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 FACIL: 50-220 Nine Mile Point Nuclear Station, Unit 1, Niagara Powe      05000220  
 AUTH. NAME      AUTHOR AFFILIATION  
 MANGAN, C.V.      Niagara Mohawk Power Corp.  
 RECIP. NAME      RECIPIENT AFFILIATION  
 EISENHUT, D.G.      Division of Licensing

SUBJECT: Provides method & schedule to be utilized for nozzle repair  
 for miscut made during repairs at facility.

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*AN*



November 18, 1982

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

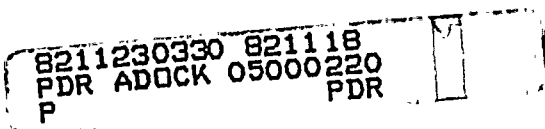
Re: Nine Mile Point Unit 1  
Docket No. 50-220  
DPR-63

Dear Mr. Eisenhut:

On June 21, 1982 Niagara Mohawk notified members of your staff of a miscut made during repairs at Nine Mile point Unit 1. The cut on number 15 recirculation safe end penetrated the edge of the nozzle material as shown on Figure 1. The purpose of this letter is to describe the method and schedule to be utilized for the nozzle repair.

The repair on number 15 recirculation nozzle will be accomplished in accordance with the ASME Boiler and Pressure Vessel Code, Section III, Division 1, Article NB-2549, "Repair by Welding". Article NB-2549 invokes requirements of Article NB-2539. These in turn require that welding and welders must be qualified per Article NB-4000 and Section IX of the Code. Also, the repaired area must be examined by magnetic particle or liquid penetrant and then radiographed. In addition, the nozzle must be heat treated in accordance with Article NB-4640.

A001





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The man-rem dose estimate for this repair is expected to be low and will be included in our next quarterly report.

The following is a milestone schedule for accomplishing the repair.

<u>Milestone</u>	<u>Date</u>
Weld Procedures and Welder Qualification	12/01/82
Demonstration on Mockup	12/10/82
Begin No. 15 Nozzle Repair	01/03/83
Complete Repair	01/31/83

In conjunction with this repair, both a stress and thermal analysis will be performed and available at the Nine Mile Point Unit 1 site for your review.

Sincerely,

*C. V. Mangano*

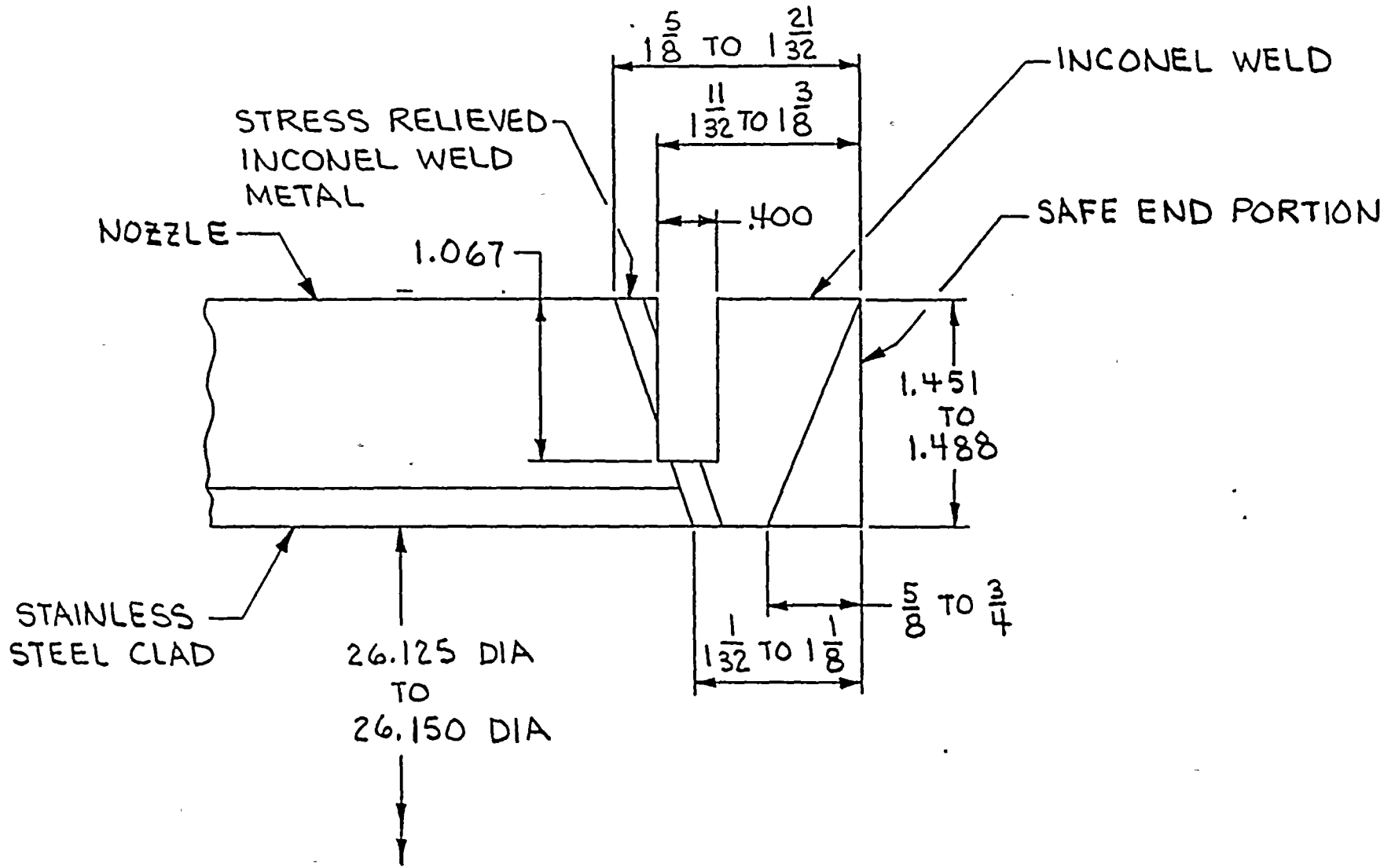
C. V. Mangano  
Vice President - Nuclear Engineering  
and Licensing

MGM:bd



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FIGURE 1



ACTUAL FIRST CUT  
ACTUAL MEASUREMENTS



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