	<u>Pipe System</u>	<u>Penetration Sleeve Size</u>	<u>Penetration Sleeve Material</u>
XS-326 XS-354	Containment Spray	4" Sch. 80 seamless pipe	ASTM A-333 Gr.0
XS-352		8" Sch. 80 seamless pipe	ASTM A-333 Gr.0
XS-365	Clean-up safety relief valve discharge	20" O.D. x 1-1/8" wall welded pipe	ASTM A-201-B FBX to A-300

