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LEMPGES,T.E. Niagara Mohawk Power Corp.
RECIP.NAME RECIPIENT AFFILIATION
EISENHUT,D.G. Division of Licensing

SUBJECT: Submits details of cutting & welding operations for safe end replacement project initially identified in 820511 ltr. Heat sink welding procedure currently being qualified. Replacement matl will be 316 nuclear-grade stainless steel.

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NIAGARA MOHAWK

NIAGARA MOHAWK POWER CORPORATION/300 ERIE BOULEVARD WEST, SYRACUSE, N.Y. 13202/TELEPHONE (315) 474-1511

June 7, 1982

Mr. Darrell G. Eisenhut, Director
Division of Licensing
Office of Nuclear Reactor Regulation
U.S. Nuclear Regulatory Commission
Washington, D.C. 20555

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

Dear Mr. Eisenhut:

Niagara Mohawk's letter of May 11, 1982 briefly described the removal and replacement of reactor recirculation safe ends. This letter provides details of cutting and welding operations for the safe end replacement project.

Pipe cutting operations and cut geometry are described in the following two procedures. These are available at the Nine Mile Point Unit 1 plant site for your review.

1. Newport News Inudstrial Corporation Instruction Number 1399-K-S003, "Pipe Cutting/End Prepping Machine Operation for Niagara Mohawk Power Corporation Nine Mile Point Unit 1, Revision B."

2. Newport News Inudstrial Corporation Controlled Work Instruction Number CWI-1399K-1-11, "Removal and Replacement of Recirculation Nozzle Safe End and Piping for Pump #11 Suction for Niagara Mohawk Power Corporation Nine Mile Point Unit 1, Revision B". Note: There is a separate Controlled Work Instruction for each pump suction and discharge.

Welding requirements for safe end replacement, elbows and piping are outlined in Section 8.0 of MPR specification 85-21-02, "Technical Requirements for Replacement of NMP-1 Reactor Vessel Recirculation Inlet and Outlet Nozzle Safe Ends, Revision 2." The details of the weld locations, weld geometry, filler material and procedure are available at the Nine Mile Point Unit 1 plant site for your review.

A heat sink welding procedure is currently being qualified at the EPRI-NDE facility in Charlotte, North Carolina. The remaining welding procedure qualifications and welder qualifications will be performed locally. All procedures will be available at the site for your review.

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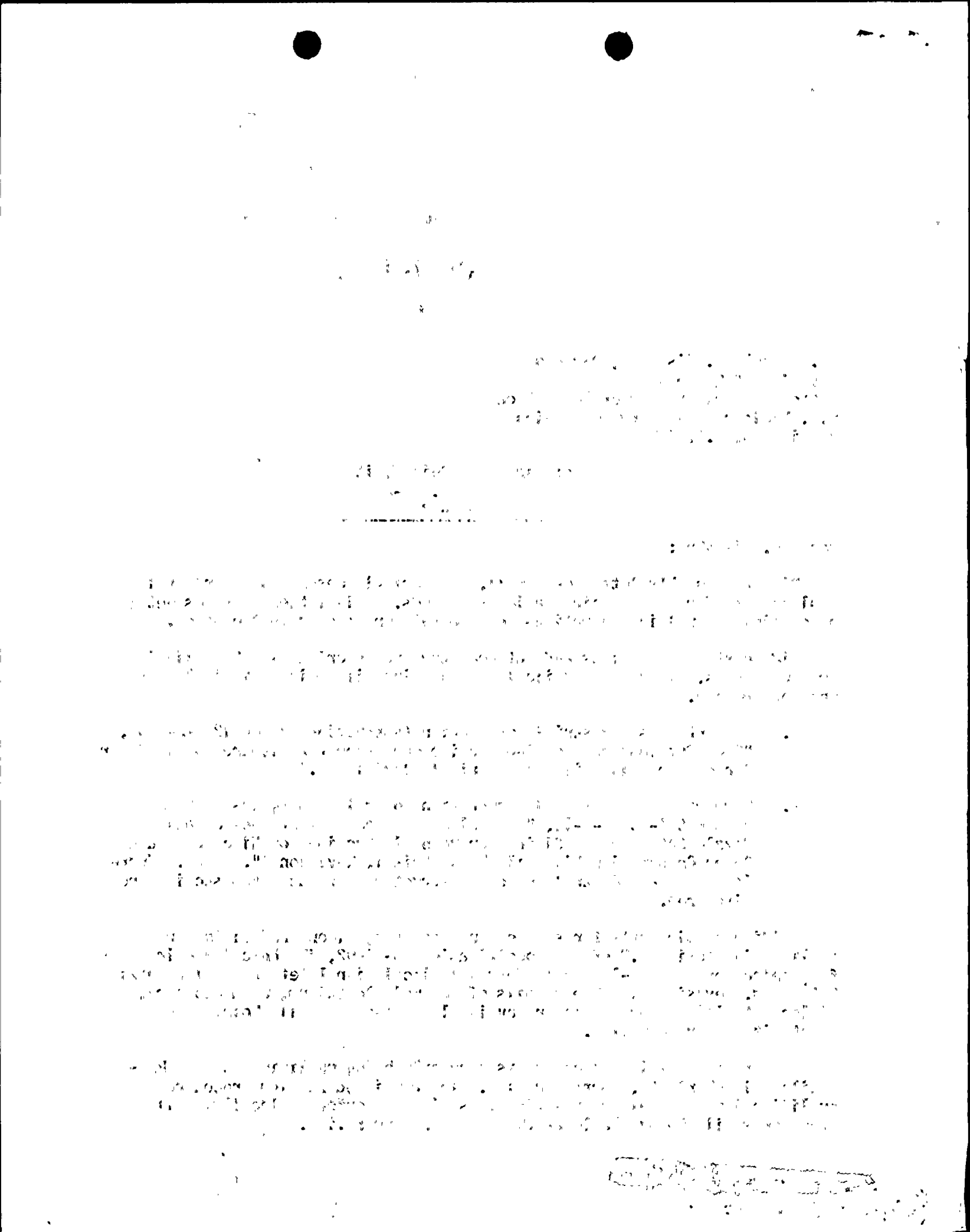

Our current plans call for the use of automatic welding machines for all pipe welding inside the drywell.

All replacement material will be 316 nuclear grade stainless steel or equivalent. This material has proven to be the most resistant to intergrannular stress corrosion cracking. This is consistent with NUREG 0313, Revision 1.

Very truly yours,

NIAGARA MOHAWK POWER CORPORATION

Thomas E. Lempges

Thomas E. Lempges
Vice President Nuclear Generation

GJG:ja